

SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 2500 UT Unitwall™ System – 2-1/2" x 7-1/2" (63.5 x 190.5) Captured system or 2-1/2" x 6-1/2" (63.5 x 165.1) SSG system nominal dimensions, Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide curtain wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (Static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 45 psf (2155 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any curtain wall member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the curtain wall members in excess of 0.2% of their clear spans shall occur.
- H. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.
- I. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.
- J. Interstory Drift: When tested to AAMA 501.7, system must meet an interstory drift of ±3/4".

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA1503 OR CSA A440 ARE BASED UPON 1" (25.4) CLEAR INSULATING GLASS (1/4", 1/2" AS 1/4"). REFER TO THERMAL CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- K. Thermal Transmittance (U-factor):
 Captured; The (U-factor) shall not be more than: 0.36 (low E) per AAMA 1503 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
 4-side SSG; The (U-factor) shall not be more than: 0.37 (low E) per AAMA 1503 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- L. Condensation Resistance (CRF):
 Captured; When tested to AAMA 1503, the CRF shall not be less than: 80_{frame} and 72_{glass} (low E).
 4-side SSG; When tested to AAMA 1503, the CRF shall not be less than: 80_{frame} and 71_{glass} (low E).
- or
- M. Condensation Index (I):
 Captured; When tested in accordance with CSA-A440.2, the Condensation Index shall not be less than: 69_{frame} and 65_{glass} (low E).
 4-side SSG; When tested in accordance with CSA-A440.2, the Condensation Index shall not be less than: 75_{frame} and 65_{glass} (low E).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" (25.4) CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/4", 1/2" ARGON, 1/4").

- N. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): Captured & 4-side SSG; When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than 36 (STC) and 30 (OITC).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8) lengths of full-size components and showing details of the following:
1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL," "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 2500 UT Unitwall™ System - Pre-fabricated, Pre-assembled and Pre-glazed™, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - 3. Frame depth options: 2-1/2" x 7-1/2" (63.5 x 190.5) Captured system, 2-1/2" x 6-1/2" (63.5 x 165.1) SSG system.
 - 4. Tested to AAMA 501

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Thermal Breaks: Captured system 4-side continuous polyamide thermal break.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass. 1" (25.4) for spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as specified and tested by manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
1. System: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets, Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- C. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- D. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.

- a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
- b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).

B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Window Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window wall framing.
 - 1. Types of Kawneer Aluminum Window Wall include:
 - a. MetroView™ FG 501T Window Wall – 2-1/4" x 5" (57.2 x 127), inside glazed or outside glazed system.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
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- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 107113 "Exterior Sun Control Devices"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum window walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum window walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum window walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Window Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.

- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (cyclic): The test specimen shall be tested in accordance with ASTM E 547. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Water Resistance, (severe, wind driven rain): The test specimen shall be tested in accordance with AAMA 520 and ASTM E2268. The test specimen shall pass performance level 5, pressure limits 9 psf (431 Pa) – 27 psf (1293 Pa).
- H. Uniform Load: A static air design load of 42 psf (2010 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-factor) shall not be more than;
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. U-Factor not more than 0.38 BTU/hr/ft² /°F. per AAMA 1503 or () BTU/hr/ft² /°F. per AAMA 507 or NFRC 100 when using project specified glass.
- J. Condensation Resistance Test (CRF): Provide aluminum window wall tested for thermal performance according to AAMA 1503, the condensation resistance factor (CRF) shall not be less than;
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. CRF not less than 69_{frame} and 68_{glass}.
- K. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;
 - 1. 1" insulating glass made with exterior 1/4" glass, 1/2" spacer, and interior 1/4" laminated glass.
 - a. STC not less than 36; OITC not less than 31.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum window walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum window walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed window wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery
 - 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum window walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum window wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of window wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum window walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. MetroView™ FG 501T Window Wall
 - 3. Frame depth options: 2-1/4" x 5" (57.2 x 127), inside glazed or outside glazed system
 - 4. Tested to AAMA 501

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum window walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum window wall manufacturer for strength, corrosion resistance, and application of required finish and each framing member shall have a wall thickness sufficient to meet the specified structural requirements and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window wall members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated window wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

- G. Thermal Barrier: Kawneer IsoLock™ Thermal Break with a 3/8" (9.5 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum window wall sections.
 - 1. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed window wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Window Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4-sided captured
 - 2. Glazing Plane: Front
- B. Glass: 1" (25.4) insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum window wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle window wall material and components to avoid damage. Protect window wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Inside glazed or outside glazed system with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by sealant manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 6. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum window wall to exterior.
- C. Window Wall Framing: Fabricate components for assembly using screw spline system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install window wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be inside glazed or outside glazed and held in place with extruded aluminum glass stops.
 - 3. Water Drainage: Each light of glass shall be internally drained using water deflectors and sealant to divert water to the sill horizontal weep locations. Weep holes shall be located in the sill to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select window wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum window wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.

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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Window Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window wall framing.
 - 1. Types of Kawneer Aluminum Window Wall include.
 - a. MetroView™ FG 601T PG Window Wall – 2-1/4" x 6" (57.2 x 152.4), Pre-glazed system.
 - b. 1" (25.4) infill, wet glazed or 1-3/16" (30.1) infill, tape glazed.
 - c. 4-Side Captured and Vertical SSG option.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

- 1. 072700 "Air Barriers".
- 2. 079200 "Joint Sealants".
- 3. 083213 "Sliding Aluminum-Framed Glass Doors".
- 4. 084113 "Aluminum-Framed Entrances and Storefronts".
- 5. 084313 "Aluminum-Framed Storefronts".
- 6. 084329 "Sliding Storefronts".
- 7. 084433 "Sloped Glazing Assemblies".
- 8. 085113 "Aluminum Windows".
- 9. 086300 "Metal-Framed Skylights".
- 10. 088000 "Glazing".
- 11. 107113 "Exterior Sun Control Devices".
- 12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum window walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum window walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following.
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum window walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Window Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.01 cfm/ft² (0.1 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (cyclic): The test specimen shall be tested in accordance with ASTM E 547. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Water Resistance, (severe, wind driven rain): The test specimen shall be tested in accordance with AAMA 520 and ASTM E2268. The test specimen shall pass performance level 5, pressure limits 9 psf (431 Pa) – 27 psf (1293 Pa).
- H. Uniform Load: A static air design load of 45 psf (2150 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-factor) shall not be more than.
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. U-Factor not more than 0.32 BTU/hr/ft² /°F. per AAMA 1503 or () BTU/hr/ft² /°F. per AAMA 507 or NFRC 100 when using project specified glass.
- J. Condensation Resistance Test (CRF): Provide aluminum window wall tested for thermal performance according to AAMA 1503, the condensation resistance factor (CRF) shall not be less than.
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. CRF not less than 76_{frame} and 74_{glass}.
- K. Condensation Resistance (I): When tested to CSA A440, the condensation resistance factor shall not be less than.
 - a. Insulated Glass – 67_{frame} and 67_{glass} (low-e).
- L. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than.
 - 1. 1" insulating glass made with exterior 1/4" tempered glass, 1/2" spacer, and interior 1/4" laminated glass.
 - a. STC not less than 34; OITC not less than 27.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum window walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum window walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed window wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following.
 - 1. Joinery.
 - 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum window walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum window wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.

1. Build mockups for type(s) of window wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum window walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL"/"OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product.
 1. Kawneer Company Inc..
 2. MetroView™ FG 601T PG Window Wall.
 3. Frame depth: 2-1/4" x 6" (57.2 x 152.4), Pre-glazed system.
 4. Tested to AAMA 501.

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- B. Subject to compliance with requirements, provide a comparable product by the following.
 1. Manufacturer: (_____).
 2. Series: (_____).
 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum window walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum window wall manufacturer for strength, corrosion resistance, and application of required finish and each framing member shall have a wall thickness sufficient to meet the specified structural requirements and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window wall members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

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Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated window wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- G. Thermal Barrier: Kawneer IsoLock™ Thermal Break with a 3/8" (9.5 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum window wall sections.
 - 1. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed window wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Window Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4-sided Captured and Vertical SSG option.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) wet glazed or 1-3/16" (30.1) tape glazed, insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum window wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle window wall material and components to avoid damage. Protect window wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Inside glazed system with 1" (25.4) wet glazed or 1-3/16" tape glazed, double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by sealant manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics.
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 6. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum window wall to exterior.

- C. Window Wall Framing: Fabricate components for assembly using screw spline system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install window wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be inside glazed and held in place with extruded aluminum glass stops.
 - 3. Water Drainage: Each light of glass shall be internally drained using water deflectors and sealant to divert water to the sill horizontal weep locations. Weep holes shall be located in the sill to divert water to the exterior of the building.
- B. Related Products Installation Requirements.
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select window wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum window wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.

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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Thermally Broken Aluminum Entrances, glass and glazing, and door hardware and components.
 1. Types of Kawneer Thermally Broken Aluminum Entrances include:
 - a. AA™250 Thermal Entrance; Narrow stile, 2-1/2" (63.5 mm) vertical face dimension, 2-1/4" (57 mm) depth, moderate traffic applications.
 - b. AA™425 Thermal Entrance; Wide stile, 4-1/4" (108 mm) vertical face dimension, 2-1/4" (57 mm) depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084313 "Aluminum-Framed Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 087000 "Hardware"
 11. 088000 "Glazing"
 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance doors shall withstand the effects of the following performance requirements without exceeding performance criteria or failure due to defective manufacture, fabrication, installation, or other defects in construction:
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance

door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm per square foot.

3. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 for typical application or L/180 for Small-Missile and Large-Missile impact, of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
4. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.3 Standard 12 for exterior doors and Standard 10 for glazing and frame bite provisions, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
5. Forced Entry: Tested in accordance with AAMA 1304.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH e= 0.035 LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Insulated Glass – 0.43 (low-e) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per AAMA 507 per NFRC 100.
7. Solar Heat Gain Coefficient: Glazed thermally broken aluminum door and frame shall have a solar heat gain coefficient of no greater than (____) <Insert value> as determined according to NFRC 200.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Insulated Glass – 57_{frame} and 71_{glass} (low-e).
9. Condensation Resistance (I): When tested to CSA A440, the condensation resistance factor shall not be less than:
 - a. Insulated Glass – 48_{frame} and 69_{glass} (low-e).
10. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with ASTM E 90, the STC and OITC ratings shall not be less than:
 - a. 32 (STC) and 28 (OITC).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating thermally broken aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports and calculations.
- C. **Source Limitations:** Obtain thermally broken aluminum-framed door through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum-framed glass entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify actual dimensions of thermally broken aluminum-framed door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. The door stile and rail face dimensions of the [_____] (choose one: AA™250 or AA™425) Thermal Entrance will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
AA™250 Thermal Entrance	2-1/2" (63.5 mm)	2-1/2" (63.5 mm)	3-7/8" (99 mm)	10" (254 mm)
AA™425 Thermal Entrance	4-1/4" (108 mm)	4-1/4" (108 mm)	6-1/2" (166 mm)	10" (254 mm)
 - 3. Major portions of the door members to be 0.125" (4) nominal in thickness and glazing molding to be 0.05" (1.3 mm) thick
 - 4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
 - 5. Provide adjustable glass jacks to help center the glass in the door opening.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum entrance and storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum entrances and storefronts for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Slide-In-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing:
1. Trifab™ VG 451T
 2. Trifab™ 451UT
 3. Trifab™ 601/601T
 4. Thermally Broken entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware:
1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with two lines of weather-stripping utilizing wool pile with polymeric fin.

- b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing and a wool pile with polymeric fin.
 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 3. Threshold: Extruded aluminum, thermally broken, with ribbed surface.
 4. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
 5. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
 6. Continuous Hinge: [_____].
 7. Push/Pull: [_____] style.
 8. Exit Device: [_____].
 9. Closer: [_____].
 10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 11. Latch Handle: [_____].
 12. Cylinder(s)/Thumbturn: [_____].
 13. Electric Strike/Strike Keeper: [_____].
- C. Optional Hardware:

EDITOR NOTE: SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Adams Rite MS 1850A-505 Hookbolt Lock.
2. Mortise cylinder, interior or exterior.
3. Thumbturn, interior.
4. Flush pull.

2.6 Fabrication

- A. Fabricate thermally broken aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate thermally broken aluminum-framed doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1" (24 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufactures drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.

2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing thermally broken aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install thermally broken aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed door and storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM

1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ 601 Framing System – 2" x 6" (50.8 mm x 152.4 mm) nominal dimension; Non-Thermal; Center Plane; Screw Spline Fabrication.
 - b. Trifab™ 601T Framing System – 2" x 6" (50.8 mm x 152.4 mm) nominal dimension; Thermal; Center Plane; Screw Spline Fabrication.
 - c. Trifab™ 601T Framing System – Impact Glazing
 - d. Trifab™ 601UT Framing System – 2" x 6" (50.8 mm x 152.4 mm) nominal dimension; Thermal; Center Plane; Screw Spline Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 088000 "Glazing"
 11. 107113 "Exterior Sun Control Devices"
 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal. CSA A440 Fixed Rating.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 10 psf (500 Pa) as defined in AAMA 501. CSA A440 B5 Rating.

4. Uniform Load: A static air design load of 30 psf (1437 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur. CSA A440 C2 Rating.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $\epsilon=0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

5. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Trifab™ 601 – 0.53 (low-e) or Project Specific (____) BTU/hr/ft²/°F. As determined per AAMA 507 or NFRC 100.
 - b. Trifab™ 601T – 0.35 (low-e) or Project Specific (____) BTU/hr/ft²/°F. As determined per AAMA 507 or NFRC 100.
 - c. Trifab™ 601UT – 0.33 (low-e) or Project Specific (____) BTU/hr/ft²/°F. As determined per AAMA 507 or NFRC 100.
6. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Trifab™ 601 – 4_{frame} and 6_{glass} (low-e).
 - b. Trifab™ 601T – 6_{frame} and 7_{glass} (low-e).
 - c. Trifab™ 601UT – 7_{frame} and 7_{glass} (low-e).
7. Condensation Resistance (I): When tested to CSA A-440.2, the condensation index shall not be less than:
 - a. 6_{frame} and 6_{glass} (low-e).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

8. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. Trifab™ 601/601T/601UT – 37 (STC) and 31 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery, including concealed welds.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.

1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Trifab™ 601 Framing System (Non-Thermal)
 3. Trifab™ 601T Framing System (Thermal)
 4. Trifab™ 601T Framing System (Thermal) – Impact Glazing
 5. Trifab™ 601UT Framing System (Thermal)
 6. System Dimensions: 2" x 6" (50.8 mm x 152.4 mm)
 7. Glass: Center Plane, Exterior or Interior Glazed

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier (Trifab™ 601T & 601UT):
 - 1. Trifab™ 601T: Kawneer IsoLock™ Thermal Break with a nominal 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - 2. Trifab™ 601UT: Kawneer IsoLock™ Thermal Break with dual nominal 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 - 1. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.

- f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
- g. Panel /Shelf projection shall not exceed 30" (762mm).
- h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
- i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
- 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
- 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.
- C. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- D. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight framed aluminum-storefront system installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ UT Windows (Structural Silicone Glazed)
 - b. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - c. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Performance Class and Grade:
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)
2. Air leakage: The test specimen shall be tested in accordance with ASTM E283. Air leakage rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.2 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.6 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa). The test specimen shall meet the B7 rating with no water leakage at 12 psf (575 Pa) when tested in accordance with CAN/CSA-A440-00 Windows;
4. Uniform Load Deflection: A minimum static air pressure difference [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C3, C4 or C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG70-C (with 3-Cam Handles); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-C (with 3-Cam handles); 90 psf (4309 Pa)
5. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.3% of span length.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 60 psf (2873 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 90 psf (4309 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 105 psf (5027 Pa)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-C (with 3-Cam Handles); 105 psf (5027 Pa)
6. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
 - a. Project-Out Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-AP (with 3-Cam handles); 135 psf (6464 Pa)

- b. Outswing Casement Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-C (with 3-Cam handles); 135 psf (6464 Pa)
- 7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
- 8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass:
 - 1) Project-Out: U-Factor not more than .56 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) clear glass, aluminum spacer, and interior 3/16" (4.76 mm) glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- b. 1-3/4" insulating glass:
 - 1) Project-Out and Outswing Casement: U-Factor not more than .23 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- 9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - i. Project-Out: CRF not less than 73 (frame) and 60 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: CRF not less than 80 (frame) and 82 (glass).
 - 2) Project-Out: CRF not less than 81 (frame) and 83 (glass).
- 10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - 1) Project-Out: (I) not less than 68 (frame) and 61 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: (I) not less than 70 (frame) and 73 (glass).
 - 2) Project-Out: (I) not less than 75 (frame) and 81 (glass).
- 11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass made with exterior 3/16" (4.76 mm) clear glass, 3/8" (9.52 mm) aluminum spacer, and interior 7/16" (11.11 mm) laminated clear glass:
 - 1) Project-Out: STC not less than 37; OITC not less than 30.
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 9/16" (14.29 mm) clear laminated glass, 7/8" (22.2 mm) aluminum spacer, and interior 5/16" (7.94 mm) clear laminated glass:
 - 1) Outswing Casement: STC not less than 41; OITC not less than 34.
- 12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
- 13. Blast Mitigation performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
- b. Section B-3.1.2 Testing
- c. Section B-3.1.3 ASTM F2248 Design Approach
- 14. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.

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- a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
- b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. GLASSvent™ UT Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 - a. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP
 - ii. CW-PG60-AP
 - iii. CW-PG70-AP
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP
 - ii. AW-PG90-AP
 - b. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C
 - ii. CW-PG70-C
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C

ii. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ UT Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.
- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
 - 1. Stainless Steel 4-Bar Hinges
 - 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- 3. Cast white Bronze Cam Handle with Pole Ring
- 4. Cast White Bronze Access Control (Custodial) Locks with Removable Handle

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T5 or 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION**3.1 Examination**

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.2 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Side load single hung (AW-PG50-H)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Windows"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99".
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than: 75 (frame) and 76 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than: 61 (frame), 75 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.23 to 0.38 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.23 to 0.38 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s·m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa) with a **10 lb. sill** or 15 lbf/sq. ft. (720 Pa) with a **15 lb. sill**.
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 32 (STC) and 24 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.41 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- L. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 1. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
(CRF_f) frame not less than 71.
(CRF_g) glass not less than 74.
- M. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 1. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
Temperature Index (I_f) frame not less than 57.
Temperature Index (I_g) glass not less than 77.
- N. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
- O. Air Exfiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Exfiltration Test.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
- P. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **10 lb. Sill**.
 - b. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **10 lb. Sill**.
 - b. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **15 lb. Sill**.
- Q. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-1/4" laminated insulating glass: 35 (STC) and 31 (OITC)

AA™ 5450 (Standard Face) and AA™ 5450 (Beveled Face)

- R. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- S. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- T. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 MANUFACTURERS**

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™5450 Ultra Thermal Singe Hung (Standard Face)
 - 3. Series AA™5450 Ultra Thermal Singe Hung (Beveled Face)
 - 4. 4 5/8" (117.48 mm) frame depth
 - 5. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.

2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Single Hung Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: AW-PG50-H

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Windows: Provide the following operating hardware:
 1. Sash Balances: A Class 5 adjustable spiral balance with stainless steel or other corrosion-resistant components. Two per sash.
 2. Handle: Continuous, integral, bottom sash lift handle.
 3. Sash Lock: White bronze sweep lock and keeper on meeting rails. One or two per sash as required by size. Brushed nickel finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.

- B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 2. Finish: Manufacturer's standard.

EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.

- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch (0.28-mm) diameter, coated aluminum wire.
1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
- D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™, AAMA 2604. Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.6 psf (75 Pa) for CW or 6.2 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Side load double hung (AW-PG50-H)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than 71 (frame) and 76 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than 40 (frame), 74 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.3 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa) with a **10 lb. sill** or 15 lbf/sq. ft. (720 Pa) with a **15 lb. sill**.
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 32 (STC) and 25 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.

2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.

AA™ 5450 (Standard Face) and AA™ 5450 (Beveled Face)

- L. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- M. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- N. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify actual dimensions of aluminum framed window openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

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PART 2 - PRODUCTS**2.1 MANUFACTURERS**

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series AA™5450 Ultra Thermal Double Hung (Standard Face)
 3. Series AA™5450 Ultra Thermal Double Hung (Beveled Face)
 4. 4 5/8" (117.48 mm) frame depth
 5. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer:
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Double Hung Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
1. Performance Class and Grade: AW-PG50-H

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads and an interior gasket in accordance with AAMA 702 or ASTM C864.

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2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Windows: Provide the following operating hardware:
 - 1. Sash Balances: A Class 5 adjustable spiral balance with stainless steel or other corrosion-resistant components. Two per sash.
 - 2. Handle: Continuous, integral, bottom and top sash lift handle.
 - 3. Sash Lock: White bronze sweep lock and keeper on meeting rails. One or two per sash as required by size. Brushed nickel finish.
 - 4. Aluminum autolock at top sash lift handle.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

- 5. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
- 6. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
- 7. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 - 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.
 - B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
 - 1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 - 2. Finish: Manufacturer's standard.
- EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.**
- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch (0.28-mm) diameter, coated aluminum wire.
 - 1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
 - D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
 - 1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 - 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permardize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604. Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within windows to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Fixed window (AW-PG70-FW)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than: 78 (frame) and 79 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than: 68 (frame) and 75 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.22 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.19 to 0.37 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32).
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.1 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa).
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 29 (STC) and 23 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.22 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.20 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.34).

AA™5450 (Standard Face) and AA™5450 (Beveled Face)

- L. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™5450 Ultra Thermal Fixed (Standard Face)
 - 3. Series AA™5450 Ultra Thermal Fixed (Beveled Face)
 - 4. 4 5/8" (117.48 mm) frame depth
 - 5. AW-PG70-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Fixed Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: AW-PG70-FW

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: None required

2.6 INSECT SCREENS

- A. General: None required

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.

1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.

- a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal
 - b. Horizontal Sliding (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Windows"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 99" x 79"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

- 1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.

- a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series AA™5450 Ultra Thermal Horizontal Sliding Window
 3. 4 5/8" (117.48 mm) frame depth

4. (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Horizontal Sliding Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- C. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than Single Slide: 76 (frame) and 77 (glass) or Double Slide: 69 (frame) and 77 (glass).
- D. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than Single Slide: 57 (frame) and 73 (glass) or Double Slide: 36 (frame) and 74 (glass).
- E. Thermal Transmittance: Provide aluminum windows tested for thermal performance according to AAMA 1503.
 1. Provide aluminum windows tested for thermal performance according to AAMA 1503, with a thermal transmittance (U-factor) no more than Single Slide: 0.25 BTU/hr/sf/F or Double Slide: 0.28 BTU/hr/sf/F.
 2. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-factor) range of; Single Slide: 0.23 to 0.38 BTU/hr/sf/F or Double Slide: 0.25 to 0.39 BTU/hr/sf/F (Based on center of glass U-factor range 0.10 to 0.32 for triple glazing).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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- F. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- G. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 - 1. Maximum Rate: 0.3 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- H. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 - 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa).
- I. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- J. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.
- L. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass:
XO UNIT = 32 (STC) and 26 (OITC)
XX UNIT = 33 (STC) and 26 (OITC)

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Windows: Provide the following operating hardware:
 - 1. Handle: Continuous, integral pulls.
 - 2. Sash Locks.
 - 3. Composite adjustable tandem roller.
 - 4. Stainless Steel roller track.
 - 5. Standard auto lock.
 - 6. Limit device.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

- 7. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
- 8. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 - 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.
- B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
 - 1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 - 2. Finish: Manufacturer's standard.

EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.

- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch- (0.28-mm-) diameter, coated aluminum wire.
 - 1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
- D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
 - 1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12.7 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604. Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.

3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall units.
 1. Types of Kawneer Curtain Wall and Glazed Assemblies include:
 - a. 1600UT System™ 1 Curtain Wall:
 - 1) 1" (25.4 mm) double glazed insulating glass: 2-1/2" x 6" (63.5 mm x 152.4 mm) or 7-1/2" (63.5 mm x 190.5 mm), outside glazed pressure plate format.
 - 2) 1-3/4" (44.4 mm) triple glazed insulating glass: 2-1/2" x 6-3/4" (63.5 mm x 171.4 mm) or 8-1/4" (63.5 mm x 209.5 mm), outside glazed pressure plate format.
 - b. 1600UT System™ 2 Curtain Wall:
 - 1) 1" (25.4 mm) double glazed insulating glass: 2-1/2" x 6" (63.5 mm x 152.4 mm) or 7-1/2" (63.5 mm x 190.5 mm), outside glazed structural silicone glazed (SSG) format.
 - 2) 1-3/4" (44.4 mm) triple glazed insulating glass: 2-1/2" x 6-3/4" (63.5 mm x 171.4 mm) or 8-1/4" (63.5 mm x 209.5 mm), outside glazed structural silicone glazed (SSG) format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.

- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of () lbs./sq. ft. or () Pa, inward and () lbs./sq. ft. or () Pa, outward. The design pressures are based on the () Building Code; () Edition.
- D. Structural-Test Performance: Test according to ASTM E 330 and TAS 202 as follows:
1. When tested at positive and negative wind load design pressures, assemblies do not evidence deflection exceeding L/175 of clear span.
 2. A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction.
 - a. When tested at 150% of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2% percent of clear span.
 - b. Minimum test duration according to ASTM E 330 is 10 seconds.
- E. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Normal to Wall Plane: Limited to edge of glass in a direction perpendicular to glass plane not exceeding L/175 of the glass edge length for each individual glazing lite, or an amount that restricts edge deflection of individual glazing lites to 3/4 inch (19 mm), whichever is less. Limit deflection of clear span of framing members to L/175 for spans less than or equal to 13'-6" (4.11 meters) and L/240 + 1/4" for spans greater than 13'-6" (4.11 meters).
 2. Deflection Parallel to Glazing Plane: Limited to [L/360 of clear span or 1/8 inch (3.2 mm), whichever is smaller] [amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8 inch (3.2 mm)].
 - a. Operable Units: Provide a minimum 1/16-inch (1.6 mm) clearance between framing members and operable units.
 3. Cantilever Deflection: Where framing members overhang an anchor point, limit deflection to two times the length of cantilevered member, divided by 175.
- F. Seismic: When tested to AAMA 501.4, system must meet design displacement (elastic) of 0.010 x the story height and ultimate displacement (inelastic) of 1.5 x the design displacement.
- G. Water Penetration under Static Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to ASTM E 331 and TAS 202 at 15 psf (720 Pa).
- H. Water Penetration under Dynamic Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to AAMA 501.1 at dynamic pressure equal to 15 psf (720 Pa).
1. Maximum Water Leakage: [According to AAMA 501.1] [No uncontrolled water penetrating assemblies or water appearing on assemblies' normally exposed interior surfaces from sources other than condensation]. Water leakage does not include water controlled by flashing and gutters that is drained to exterior.
- I. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.
- J. Energy Performance: Glazed aluminum curtain walls shall be tested in accordance with NFRC and AAMA Standards.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" OR 1-3/4" CLEAR HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E, ARGON FILLED, WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

1. Thermal Transmittance (U-factor):
 - a. 1600UT System™1 Curtain Wall:
 - 1) Glass and framing areas shall have U-factor of no greater than 0.33 with 1" (25.4 mm) High Performance (HP) Glass as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.
 - 2) Glass and framing areas shall have U-factor of no greater than 0.24 with 1-3/4" (44.4 mm) High Performance (HP) Triple Glazed as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.

EDITOR NOTE: FOR IMPROVED U-FACTORS WITH FIBER GLASS PRESSURE PLATE BASED ON AAMA 507/NFRC100 SIMULATIONS PLEASE REFER TO THERMAL CHARTS IN ARCHITECTURAL DETAIL MANUAL, AVAILABLE ON KAWNEER.COM.

- b. 1600UT System™2 Curtain Wall:
 - 1) Project specific U-factor () BTU/Hr/Ft²/°F with 1" (25.4 mm) Glass as determined per AAMA 507 or NFRC 100.
 - 2) Project specific U-factor () BTU/Hr/Ft²/°F with 1-3/4" (44.4 mm) Triple Glazed Glass as determined per AAMA 507 or NFRC 100.

EDITOR NOTE: FOR IMPROVED U-FACTORS WITH FIBER GLASS PRESSURE PLATE BASED ON AAMA 507/NFRC100 SIMULATIONS PLEASE REFER TO THERMAL CHARTS IN ARCHITECTURAL DETAIL MANUAL, AVAILABLE ON KAWNEER.COM.

2. Solar Heat Gain Coefficient: Glass and framing areas shall have a solar heat gain coefficient of no greater than [0.35] [0.40] [0.45] <Insert value> as determined according to NFRC 200.

3. Air Leakage: Maximum air leakage through fixed glazing and framing areas of 0.06 cfm/sq.ft. (0.31 l/s.m²) of fixed wall area as determined according to ASTM E 283 and TAS 202 at a minimum static-air-pressure differential of 6.2 psf (300 Pa).
 4. Condensation Resistance: When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 1600UT System™1 Curtain Wall:
 - 1) CRF_{glass} (1" [25.4 mm] Double Glazed HP) = 76, CRF_{frame} = 79
 - 2) CRF_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 81, CRF_{frame} = 82
 5. Temperature Index (I): when tested to CSA-A440-00, the Temperature Index shall not be less than:
 - a. 1600UT System™1 Curtain Wall with aluminum pressure plate:
 - 1) I_{glass} (1" [25.4 mm] Double Glazed HP) = 67, I_{frame} = 71
 - 2) I_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 77, I_{frame} = 74
 - b. 1600UT System™1 Curtain Wall with fiber glass pressure plate:
 - 1) I_{glass} (1" [25.4 mm] Double Glazed HP) = 68, I_{frame} = 76
 - 2) I_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 78, I_{frame} = 76
- K. Storm Shelter Performance:
1. Shall be tested to meet ICC500: ICC / NSSA Standard for the design and construction of storm shelters.
 2. Missile Criteria for tornado shelters.
 - a. Design Wind Speed:
 - 1) 200 mph (EF4)
 - 2) 240 mph (EF5)
 - b. Missile Speed:
 - 1) 90 mph (EF4)
 - 2) 100 mph (EF5)
- L. Sound Transmission: Provide glazed aluminum curtain walls with fixed glazing and framing areas having the following sound-transmission characteristics:
1. 1600UT System™1 Curtain Wall:
 - a. STC-31 or OITC-25 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1" (25.4 mm) double insulating glass (1/4", 1/2" AS, 1/4")
 - b. STC-33 or OITC-27 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1-3/4" (44.4 mm) triple insulating glass (1/4", 1/2" AS, 1/4", 1/2" AS, 1/4").

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. 1600UT System™1 Curtain Wall or 1600UT System™2 Curtain Wall
 3. Frame depth options: 6" (152.4 mm) & 7-1/2" (190.5 mm) with 1" (25.4 mm) Double Glazed Insulating Glass; 6-3/4" (171.4 mm) & 8-1/4" (209.5 mm) with 1-3/4" (44.4 mm) Triple Glazed Insulating Glass
 4. Tested to AAMA 501-05 and TAS 202

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be either aluminum or fiberglass and fastened to the mullion with stainless steel screws. Fiberglass pressure plate shall be tested to ASTM D638, D790, D695, D953, D3846.

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- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal barrier consists of 1" (25.4 mm) separation between the interior and exterior metal members in a typical condition. Thermal barrier assembly shall be tested to the thermal cycling requirements of ASTM E2692 and show no sign of degradation following the test.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4-sided captured or 2-sided SSG.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4 mm) and 1-3/4" (44.4 mm) insulating glass option. 1/4" (6.3 mm) or 1" (25.4 mm) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600UT System™1 Curtain Wall: Outside glazed pressure plate format with 1" (25.4 mm) double glazed and 1-3/4" (44.4 mm) triple glazed insulating glass.
 - 2. 1600UT System™2 Curtain Wall: Outside glazed structural silicone glazed (SSG) format with 1" (25.4 mm) double glazed and 1-3/4" (44.4 mm) triple glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- C. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.

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- c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
- a. Curtain wall framing system.
 - b. Storefront Framing System.
4. Submittals.
- a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- D. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
- 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
 - 8. Double seal design with primary air and vapor barrier at interior side of glazed aluminum curtain wall and secondary seal weeped and vented to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
- 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permardize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
 - 1. Comply with manufacturer's written instructions.
 - 2. Do not install damaged components.
 - 3. Fit joints to produce hairline joints free of burrs and distortion.
 - 4. Rigidly secure non-movement joints.
 - 5. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 - 6. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 - 7. Seal joints watertight unless otherwise indicated.
- B. Metal Protection:
 - 1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 - 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- D. Install components plumb and true in alignment with established lines and grades.
- E. Install operable units level and plumb, securely anchored, and without distortion. Adjust weather-stripping contact and hardware movement to produce proper operation.
- F. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- G. Install glazing as specified in Division 08 Section "Glazing."

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Leakage Tests: Conduct tests in accordance with ASTM E 783. Allowable air leakage shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall units.
 - 1. Types of Kawneer Curtain Wall and Glazed Assemblies include:
 - a. 1600UT System™ 1 Curtain Wall:
 - 1) 1" (25.4 mm) double glazed insulating glass: 2-1/2" x 6" (63.5 mm x 152.4 mm) or 7-1/2" (63.5 mm x 190.5 mm), outside glazed pressure plate format.
 - 2) 1-3/4" (44.4 mm) triple glazed insulating glass: 2-1/2" x 6-3/4" (63.5 mm x 171.4 mm) or 8-1/4" (63.5 mm x 209.5 mm), outside glazed pressure plate format.
 - b. 1600UT System™ 2 Curtain Wall:
 - 1) 1" (25.4 mm) double glazed insulating glass: 2-1/2" x 6" (63.5 mm x 152.4 mm) or 7-1/2" (63.5 mm x 190.5 mm), outside glazed structural silicone glazed (SSG) format.
 - 2) 1-3/4" (44.4 mm) triple glazed insulating glass: 2-1/2" x 6-3/4" (63.5 mm x 171.4 mm) or 8-1/4" (63.5 mm x 209.5 mm), outside glazed structural silicone glazed (SSG) format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 107113 "Exterior Sun Control Devices"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.

- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of () lbs./sq. ft. or () Pa, inward and () lbs./sq. ft. or () Pa, outward. The design pressures are based on the () Building Code; () Edition.
- D. Structural-Test Performance: Test according to ASTM E 330 and TAS 202 as follows:
1. When tested at positive and negative wind load design pressures, assemblies do not evidence deflection exceeding L/175 of clear span.
 2. A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction.
 - a. When tested at 150% of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2% percent of clear span.
 - b. Minimum test duration according to ASTM E 330 is 10 seconds.
- E. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Normal to Wall Plane: Limited to edge of glass in a direction perpendicular to glass plane not exceeding L/175 of the glass edge length for each individual glazing lite, or an amount that restricts edge deflection of individual glazing lites to 3/4 inch (19 mm), whichever is less. Limit deflection of clear span of framing members to L/175 for spans less than or equal to 13'-6" (4.11 meters) and L/240 + 1/4" for spans greater than 13'-6" (4.11 meters).
 2. Deflection Parallel to Glazing Plane: Limited to [L/360 of clear span or 1/8 inch (3.2 mm), whichever is smaller] [amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8 inch (3.2 mm)].
 - a. Operable Units: Provide a minimum 1/16-inch (1.6 mm) clearance between framing members and operable units.
 3. Cantilever Deflection: Where framing members overhang an anchor point, limit deflection to two times the length of cantilevered member, divided by 175.
- F. Seismic: When tested to AAMA 501.4, system must meet design displacement (elastic) of 0.010 x the story height and ultimate displacement (inelastic) of 1.5 x the design displacement.
- G. Water Penetration under Static Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to ASTM E 331 and TAS 202 at 15 psf (720 Pa).
- H. Water Penetration under Dynamic Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to AAMA 501.1 at dynamic pressure equal to 15 psf (720 Pa).
1. Maximum Water Leakage: [According to AAMA 501.1] [No uncontrolled water penetrating assemblies or water appearing on assemblies' normally exposed interior surfaces from sources other than condensation]. Water leakage does not include water controlled by flashing and gutters that is drained to exterior.
- I. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.
- J. Energy Performance: Glazed aluminum curtain walls shall be tested in accordance with NFRC and AAMA Standards.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" OR 1-3/4" CLEAR HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E, ARGON FILLED, WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

1. Thermal Transmittance (U-factor):
 - a. 1600UT System™1 Curtain Wall:
 - 1) Glass and framing areas shall have U-factor of no greater than 0.33 with 1" (25.4 mm) High Performance (HP) Glass as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.
 - 2) Glass and framing areas shall have U-factor of no greater than 0.24 with 1-3/4" (44.4 mm) High Performance (HP) Triple Glazed as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.

EDITOR NOTE: FOR IMPROVED U-FACTORS WITH FIBER GLASS PRESSURE PLATE BASED ON AAMA 507/NFRC100 SIMULATIONS PLEASE REFER TO THERMAL CHARTS IN ARCHITECTURAL DETAIL MANUAL, AVAILABLE ON KAWNEER.COM.

- b. 1600UT System™2 Curtain Wall:
 - 1) Project specific U-factor () BTU/Hr/Ft²/°F with 1" (25.4 mm) Glass as determined per AAMA 507 or NFRC 100.
 - 2) Project specific U-factor () BTU/Hr/Ft²/°F with 1-3/4" (44.4 mm) Triple Glazed Glass as determined per AAMA 507 or NFRC 100.

EDITOR NOTE: FOR IMPROVED U-FACTORS WITH FIBER GLASS PRESSURE PLATE BASED ON AAMA 507/NFRC100 SIMULATIONS PLEASE REFER TO THERMAL CHARTS IN ARCHITECTURAL DETAIL MANUAL, AVAILABLE ON KAWNEER.COM.

2. Solar Heat Gain Coefficient: Glass and framing areas shall have a solar heat gain coefficient of no greater than [0.35] [0.40] [0.45] <Insert value> as determined according to NFRC 200.

3. Air Leakage: Maximum air leakage through fixed glazing and framing areas of 0.06 cfm/sq.ft. (0.31 l/s.m²) of fixed wall area as determined according to ASTM E 283 and TAS 202 at a minimum static-air-pressure differential of 6.2 psf (300 Pa).
4. Condensation Resistance: When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 1600UT System™1 Curtain Wall:
 - 1) CRF_{glass} (1" [25.4 mm] Double Glazed HP) = 76, CRF_{frame} = 79
 - 2) CRF_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 81, CRF_{frame} = 82
5. Temperature Index (I): when tested to CSA-A440-00, the Temperature Index shall not be less than:
 - a. 1600UT System™1 Curtain Wall with aluminum pressure plate:
 - 1) I_{glass} (1" [25.4 mm] Double Glazed HP) = 67, I_{frame} = 71
 - 2) I_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 77, I_{frame} = 74
 - b. 1600UT System™1 Curtain Wall with fiber glass pressure plate:
 - 1) I_{glass} (1" [25.4 mm] Double Glazed HP) = 68, I_{frame} = 76
 - 2) I_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 78, I_{frame} = 76
- K. Storm Shelter Performance:
 1. Shall be tested to meet ICC500: ICC / NSSA Standard for the design and construction of storm shelters.
 2. Missile Criteria for tornado shelters.
 - a. Design Wind Speed:
 - 1) 200 mph (EF4)
 - 2) 240 mph (EF5)
 - b. Missile Speed:
 - 1) 90 mph (EF4)
 - 2) 100 mph (EF5)
- L. Sound Transmission: Provide glazed aluminum curtain walls with fixed glazing and framing areas having the following sound-transmission characteristics:
 1. 1600UT System™1 Curtain Wall:
 - a. STC-31 or OITC-25 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1" (25.4 mm) double insulating glass (1/4", 1/2" AS, 1/4")
 - b. STC-33 or OITC-27 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1-3/4" (44.4 mm) triple insulating glass (1/4", 1/2" AS, 1/4", 1/2" AS, 1/4").

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

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1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. 1600UT System™1 Curtain Wall or 1600UT System™2 Curtain Wall
 3. Frame depth options: 6" (152.4 mm) & 7-1/2" (190.5 mm) with 1" (25.4 mm) Double Glazed Insulating Glass; 6-3/4" (171.4 mm) & 8-1/4" (209.5 mm) with 1-3/4" (44.4 mm) Triple Glazed Insulating Glass
 4. Tested to AAMA 501-05 and TAS 202

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be either aluminum or fiberglass and fastened to the mullion with stainless steel screws. Fiberglass pressure plate shall be tested to ASTM D638, D790, D695, D953, D3846.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal barrier consists of 1" (25.4 mm) separation between the interior and exterior metal members in a typical condition. Thermal barrier assembly shall be tested to the thermal cycling requirements of ASTM E2692 and show no sign of degradation following the test.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4-sided captured or 2-sided SSG.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4 mm) and 1-3/4" (44.4 mm) insulating glass option. 1/4" (6.3 mm) or 1" (25.4 mm) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600UT System™1 Curtain Wall: Outside glazed pressure plate format with 1" (25.4 mm) double glazed and 1-3/4" (44.4 mm) triple glazed insulating glass.
 - 2. 1600UT System™2 Curtain Wall: Outside glazed structural silicone glazed (SSG) format with 1" (25.4 mm) double glazed and 1-3/4" (44.4 mm) triple glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- C. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.

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- c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
- a. Curtain wall framing system.
 - b. Storefront Framing System.
4. Submittals.
- a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- D. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
- 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
 - 8. Double seal design with primary air and vapor barrier at interior side of glazed aluminum curtain wall and secondary seal weeped and vented to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
- 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permardize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
 - 1. Comply with manufacturer's written instructions.
 - 2. Do not install damaged components.
 - 3. Fit joints to produce hairline joints free of burrs and distortion.
 - 4. Rigidly secure non-movement joints.
 - 5. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 - 6. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 - 7. Seal joints watertight unless otherwise indicated.
- B. Metal Protection:
 - 1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 - 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- D. Install components plumb and true in alignment with established lines and grades.
- E. Install operable units level and plumb, securely anchored, and without distortion. Adjust weather-stripping contact and hardware movement to produce proper operation.
- F. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- G. Install glazing as specified in Division 08 Section "Glazing."

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Leakage Tests: Conduct tests in accordance with ASTM E 783. Allowable air leakage shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 5500 Thermal Windows
 - b. Fixed window
 - c. 4" (102 mm) frame depth
 - d. Architectural Window Grade AW-PG80-F

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 90" (1524 x 2286). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 2. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 90" (1524 x 2286). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (500 Pa). The test specimen shall meet the B5 rating with no water leakage at 500 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 3. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3840 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2874 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
 5. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than .34 BTU/hr/ft²/°F.
7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than (72 frame) and (74 glass), or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than (62 frame) and (66 glass).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 5500 Thermal Windows - Fixed
 3. 4" (102) frame depth
 4. Architectural Window Grade AW-PG80-F

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)

2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 5500 Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

- G. Optional Perimeters and Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
- H. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 5525 Thermal Windows
 - b. Fixed window
 - c. 5" (127 mm) frame depth
 - d. Architectural Window Grade AW-PG75-F

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 90" (1524 x 2286). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 2. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 90" (1524 x 2286). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (500 Pa). The test specimen shall meet the B5 rating with no water leakage at 500 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 3. Uniform Load Deflection: A minimum static air pressure difference of 75 psf (3592 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2874 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
 5. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than .35 BTU/hr/ft²/°F.
7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than (73 frame) and (74 glass), or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than (64 frame) and (66 glass).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 5525 Thermal Windows - Fixed
 3. 5" (127) frame depth
 4. Architectural Window Grade AW-PG75-F

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)

2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 5525 Thermal Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

- G. Optional Perimeters and Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
- H. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 7500 Wall™ Curtain Wall System – 2-1/2" x 6-5/16" (63.5 x 160.3) or 2-1/2" x 7-5/16" (63.5 x 185.7), outside glazed pressure plate format.
 - 1) 7525 Wall™ with 1" (25.4) double glazing.
 - 2) 7550 Wall™ with 1-3/4" (44.4) triple glazing.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s· m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331 and ASTM E 547. There shall be no leakage at a static air pressure differential of 15 psf (720 Pa) as defined in AAMA 501.
- F. Structural performance shall be based on Aluminum Association "Specification for Aluminum Structures" or CSA Standard CAN3-S157 "Strength Design in Aluminum". There shall be no deflection in excess of L/175 of the span of any framing member at design load.

EDITOR NOTE: FOR 7525 WALL THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" (25.4 MM) DOUBLE GLAZED INSULATING GLASS UNIT WITH LOW EMISSIVITY COATING ON SURFACE 2, ARGON GAS FILLED INTERSPACE AND A HELIMA WARM EDGE GLAZING SPACER.

- G. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.36 BTU/hr· ft²· °F (2.02 W/m²· °C) or Project Specific () BTU/hr/ft² /°F, per AAMA 507 or () BTU/hr/ft² /°F, per NFRC 100.
- H. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 83_{frame} and 72_{glass}, or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 76_{frame} and 65_{glass}.

EDITOR NOTE: FOR 7550 WALL THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 2" (50 MM) TRIPLE GLAZED INSULATING GLASS UNIT WITH LOW EMISSIVITY COATING ON SURFACE 2 AND 5, TWO ARGON GAS FILLED INTERSPACES AND HELIMA WARM EDGE GLAZING SPACERS.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.17 BTU/hr· ft²· °F (0.98 W/m²· °C).
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 85_{frame} and 80_{glass}, or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 77_{frame} and 76_{glass}.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 7500 Wall™ Curtain Wall System.
 - a. 7525 Wall™ for 1" (25.4) double glazing.
 - b. 7550 Wall™ for 1-3/4" (44.4) triple glazing.
 - 3. Frame depth options: 2-1/2" x 6-5/16" (63.5 x 160.3) or 2-1/2" x 7-5/16" (63.5 x 185.7).
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Kawneer IsoWeb™ Thermal Break: All framing members shall consist of interior and exterior extruded aluminum sections that shall be integrated with two parallel, glass reinforced nylon strips forming a continuous composite assembly.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) or 1-3/4" (44.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Outside glazed pressure plate format with 1" (25.4) double or 1-3/4" (44.4) triple glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.

- 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- C. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadoze™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 083213 - SLIDING ALUMINUM-FRAMED GLASS DOORS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Sliding aluminum-framed glass doors, including factory glazing, operating hardware and accessories designed for exterior applications.
 - 1. Types of sliding aluminum-framed glass doors include:
 - a. Kawneer Series AA™3200 Thermal Sliding Doors
 - b. 6-3/4" (171.5 mm) frame depth
 - c. AW-PG135-SD

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 084113 "Aluminum-Framed Entrances and Storefronts"
- 4. 084313 "Aluminum-Framed Storefronts"
- 5. 084329 "Sliding Storefronts"
- 6. 084413 "Glazed Aluminum Curtain Walls"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 087000 "Hardware"
- 11. 088000 "Glazing"
- 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Sliding aluminum-framed glass door system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Sliding Aluminum-Framed Glass Door Performance Requirements:
 - 1. Performance Requirements: Provide sliding aluminum-framed glass doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG135-SD

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR SLIDING ALUMINUM-FRAMED GLASS DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide sliding door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s•m²) at a static air pressure differential of 1.56 psf (75 Pa).

4. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331. There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).
 - a. Water performance for optional low profile sill of 4 psf (192 Pa).
5. Uniform Load: A static air design load of 40 PSF (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing member in excess of 0.2% of the clear spans shall occur.
6. Forced Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 842.
7. Operating Force: Tested according to and complying with ASTM E2068.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" HIGH PERFORMANCE (HP) INSULATING GLASS (1/4" CLEAR WITH $\epsilon=0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS, 1/4" CLEAR).

8. Thermal Transmittance (U-Factor): The thermal transmittance (U-Factor) shall not be more than 0.45 when tested to AAMA 1503.

EDITOR NOTE: SELECT CONDENSATION PERFORMANCE BASED ON U.S. STANDARD (CRF) OR CANADIAN STANDARD (I) FROM BELOW.

9. Condensation Resistance Factor (CRF): When tested to AAMA 1503, the Condensation Resistance Factor shall not be less than:
 - a. 57_{frame} and 66_{glass}.
10. The Condensation Index (I): When tested to CSA-A440 shall not be less than:
 - a. 39_{frame} and 53_{glass}.

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

11. Sound Transmission class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with ASTM E90, the STC and OITC rating shall not be less than:
 - a. 38 (STC) and 33 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

12. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding aluminum-framed glass door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding aluminum-framed glass door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding aluminum-framed glass doors. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 1. Sliding Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding door hardware, as well as procedures and diagrams. Coordinate final sliding door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding aluminum-framed glass doors that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding aluminum-framed glass door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding aluminum-framed glass doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of sliding door(s) indicated, in location(s) shown on Drawings.

- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding aluminum-framed glass door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™3200 Thermal Sliding Doors
 - 3. 6-3/4" (171.5 mm) frame depth
 - 4. AW-PG135-SD

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding aluminum-framed glass doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed glass door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding door, provide sliding door manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Sliding Door

- A. Sliding Aluminum-Framed Glass Doors:
1. AA™3200 Thermal Sliding Doors.
 2. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
 3. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
 4. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
 5. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
 6. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle sliding door material and components to avoid damage. Protect sliding door material against damage from elements, construction activities, and other hazards before, during and after sliding door installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding aluminum-framed glass doors units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding aluminum-framed glass doors.
- B. Standard Hardware:
1. One pair of stainless steel tandem rollers per sliding panel.
 2. Stainless steel roller track.
 3. Hookbolt lock: [1-point Hookbolt lock] or [2-point Hookbolt lock].
 4. Pull handle exterior: [Flush finger pull] or ["D" Pull].
 5. Pull handle interior: [Flush finger pull] or ["D" Pull].

2.6 Insect Screens

- A. Optional Insect Screens: Extruded aluminum frames, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum sliding doors; splines shall be extruded vinyl, removable to permit rescreening.
- B. Hardware: Manufacturer's standard flush pull, adjustable stainless steel or steel rollers and continuous EPDM closure strip at jamb.

2.7 Fabrication

- A. Fabricate sliding aluminum-framed glass doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate sliding aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
1. Master Frame: Joined together with butt type joints, neatly sealed and assembled by a minimum of 2 stainless steel fasteners per joint anchored into continuous integral screw raceways.
 2. Sliding Panels: Shall have coped butt type joinery secured with stainless steel fasteners. Sliding panels shall not be removable when in a locked position.
 3. Fixed Panels: Shall have coped butt type joinery secured with stainless steel fasteners.
- C. Weather Stripping: Provide weather stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.
- D. Weep Holes: Provide weep holes and internal drainage passages to conduct infiltrating water to exterior as detailed.
- E. Factory-Glazed Fabrication: Glaze sliding aluminum-framed glass doors in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding doors, hardware, accessories, and other components.
- B. Install sliding doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding doors and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed sliding doors shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct in accordance with ASTM E 783. Tests shall be conducted at a minimum uniform static test pressure of 1.57 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted at a static test pressure equal to 2/3 of the tested laboratory performance test pressure.
 2. Testing Extent: Architect shall select sliding door units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured and prior to the installation of interior finishes and trim. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding doors. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect sliding door surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding door surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding door surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 083213

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™6400/6500/6600 Windows
 - b. Inswing and Outswing Casement Windows
 - c. 3-9/16" (90.4 mm) Inswing vent depth or 3-3/8" (85.7 mm) Outswing vent depth
 - d. AW-PG70-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-C

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of $L/175$ of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. Outswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
Inswing Casement: U-Factor not more than .40 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
 - b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 71 (frame) and 69 (glass).
 - b. Inswing Casement: CRF not less than 74 (frame) and 68 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: (I) not less than 62 (frame) and 64 (glass).
 - b. Inswing Casement: (I) not less than 70 (frame) and 68 (glass).
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: STC not less than 35; OITC not less than 28.
- b. Inswing Casement: STC not less than 33; OITC not less than 27.

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED STC AND OITC VALUES

12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum windows through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows - Inswing and Outswing Casement
 - 3. 3-9/16" (90.4 mm) Inswing vent depth or 3-3/8" (85.7 mm) Outswing vent depth
 - 4. AW-PG70-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. **Subject to compliance with requirements, provide a comparable product by the following:**
 - 1. **Manufacturer:** (_____)
 - 2. **Series:** (_____)
 - 3. **Profile dimension:** (_____)
 - 4. **Performance Grade:** (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements.
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid window installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. **Substitution Acceptance:** Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. **Aluminum Extrusions:** Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. **Thermal Barrier:** The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. **Fasteners:** Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. **Anchors, Clips, and Accessories:** Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™6400/6500/6600 Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior TPE gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Single Handle Multi-Point Locks (Standard)
 - b. Cast White Bronze Cam Locks (Outswing Casement)
 - c. Access Control Locks (Outswing Casement)
 - 2. Hinging
 - a. 4-Bar Hinges (Inswing Casement)
 - b. Limit Stop
 - c. Concealed Hinges (Outswing Casement)
 - d. Friction Adjusters
 - 3. Other
 - a. Roto Operator (Outswing Casement)

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 - 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- G. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.

4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and/or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.

- a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™ 6400/6500/6600 Windows
 - b. Fixed Window
 - c. 4" (101.6 mm) AA™ 6400 frame depth, 5" (127 mm) AA™ 6500 frame depth or 6" (152 mm) AA™ 6600 frame depth
 - d. AW-PG70-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Framing System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-FW

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 75 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. U-Factor not more than .31 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than 77 (frame) and 72 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than 73 (frame) and 66 (glass) for AA™6400 and 70 (frame) and 67 (glass) for AA™6500.
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass made with exterior 3/16" clear glass, 3/8" aluminum spacer, and interior 7/16" laminated clear glass:
 - i. STC not less than 38; OITC not less than 32.
- b. 1-3/4" insulating glass made with exterior 1/2" clear laminated glass, 1" aluminum spacer, and interior 1/4" clear laminated glass:
 - i. STC not less than 48; OITC not less than 38.
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows - Fixed
 - 3. 4" (101.6 mm) AA™6400 frame depth, 5" (127 mm) AA™6500 frame depth or 6" (152 mm) AA™6600 frame depth
 - 4. AW-PG70-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window Framing System

- A. Series AA™6400/6500/6600 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior TPE gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (45,72 cm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Framing: Fabricate components for assembly using manufacture's standard installation instructions.
- C. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.
- D. Thermally Improved Construction: Fabricate aluminum window framing with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™ 6400/6500/6600 Windows
 - b. Project-In and Project-Out Windows
 - c. 3-9/16" (90.4 mm) Project-In vent depth or 3-3/8" (85.7 mm) Project-Out vent depth
 - d. AW-PG70-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-AP

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. Project-Out: U-Factor not more than .43 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
Project-In: U-Factor not more than .40 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
 - b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: CRF not less than 71 (frame) and 69 (glass).
 - b. Project-In: CRF not less than 74 (frame) and 68 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: (I) not less than 62 (frame) and 64 (glass).
 - b. Project-In: (I) not less than 70 (frame) and 68 (glass).
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: STC not less than 35; OITC not less than 28.
- b. Project-In: STC not less than 33; OITC not less than 27.

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED STC AND OITC VALUES

12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum windows through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows
 - 3. Project-In and Project-Out
 - 4. 3-9/16" (90.4 mm) Project-In vent depth or 3-3/8" (85.7 mm) Project-Out vent depth
 - 5. AW-PG70-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements.
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid window installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. **Substitution Acceptance:** Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. **Aluminum Extrusions:** Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. **Thermal Barrier:** The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. **Fasteners:** Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™6400/6500/6600 Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Single Handle Multi-Point Locks (Standard) Project-In
 - b. Dual Handle Multi-Point Locks (Standard) Project-Out
 - c. Cast White Bronze Cam Locks (Project-Out)
 - d. Access Control Locks (Project-Out)
 - 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - 3. Other
 - a. Roto Operator (Project-Out)
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 - 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- G. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. C-HC90 / C-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/11.S.2/A440 (NAFS).
 - a. Performance Class and Grade: C-HC90
 - b. Performance Class and Grade: C-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.

4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 720 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Inswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 61 (53.2 I-frame).
- b. Inswing Casement: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Inswing and Outswing Casement
 - 3. 2-5/8" (67 mm) frame depth
 - 4. C-HC90 / C-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.

- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:

1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
 - c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:

1. True muntins.
2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.

- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Fixed window
 - c. 2-5/8" (67 mm) frame depth
 - d. AW-PG90-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-FW
 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
 5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.

6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than .34 BTU/hr/ft²/°F.
9. Condensation Resistance (CRF): When tested to AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than 67 (66 I-Frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Fixed
 - 3. 2-5/8" (67 mm) frame depth
 - 4. AW-PG90-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. AP-HC90 / AP-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AP-HC90
 - b. Performance Class and Grade: AP-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 6.24 psf (300 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Project-In: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: CRF not less than 61 (53.2 I-frame).
- b. Project-In: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Project-Out only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Project-In and Project-Out
 - 3. 2-5/8" (67 mm) frame depth
 - 4. AP-HC90 / AP-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window System

- A. Series AA™ 900 Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
- c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
3. Other
 - a. Roto Operator (Project-Out)
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.

2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.

- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. Clearwall™ Curtain Wall System - SS (Screw Spline)
 - 1) Clearwall™ (SS): 2-1/2" x 6-5/8" (63.5 x 168.3) or 2-1/2" x 5-1/8" (63.5 x 130.2), outside glazed with recessed glass edge spacer by qualified Insulated Glass Unit (IGU) manufacturer.
 - 2) Clearwall™ (SSI): 2-1/2" x 7-1/2" (63.5 x 190.5) or 2-1/2" x 6" (63.5 x 152.4), outside glazed with metal interfaced insulating glass (interface shop applied with structural silicone).
 - 3) Clearwall™ (SSIT): 2-1/2" x 7-3/8" (63.5 x 187.0) or 2-1/2" x 5-7/8" (63.5 x 149.0), outside glazed with metal interfaced insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).
 - b. Clearwall™ Curtain Wall System - SB (Shear Block)
 - 1) Clearwall™ (SB): 2-1/2" x 10-1/8" (63.5 x 257.2), outside glazed with recessed glass edge spacer by qualified Insulated Glass Unit (IGU) manufacturer.
 - 2) Clearwall™ (SBI): 2-1/2" x 11" (63.5 x 279.4), outside glazed with metal interfaced insulating glass (interface shop applied with structural silicone).
 - 3) Clearwall™ (SBIT): 2-1/2" x 10-27/32" (63.5 x 275.4), outside glazed with metal interfaced insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.

- b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____) Pa, inward and (____) lbs./sq. ft. or (____) Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Structural-Test Performance: Test according to ASTM E 330 and TAS 202 as follows:
1. When tested at positive and negative wind load design pressures, assemblies do not evidence deflection exceeding L/175 of clear span.
 2. A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction.
 - a. When tested at 150% of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2% percent of clear span.
 - b. Minimum test duration according to ASTM E 330 is 10 seconds.
- E. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Normal to Wall Plane: Limited to edge of glass in a direction perpendicular to glass plane not exceeding L/175 of the glass edge length for each individual glazing lite, or an amount that restricts edge deflection of individual glazing lites to 3/4 inch (19 mm), whichever is less.
 2. Deflection Parallel to Glazing Plane: Limited to [L/360 of clear span or 1/8 inch (3.2 mm), whichever is smaller] [amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8 inch (3.2 mm)].
 - a. Operable Units: Provide a minimum 1/16-inch (1.6-mm) clearance between framing members and operable units.
 3. Cantilever Deflection: Where framing members overhang an anchor point, limit deflection to two times the length of cantilevered member, divided by 175.
- F. Seismic Story Drift: Accommodate design displacement of adjacent stories indicated.
1. Design Displacement: Shall not exceed 1% of story height.
 2. Test Performance: Meeting criteria for passing based on building occupancy type when tested according to AAMA 501.4 at design displacement and 1.5 times the design displacement.
- G. Water Penetration under Static Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to ASTM E 331 and TAS 202 at 15psf (720 Pa).
- H. Water Penetration under Dynamic Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to AAMA 501.1 at dynamic pressure equal to 15psf (720 Pa).
1. Maximum Water Leakage: [According to AAMA 501.1] [No uncontrolled water penetrating assemblies or water appearing on assemblies' normally exposed interior surfaces from sources other than condensation]. Water leakage does not include water controlled by flashing and gutters that is drained to exterior.
- I. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 120 deg F (49 deg C), ambient; 180 deg F (82 deg C), material surfaces.
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)].
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5.
- J. Energy Performance: Glazed aluminum curtain walls shall be tested in accordance with NFRC and AAMA Standards.

EDITOR NOTE: HP Low-e BASED ON 1-1/8" (28.6) IG UNIT, e=0.04 #2, AIR FILLED, ALUMINUM SPACER.

- K. Thermal Transmittance (U-factor): Fixed glazing and framing areas shall have U-factor of no greater than 0.39 (HP Low-e) for Clearwall™ SS as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.
- L. Solar Heat Gain Coefficient: Fixed glazing and framing areas shall have a solar heat gain coefficient of no greater than [_____] <Insert value> as determined according to NFRC 200.
- M. Air Infiltration: Maximum air leakage through fixed glazing and framing areas of 0.06 cfm/sq.ft. (0.31 l/s.m²) of fixed wall area as determined according to ASTM E 283 and TAS 202 at a minimum static-air-pressure differential of 6.24 psf (300 Pa).
- N. Condensation Resistance: When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
1. Clearwall™ (SS): CRF_{glass} (HP Low-e) = 61, CRF_{frame} = 78
- O. Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
1. Clearwall™ (SS): I_{glass} (HP Low-e) = 56, I_{frame} = 74
- P. Sound Transmission: Provide glazed aluminum curtain walls with fixed glazing and framing areas having the following sound-transmission characteristics:
1. Clearwall™ (SS): STC-33 or OITC-28 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1-1/8" (28.6) insulating glass (1/4", 5/8" AS, 1/4").

2. Clearwall™ (SSI): STC-37 or OITC-30 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4" with Laminate).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Clearwall™ Curtain Wall System
 3. Frame depth options:
 - a. Clearwall™ Curtain Wall System - SS (Screw Spline).

- 1) Clearwall™ (SS): 2-1/2" x 6-5/8" (63.5 x 168.3) or 2-1/2" x 5-1/8" (63.5 x 130.2), outside glazed with recessed glass edge spacer by qualified Insulated Glass Unit (IGU) manufacturer.
- 2) Clearwall™ (SSI): 2-1/2" x 7-1/2" (63.5 x 190.5) or 2-1/2" x 6" (63.5 x 152.4), outside glazed with metal interfaced insulating glass (interface shop applied with structural silicone).
- 3) Clearwall™ (SSIT): 2-1/2" x 7-3/8" (63.5 x 187.0) or 2-1/2" x 5-7/8" (63.5 x 149.0), outside glazed with metal interfaced insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).
- b. Clearwall™ Curtain Wall System - SB (Shear Block).
 - 1) Clearwall™ (SB): 2-1/2" x 10-1/8" (63.5 x 257.2), outside glazed with recessed glass edge spacer by qualified Insulated Glass Unit (IGU) manufacturer.
 - 2) Clearwall™ (SBI): 2-1/2" x 11" (63.5 x 279.4), outside glazed with metal interfaced insulating glass (interface shop applied with structural silicone).
 - 3) Clearwall™ (SBIT): 2-1/2" x 10-27/32" (63.5 x 275.4), outside glazed with metal interfaced insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).
4. Tested to AAMA 501-05 and TAS 202.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- G. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 1. Glazing System: Retained mechanically with toggles on four sides.
 2. Glazing Plane: Front.
- B. Glass:

1. Clearwall™ (SS)/(SB): Outside glazed with 1-1/8" (28.6) insulating glass with 5/8" (15.9) recessed glass edge spacer supplied by qualified glass supplier.
 2. Clearwall™ (SSI)/(SBI): Outside glazed with metal interfaced 1" (25.4) insulating glass (interface shop applied with structural silicone).
 3. Clearwall™ (SSIT)/(SBIT): Outside glazed with metal interfaced 1" (25.4) insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
1. Toggle Assembly: Toggle assembly as tested by manufacturer.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
1. System: Outside toggle glazed format with 1" (25.4) or 1-1/8" (28.6) double glazed insulating glass.
 - a. Clearwall™ (SS)/(SB): Outside glazed with 1-1/8" (28.6) insulating glass with 5/8" (15.9) recessed glass edge spacer supplied by qualified glass supplier.
 - b. Clearwall™ (SSI)/(SBI): Outside glazed with metal interfaced 1" (25.4) insulating glass (interface shop applied with structural silicone).
 - c. Clearwall™ (SSIT)/(SBIT): Outside glazed with metal interfaced 1" (25.4) insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape). 3M™ to conduct application review prior to start of each project.
 - B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
 - C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
 - D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fitted joints.
 3. Physical and thermal isolation of glazing from framing members.
 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 5. Provisions for field replacement of glazing from exterior.
 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
 8. Double seal design with primary air and vapor barrier at interior side of glazed aluminum curtain wall and secondary seal weeped and vented to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
 1. Types of Kawneer Aluminum Storefront Systems include:
 - a. IR 501T/IR 501UT Framing – 2-3/4" x 5" (69.8 mm x 127 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.
 - b. IR 501T/IR 501UT Framing – Impact Glazing
 - c. IR 501T/IR 501UT Framing – Blast Mitigation

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 088000 "Glazing"
 11. 107113 "Exterior Sun Control Devices"
 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (720 Pa) as defined in AAMA 501.

4. Uniform Load: A static air design load of 30 psf (1436 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
5. Thermal Transmittance (U-Factor): When tested to AAMA specification 507 or NFRC100 the thermal transmittance (U-Factor) shall not be more than:

IR 501T:

 - a. (With 2-Piece Mullion) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.57 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 - b. (With 3-Piece Mullion) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.24 to 0.55 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
6. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW.

IR 501UT:

- a. 1" insulating glass:
 - i. U-Factor not more than .33 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" clear with e=0.035 low-e coating on surface #2, 1/2" air space with warm edge spacer and 90% argon gas fill, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

IR 501T:

- b. 1" insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:

IR 501UT:

- a. 68_{frame} and 70_{glass} (low-e).

8. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

IR 501UT:

- a. 59_{frame} and 65_{glass} (low-e).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

9. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:

IR 501UT:

- a. 38 (STC) and 33 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, b-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery, including concealed welds.
 - 2. Anchorage.
 - 3. Expansion provisions.
 - 4. Glazing.
 - 5. Flashing and drainage.
- G. Other Action Submittals:
 - 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. IR 501T/IR 501UT Framing
 - 3. IR 501T/IR 501UT Framing – Impact Glazing
 - 4. IR 501T/IR 501UT Framing – Blast Mitigation
 - 5. System Dimensions: 2-3/4" x 5" (69.8 mm x 127 mm)
 - 6. Glass: Center Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier:
 1. IR 501UT - Kawneer DUAL IsoLock™ Thermal Break with two (2) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
 2. IR 501T - Kawneer SINGLE IsoLock™ Thermal Break with one (1) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black

2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
3. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacturer of single-source for light shelf and framing system and compatibility between the system.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- E. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Fixed Window
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-FW.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .19 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
(CRF_f) frame not less than 78.
(CRF_g) glass not less than 82.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass:
Temperature Index (I_f) frame not less than 67.
Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.

- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Fixed
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 5/8" (15.9 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.

2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Inswing or Outswing Casement Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).

5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade (Outswing Casement only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Outswing Casement only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass: 33 (STC) and 26 (OITC).

- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...
Enter the following for an AAMA 2605 70% fluoropolymer paint finish
 - 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.4) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**

4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
6. Coating: **consult your Kawneer representative**

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 3. Patterns: grid patterns to be designated by architect.
 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 3. Interior: (two-piece snap trim;) (stool cover).
 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access **Enter wicket color choice: white, bronze, or black** wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.)

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800-07, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
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END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

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1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Project-Out only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 33 (STC) and 26 (OITC).
 - b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...
Enter the following for an AAMA 2605 70% fluoropolymer paint finish
 - 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.5) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
 1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].

- c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
- 6. Coating: *consult your Kawneer representative*

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 - 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 - 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 - 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 - 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 - 3. Patterns: grid patterns to be designated by architect.
 - 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 - 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 - 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 - 3. Interior: (two-piece snap trim;) (stool cover).
 - 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access *Enter wicket color choice: white, bronze, or black* wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.

6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
 - C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
 - D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
 - E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
 - F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
 - G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
 - H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ 451UT Framing – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.
 - b. Trifab™ 451UT Framing – Blast Mitigation, 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal. CSA A440 Fixed Rating.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 10 psf (479 Pa) as defined in AAMA 501.
4. Uniform Load: A static air design load of 30 psf (1436 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

5. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.
6. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
 - a. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 - b. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 - c. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $\epsilon=0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

7. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. 0.32 (low-e) or Project Specific (____) BTU/hr/ft²/°F.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 68_{frame} and 68_{glass} (low-e).
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 - a. 60_{frame} and 62_{glass} (low-e).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

10. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. 37 (STC) and 30 (OITC).

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.

- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Trifab™ 451UT Framing (Thermal)
 - 3. Trifab™ 451UT Framing (Thermal) - Blast Mitigation
 - 4. System Dimensions: 2" x 4-1/2" (50.8 mm x 114.3 mm)
 - 5. Glass: Center Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier (Trifab™ 451UT):
 - 1. Kawneer DUAL IsoLock™ Thermal Break with two (2) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
 - 1)
- B. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type, and as follows:
 - 1. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)

- a. Curtain Wall framing system.
- b. Storefront framing system.
- 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.
- C. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- D. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.

- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include.
 - a. 1600 Wall System™1 Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 1) System depth: 6" (152.4) or 7-1/2" (190.5) for 1" (25.4) insulating glazing and 1/4" (6.3) monolithic glazing.
 - b. 1600 Wall System™1 IR Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 2) System depth: 7-1/2" (190.5) depth for 9/16" (14.3) and 5/8" (15.9) monolithic glazing.
 - 3) System depth: 7-13/16" (198.4) or 10-13/16" (274.6) depth for 1-5/16" (33.3) insulating glazing.
 - c. 1600 Wall System™1 Curtain Wall Blast Mitigation – 2-1/2" (63.5) sightline, outside glazed pressure plate format.
 - 4) System depth: 7-1/2" (190.5) for 1" (25.4) insulating glazing.
 - d. 1600 Wall System™1 Ribbon Curtain Wall Blast Mitigation.
 - 5) System depth: 6" (152.4) for 1" (25.4) insulating glazing.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

- 1. 072700 "Air Barriers".
- 2. 079200 "Joint Sealants".
- 3. 083213 "Sliding Aluminum-Framed Glass Doors".
- 4. 084113 "Aluminum-Framed Entrances and Storefronts".
- 5. 084313 "Aluminum-Framed Storefronts".
- 6. 084329 "Sliding Storefronts".
- 7. 084433 "Sloped Glazing Assemblies".
- 8. 085113 "Aluminum Windows".
- 9. 086300 "Metal-Framed Skylights".
- 10. 088000 "Glazing".
- 11. 107113 "Exterior Sun Control Devices".
- 12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following.
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.

- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement (elastic) of 0.010 x the story height and ultimate displacement (inelastic) of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.66 (clear) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 66_{frame} and 60_{glass} (clear).

or

Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 68_{frame} and 54_{glass} (clear).

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR HIGH PERFORMANCE INSULATING GLASS, (1/4" (E=0.035,#2), 1/2" WARM EDGE SPACER AND ARGON GAS FILL, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- K. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.43 (HP glass) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- L. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 71_{frame} and 71_{glass} (HP glass).
- M. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than:
STC 31 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4"),
STC 37 or OITC 30 based upon 1" (25.4) laminated glass (1/4" laminated, 1/2" AS, 1/4" laminated).
- N. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
1. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
2. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
- O. Blast Mitigation performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- Section B-3.1.1 Dynamic analysis.
- Section B-3.1.2 Testing.
- Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following.
 - 1. Joinery.
 - 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - a. 1600 Wall System™1 Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 1) System depth: 6" (152.4) or 7-1/2" (190.5) for 1" (25.4) insulating glazing and 1/4" (6.3) monolithic glazing.
 - b. 1600 Wall System™1 IR Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 1) System depth: 7-1/2" (190.5) depth for 9/16" (14.3) and 5/8" (15.9) monolithic glazing.
 - 2) System depth: 7-13/16" (198.4) or 10-13/16" (274.6) depth for 1-5/16" (33.3) insulating glazing.
 - c. 1600 Wall System™1 Curtain Wall Blast Mitigation – 2-1/2" (63.5) sightline, outside glazed pressure plate format.
 - 1) System depth: 7-1/2" (190.5) for 1" (25.4) insulating glazing.
 - 2) Tested to AAMA 501, ASTM E 1886, E 1996 and TAS 201, 202, 203.
 - d. 1600 Wall System™1 Ribbon Curtain Wall Blast Mitigation.
 - 1) System depth: 6" (152.4) for 1" (25.4) insulating glazing.
 - 2) Tested to AAMA 501, ASTM E 1886, E 1996 and TAS 201, 202, 203.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following.
1. Manufacturer: (_____).
 2. Series: (_____).
 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" (6.3) separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1/4" (6.3), 9/16" (14.3), 5/8" (15.9) monolithic glass or 1" (25.4), 1-5/16" (33.3) insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600 Wall System™1 Curtain Wall.
 - a. System depth: 6" (152.4) or 7-1/2" (190.5) for 1" (25.4) insulating glazing and 1/4" (6.3) monolithic glazing.
 - 2. 1600 Wall System™1 IR Curtain Wall.
 - a. System depth: 7-1/2" (190.5) depth for 9/16" (14.3) and 5/8" (15.9) monolithic glazing.
 - b. System depth: 7-13/16" (198.4) or 10-13/16" (274.6) depth for 1-5/16" (33.3) insulating glazing.
 - 3. 1600 Wall System™1 Curtain Wall Blast Mitigation.
 - a. System depth: 7-1/2" (190.5) for 1" (25.4) insulating glazing.
 - 4. 1600 Wall System™1 Ribbon Curtain Wall Blast Mitigation.
 - a. System depth: 6" (152.4) for 1" (25.4) insulating glazing.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. 1600 PowerShade™ Sun Shade System: An aluminum sunshade consisting of strut anchors and strut arms and three louvers per bay with integral amorphous silicon (photovoltaic or P.V.) panels which produce nominal 45 watts of electrical generation per bay at peak performance. Optional aluminum panels are also available, if selected, in lieu of the P.V. panels. Strut anchors and strut arms shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- C. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- D. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of.
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system).
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 - 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including.
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics.
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION**3.1 Examination**

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements.
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.

- b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Window Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window wall framing.
 - 1. Types of Kawneer Aluminum Window Wall include:
 - a. MetroView™ FG 501T Window Wall – 2-1/4" x 5" (57.2 x 127), inside glazed or outside glazed system.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 107113 "Exterior Sun Control Devices"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum window walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum window walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum window walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Window Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.

- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (cyclic): The test specimen shall be tested in accordance with ASTM E 547. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Water Resistance, (severe, wind driven rain): The test specimen shall be tested in accordance with AAMA 520 and ASTM E2268. The test specimen shall pass performance level 5, pressure limits 9 psf (431 Pa) – 27 psf (1293 Pa).
- H. Uniform Load: A static air design load of 42 psf (2010 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-factor) shall not be more than;
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. U-Factor not more than 0.38 BTU/hr/ft² /°F. per AAMA 1503 or () BTU/hr/ft² /°F. per AAMA 507 or NFRC 100 when using project specified glass.
- J. Condensation Resistance Test (CRF): Provide aluminum window wall tested for thermal performance according to AAMA 1503, the condensation resistance factor (CRF) shall not be less than;
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. CRF not less than 69_{frame} and 68_{glass}.
- K. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;
 - 1. 1" insulating glass made with exterior 1/4" glass, 1/2" spacer, and interior 1/4" laminated glass.
 - a. STC not less than 36; OITC not less than 31.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum window walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum window walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed window wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery
 - 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum window walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum window wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of window wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum window walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. MetroView™ FG 501T Window Wall
 - 3. Frame depth options: 2-1/4" x 5" (57.2 x 127), inside glazed or outside glazed system
 - 4. Tested to AAMA 501

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum window walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum window wall manufacturer for strength, corrosion resistance, and application of required finish and each framing member shall have a wall thickness sufficient to meet the specified structural requirements and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window wall members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated window wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

- G. Thermal Barrier: Kawneer IsoLock™ Thermal Break with a 3/8" (9.5 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum window wall sections.
 - 1. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed window wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Window Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4-sided captured
 - 2. Glazing Plane: Front
- B. Glass: 1" (25.4) insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum window wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle window wall material and components to avoid damage. Protect window wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Inside glazed or outside glazed system with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by sealant manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 6. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum window wall to exterior.
- C. Window Wall Framing: Fabricate components for assembly using screw spline system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install window wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be inside glazed or outside glazed and held in place with extruded aluminum glass stops.
 - 3. Water Drainage: Each light of glass shall be internally drained using water deflectors and sealant to divert water to the sill horizontal weep locations. Weep holes shall be located in the sill to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select window wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum window wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.

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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 1. Types of Kawneer Aluminum Curtain Wall include.
 - a. 1600 Wall System™2 Curtain Wall – 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed, structural silicone glazed (SSG) format with 1" (25.4) insulating glass and 1/4" (6.3) monolithic glazing.
 - b. 1600 Wall System™2 IR Curtain Wall – 2-1/2" x 7-13/16" (63.5 x 198.4), outside glazed, structural silicone glazed (SSG) format with 1-5/16" (33.3) insulating glass.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

1. 072700 "Air Barriers".
2. 079200 "Joint Sealants".
3. 083213 "Sliding Aluminum-Framed Glass Doors".
4. 084113 "Aluminum-Framed Entrances and Storefronts".
5. 084313 "Aluminum-Framed Storefronts".
6. 084329 "Sliding Storefronts".
7. 084433 "Sloped Glazing Assemblies".
8. 085113 "Aluminum Windows".
9. 086300 "Metal-Framed Skylights".
10. 088000 "Glazing".
11. 107113 "Exterior Sun Control Devices".
12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following.
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____) Pa, inward and (____) lbs./sq. ft. (____) Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement (elastic) of 0.010 x the story height and ultimate displacement (inelastic) of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.57 (clear glass) or Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 68_{frame} and 59_{glass} (clear glass).

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR HIGH PERFORMANCE INSULATING GLASS, (1/4" (E=0.035,#2), 1/2" WARM EDGE SPACER AND ARGON GAS FILL, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- K. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.36 (HP glass) or Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- L. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 75_{frame} and 72_{glass} (HP glass).
or
Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 65_{frame} and 62.2_{glass} (HP glass).
- M. Sound Transmission Loss: When tested to ASTM E90, the Sound Transmission Class (STC) shall not be less than 31 and the outdoor-indoor transmission class (OITC) shall not be less than 25 based upon 1" (25.4) laminated glass (1/4" laminated, 1/2" AS, 1/4" laminated).
- N. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 1. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 2. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following.
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.

- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - 2. 1600 Wall System™2 Curtain Wall.
 - a. Frame depth options: 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed, structural silicone glazed (SSG) format, with 1" (25.4) insulating glass and 1/4" (6.3) monolithic glazing.
 - 3. 1600 Wall System™2 IR Curtain Wall.
 - a. Frame depth options: 2-1/2" x 7-13/16" (63.5 x 198.4), outside glazed, structural silicone glazed (SSG) format, with 1-5/16" (33.3) insulating glass.
 - 4. Tested to AAMA 501, ASTM E 1886, E 1996 and TAS 201, 202, 203.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following.
 - 1. Manufacturer: (_____).
 - 2. Series: (_____).
 - 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" (6.3) separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: Structural silicone glazed (SSG).
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) and 1-5/16" (33.3) insulating glass option. 1/4" (6.3) or 1" (25.4) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600 Wall System™2 Curtain Wall: Outside glazed, structural silicone glazed (SSG) format with 1" (25.4) insulating glass.
 - 2. 1600 Wall System™2 IR Curtain Wall: Outside glazed, structural silicone glazed (SSG) format with 1-5/16" (33.3) insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes).
- C. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of.
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system).
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including.
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics.
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fitted joints.
 3. Physical and thermal isolation of glazing from framing members.
 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 5. Provisions for field replacement of glazing from exterior.
 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION**3.1 Examination**

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements.
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Thermally Broken Aluminum Entrances, glass and glazing, and door hardware and components.
 1. Types of Kawneer Thermally Broken Aluminum Entrances include:
 - a. AA™250 Thermal Entrance; Narrow stile, 2-1/2" (63.5 mm) vertical face dimension, 2-1/4" (57 mm) depth, moderate traffic applications.
 - b. AA™425 Thermal Entrance; Wide stile, 4-1/4" (108 mm) vertical face dimension, 2-1/4" (57 mm) depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084313 "Aluminum-Framed Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 087000 "Hardware"
 11. 088000 "Glazing"
 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance doors shall withstand the effects of the following performance requirements without exceeding performance criteria or failure due to defective manufacture, fabrication, installation, or other defects in construction:
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance

door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm per square foot.

3. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 for typical application or L/180 for Small-Missile and Large-Missile impact, of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
4. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.3 Standard 12 for exterior doors and Standard 10 for glazing and frame bite provisions, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
5. Forced Entry: Tested in accordance with AAMA 1304.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $e=0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Insulated Glass – 0.43 (low-e) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per AAMA 507 per NFRC 100.
7. Solar Heat Gain Coefficient: Glazed thermally broken aluminum door and frame shall have a solar heat gain coefficient of no greater than (____) <Insert value> as determined according to NFRC 200.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Insulated Glass – 57_{frame} and 71_{glass} (low-e).
9. Condensation Resistance (I): When tested to CSA A440, the condensation resistance factor shall not be less than:
 - a. Insulated Glass – 48_{frame} and 69_{glass} (low-e).
10. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with ASTM E 90, the STC and OITC ratings shall not be less than:
 - a. 32 (STC) and 28 (OITC).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating thermally broken aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports and calculations.
- C. **Source Limitations:** Obtain thermally broken aluminum-framed door through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum-framed glass entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify actual dimensions of thermally broken aluminum-framed door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. The door stile and rail face dimensions of the [_____] (choose one: AA™250 or AA™425) Thermal Entrance will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
AA™250 Thermal Entrance	2-1/2" (63.5 mm)	2-1/2" (63.5 mm)	3-7/8" (99 mm)	10" (254 mm)
AA™425 Thermal Entrance	4-1/4" (108 mm)	4-1/4" (108 mm)	6-1/2" (166 mm)	10" (254 mm)
 - 3. Major portions of the door members to be 0.125" (4) nominal in thickness and glazing molding to be 0.05" (1.3 mm) thick
 - 4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
 - 5. Provide adjustable glass jacks to help center the glass in the door opening.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum entrance and storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum entrances and storefronts for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Slide-In-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing:
1. Trifab™ VG 451T
 2. Trifab™ 451UT
 3. Trifab™ 601/601T
 4. Thermally Broken entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware:
1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with two lines of weather-stripping utilizing wool pile with polymeric fin.

- b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing and a wool pile with polymeric fin.
 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 3. Threshold: Extruded aluminum, thermally broken, with ribbed surface.
 4. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
 5. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
 6. Continuous Hinge: [_____].
 7. Push/Pull: [_____] style.
 8. Exit Device: [_____].
 9. Closer: [_____].
 10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 11. Latch Handle: [_____].
 12. Cylinder(s)/Thumbturn: [_____].
 13. Electric Strike/Strike Keeper: [_____].
- C. Optional Hardware:

EDITOR NOTE: SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Adams Rite MS 1850A-505 Hookbolt Lock.
2. Mortise cylinder, interior or exterior.
3. Thumbturn, interior.
4. Flush pull.

2.6 Fabrication

- A. Fabricate thermally broken aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate thermally broken aluminum-framed doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1" (24 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufactures drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.

2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing thermally broken aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install thermally broken aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed door and storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ UT Windows (Structural Silicone Glazed)
 - b. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - c. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Performance Class and Grade:
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)
2. Air leakage: The test specimen shall be tested in accordance with ASTM E283. Air leakage rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.2 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.6 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa). The test specimen shall meet the B7 rating with no water leakage at 12 psf (575 Pa) when tested in accordance with CAN/CSA-A440-00 Windows;
4. Uniform Load Deflection: A minimum static air pressure difference [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C3, C4 or C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG70-C (with 3-Cam Handles); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-C (with 3-Cam handles); 90 psf (4309 Pa)
5. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.3% of span length.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 60 psf (2873 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 90 psf (4309 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 105 psf (5027 Pa)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-C (with 3-Cam Handles); 105 psf (5027 Pa)
6. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
 - a. Project-Out Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-AP (with 3-Cam handles); 135 psf (6464 Pa)

- b. Outswing Casement Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-C (with 3-Cam handles); 135 psf (6464 Pa)
- 7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
- 8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass:
 - 1) Project-Out: U-Factor not more than .56 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) clear glass, aluminum spacer, and interior 3/16" (4.76 mm) glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- b. 1-3/4" insulating glass:
 - 1) Project-Out and Outswing Casement: U-Factor not more than .23 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- 9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - i. Project-Out: CRF not less than 73 (frame) and 60 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: CRF not less than 80 (frame) and 82 (glass).
 - 2) Project-Out: CRF not less than 81 (frame) and 83 (glass).
- 10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - 1) Project-Out: (I) not less than 68 (frame) and 61 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: (I) not less than 70 (frame) and 73 (glass).
 - 2) Project-Out: (I) not less than 75 (frame) and 81 (glass).
- 11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass made with exterior 3/16" (4.76 mm) clear glass, 3/8" (9.52 mm) aluminum spacer, and interior 7/16" (11.11 mm) laminated clear glass:
 - 1) Project-Out: STC not less than 37; OITC not less than 30.
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 9/16" (14.29 mm) clear laminated glass, 7/8" (22.2 mm) aluminum spacer, and interior 5/16" (7.94 mm) clear laminated glass:
 - 1) Outswing Casement: STC not less than 41; OITC not less than 34.
- 12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
- 13. Blast Mitigation performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
- b. Section B-3.1.2 Testing
- c. Section B-3.1.3 ASTM F2248 Design Approach
- 14. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
- b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. GLASSvent™ UT Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 - a. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP
 - ii. CW-PG60-AP
 - iii. CW-PG70-AP
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP
 - ii. AW-PG90-AP
 - b. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C
 - ii. CW-PG70-C
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C

ii. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ UT Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.
- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
 - 1. Stainless Steel 4-Bar Hinges
 - 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- 3. Cast white Bronze Cam Handle with Pole Ring
- 4. Cast White Bronze Access Control (Custodial) Locks with Removable Handle

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T5 or 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.2 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 084413 - GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall units.
1. Types of Kawneer Curtain Wall and Glazed Assemblies include:
- a. 1630 SS IR Curtain Wall System: (Hurricane Impact and Blast Mitigation) - 3" x 7-13/16" (76.2 x 198.4) or 8-13/16" (76.2 x 223.8), outside glazed pressure plate format, with 1-5/16" (33.3) laminated insulating glass.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY CONTROL.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
- a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Structural-Test Performance: Test according to ASTM E 330 and TAS 202 as follows:
1. When tested at positive and negative wind load design pressures, assemblies do not evidence deflection exceeding L/180 of clear span.
 2. A static air design load of 130 psf (6224.4 Pa) shall be applied in the positive and negative direction.

- a. When tested at 150% of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2% percent of clear span.
 - b. Minimum test duration according to TAS 202 is 30 seconds.
- E. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Normal to Wall Plane: Limited to edge of glass in a direction perpendicular to glass plane not exceeding L/180 of the glass edge length for each individual glazing lite, or an amount that restricts edge deflection of individual glazing lites to 3/4 inch (19 mm), whichever is less. Limit deflection of clear span of framing members to L/180 for spans less than or equal to 13'-6" (4.11 meters) and L/240 + 1/4" for spans greater than 13'-6" (4.11 meters).
 2. Deflection Parallel to Glazing Plane: Limited to [L/360 of clear span or 1/8" (3.2 mm), whichever is smaller] [amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8" (3.2 mm)].
 - a. Operable Units: Provide a minimum 1/16" (1.6 mm) clearance between framing members and operable units.
 3. Cantilever Deflection: Where framing members overhang an anchor point, limit deflection to two times the length of cantilevered member, divided by 175.
- F. Water Penetration under Static Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to ASTM E 331 and TAS 202 at 15psf (720 Pa).
- G. Water Penetration under Dynamic Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to AAMA 501.1 at dynamic pressure equal to 15psf (720 Pa).
1. Maximum Water Leakage: [According to AAMA 501.1] [No uncontrolled water penetrating assemblies or water appearing on assemblies' normally exposed interior surfaces from sources other than condensation]. Water leakage does not include water controlled by flashing and gutters that is drained to exterior.
- H. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)].
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.
- I. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
1. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 2. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
- J. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria. To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
1. Section B-3.1.1 Dynamic analysis
 2. Section B-3.1.2 Testing
 3. Section B-3.1.3 ASTM F2248 Design Approach
- K. Energy Performance: Glazed aluminum curtain walls shall be tested in accordance with NFRC and AAMA Standards.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" OR 1-3/4" CLEAR HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E, ARGON FILLED, WITH WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

1. Thermal Transmittance (U-factor):
 - a. 1630 SS IR Curtain Wall System:
 - 1) Glass and framing areas shall have U-factor of no greater than 0.44 with 1-5/16" (33.3) High Performance (HP) Glass as determined according to AAMA 1503 or Project specific (___) BTU/Hr/Ft²/°F per AAMA 507 or (___) BTU/Hr/Ft²/°F per NFRC 100.
 2. Solar Heat Gain Coefficient: Glass and framing areas shall have a solar heat gain coefficient of no greater than [0.20] [0.25] [0.30] <Insert value> as determined according to NFRC 200.
 3. Air Infiltration: Maximum air leakage through fixed glazing and framing areas of 0.06 cfm/sq.ft. (0.31 l/s.m²) of fixed wall area as determined according to ASTM E 283 and TAS 202 at a minimum static-air-pressure differential of 6.24 psf (300 Pa).
 4. Condensation Resistance: When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 1630 SS IR:
 - 1) CRF_{glass} (1-5/16" 1G HP) = 70, CRF_{frame} = 74
 5. Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
 - a. 1630 SS IR aluminum pressure plate:
 - 1) I_{glass} (1-5/16" 1G HP) = 63, I_{frame} = 67
- L. Sound Transmission: Provide glazed aluminum curtain walls with fixed glazing and framing areas having the following sound-transmission characteristics:
1. 1630 SS IR:
 - a. (STC = 37) or (OITC = 32) when tested for laboratory sound transmission loss according to AAMA 1801, ASTM E 90 and ASTM E 1425, and based on 1-5/16" (33.3) laminated insulating glass (1/4", 1/2" AS, 1/4").

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery
 - 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR'S NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1630 SS IR Curtain Wall System: 3" (76.2) sightline.
 - 3. Frame depth options:
 - a. Hurricane Impact and Blast Mitigation: 7-13/16" and 8-13/16" with 1-5/16" (33.3) Laminated Insulating Glass.
 - 4. Tested to AAMA 501-05 and ASTM E 1886, E 1996 and TAS 201, 202, 203.

EDITOR'S NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal barrier consists of 9/16" (14.25 mm) separation between the interior and exterior metal members in a typical condition.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1-5/16" (33.3) laminated insulating glass for vision and Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1630 SS IR Curtain Wall: Outside glazed pressure plate format with 1-5/16" (33.3) laminated insulating glass.
 - 2. 1630 SS IR Curtain Wall Blast Mitigation: Outside glazed pressure plate format with 1" laminated insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using screw spline system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
1. Comply with manufacturer's written instructions.
 2. Do not install damaged components.
 3. Fit joints to produce hairline joints free of burrs and distortion.
 4. Rigidly secure non-movement joints.
 5. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 6. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 7. Seal joints watertight unless otherwise indicated.
- B. Metal Protection:
1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- D. Install components plumb and true in alignment with established lines and grades.
- E. Install operable units level and plumb, securely anchored, and without distortion. Adjust weather-stripping contact and hardware movement to produce proper operation.
- F. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- G. Install glazing as specified in Division 08 Section "Glazing."

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 10 psf (479 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 1. Types of Kawneer Aluminum Entrances include:
 - a. 190 Swing Door; Narrow stile, 2-1/8" (54 mm) vertical face dimension, 1-3/4" (44.5 mm) depth, moderate traffic applications.
 - b. 350 Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 1-3/4" (44.5 mm) depth, high traffic applications.
 - c. 500 Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 1-3/4" (44.5 mm) depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084313 "Aluminum-Framed Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"
12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 PA) for single and pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

A. Basis-of-Design Product:

1. Kawneer Company Inc.
2. The door stile and rail face dimensions of the [_____] (choose one: 190-350-500) entrance door will be as follows

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
190	2-1/8" (54 mm)	2-1/4" (58 mm)	3-7/8" (99 mm)	10" (254 mm)
350	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)

3. Major portions of the door members to be 0.125" (3.2) nominal in thickness and glazing molding to be 0.05" (1.3) thick.
4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
5. Provide adjustable glass jacks to help center the glass in the door opening.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
2. Series: (_____)
3. Profile dimension: (_____)
4. Performance Grade: (_____)

C. Substitutions: Refer to Substitutions Section for procedures and submission requirements

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed entrance door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

A. Storefront Entrance Framing:

1. Trifab™ VG 450/451/451T or Trifab™ 451UT.
2. Trifab™ 601/601T/601UT.

3. Thermally Broken entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware:
 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 4. Center Pivots: [_____].
 5. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
 6. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
 7. Continuous Hinge: [_____].
 8. Push/Pull: [_____] style.
 9. Exit Device: [_____].
 10. Closer: [_____].
 11. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 12. Latch Handle: [_____].
 13. Cylinder(s)/Thumbturn: [_____].
 14. Electric Strike/Strike Keeper: [_____].
- C. Optional Hardware:

EDITOR NOTE SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Adams Rite MS 1850A-505 Hookbolt Lock.
2. Mortise cylinder, interior or exterior.
3. Thumbturn, interior.
4. Flush pull.

- D. Access Control Entrance Hardware:
 - 1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
 - 2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
 - 3. Proximity Cards.
 - 4. Exit Device: Kawneer Paneline™ EL
 - 5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
 - 6. Power supply for Electric Strike: Altronix AL UL 175.
 - 7. Power Transfer [_____]. One per EL Exit Device required for access control.
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
 - 8. Interior push button release.
 - 9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
 - 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 - 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 - 3. Prepare components with internal reinforcement for door hardware.
 - 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.

- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrance doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 2500 PG Wall™ Curtain Wall System – 2-1/2" x 7-1/2" (63.5 x 190.5) nominal dimension, Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - b. 2500 PG Wall™ Curtain Wall System (Impact Glazing) Zone 3, Level D – 2-1/2" x 7-1/2" (63.5 x 190.5) nominal dimension, Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide curtain wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (Static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any curtain wall member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the curtain wall members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA1503 OR CSA A440 ARE BASED UPON 1" (25.4) CLEAR INSULATING GLASS (1/4", 1/2" AS 1/4"). REFER TO THERMAL CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): The (U-factor) shall not be more than: 0.65 (clear) per AAMA 1503 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA 1503, the CRF shall not be less than: Captured – 69_{frame} and 58_{glass} (clear).
or
- K. Condensation Index (I): When tested in accordance with CSA-A440-00, the Condensation Index shall not be less than: Captured – 58_{frame} and 43.6_{glass} (clear).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" (25.4) CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

- L. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than 35 (STC) and 28 (OITC).
- M. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 1. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 2500 PG Wall™ Curtain Wall System - Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - 3. 2500 PG Wall™ Curtain Wall System (Impact Glazing) Zone 3, Level D - Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - 4. Frame depth options: 2-1/2" x 7-1/2" (63.5 x 190.5)
 - 5. Tested to AAMA 501

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Aluminum Entrances include:
 - a. 350 Heavy Wall™ Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - b. 500 Heavy Wall™ Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - c. 350 Heavy Wall™ IR Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - d. 500 Heavy Wall™ IR Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084313 "Aluminum-Framed Storefronts"
 - 5. 084329 "Sliding Storefronts"
 - 6. 084413 "Glazed Aluminum Curtain Walls"
 - 7. 084433 "Sloped Glazing Assemblies"
 - 8. 085113 "Aluminum Windows"
 - 9. 086300 "Metal-Framed Skylights"
 - 10. 087000 "Hardware"
 - 11. 088000 "Glazing"
 - 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction:
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide aluminum-framed entrance door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for single doors and for pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].
4. Uniform Load: A static air design load of 85 psf (4070 Pa), (65 psf (3113 Pa) for laminated infill) shall be applied in the positive and negative direction in accordance with Florida Building Code TAS202 and ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage shall occur.
5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
7. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.

1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of aluminum-framed entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:

1. Kawneer Company Inc.
2. The door stile and rail face dimensions of the [_____] (choose from below) entrance door will be as follows

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
350 Heavy Wall™	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 Heavy Wall™	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)
350 Heavy Wall™ IR	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 Heavy Wall™ IR	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)

3. Major portions of the door members to be 0.188" (5 mm) nominal in thickness and glazing molding to be 0.05" (1.5 mm) thick.
4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
5. (350/500 Heavy Wall™) Provide adjustable glass jacks to help center the glass in the door opening.
6. (350/500 Heavy Wall™ IR) Structural silicone sealant to be DOW 995 or Tremco Proglaze SSG.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
2. Series: (_____)
3. Profile dimension: (_____)
4. Performance Grade: (_____)

- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed entrance door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing:
 - 1. Trifab™ 450/451/451T
 - 2. Trifab™ 601/601T
 - 3. IR 500/501
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle aluminum-framed entrance door material and components to avoid damage. Protect aluminum-framed entrance door material against damage from elements, construction activities, and other hazards before, during and after aluminum-framed entrance door installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
 - 1. 350/500 Heavy Wall IR: 9/16" (14.3 mm) laminated infill with 0.090" (3 mm) PVB interlayer.
 - 2. 350/500 Heavy Wall IR: 9/16" (14.3 mm) laminated infill with Solutia Vanceva 0.075" (2 mm) interlayer, Dupont SG 0.090" (3 mm) interlayer.
 - 3. 350/500 Heavy Wall IR: 0.090" (3 mm) PVB interlayer, Dupont SG 0.090" (3 mm) interlayer.
 - 4. 350/500 Heavy Wall IR BLAST: 9/16" (14.3 mm) laminated infill with 0.090" (3 mm) PVB interlayer.
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware (350/500 Heavy Wall™):
 - 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).

3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
4. Offset Pivots: [_____].
5. Butt Hinge: [_____].
6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: [_____].
9. Closer: [_____].
10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
11. Latch Handle: [_____].
12. Cylinder(s)/Thumbturn: [_____].
13. Electric Strike/Strike Keeper: [_____].

C. Standard Hardware (350/500 Heavy Wall™ IR):

1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
4. Offset Pivots: [_____].
5. Butt Hinge: [_____].
6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: [_____].
 - a. Concealed Rod Device; Kawneer 1686, Jackson 2086, Paneline™, Falcon HH1690, Von Duprin 9947HH.
 - b. Rim Exit Device; Von Duprin 98/99.
9. Closer: [_____].
10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
11. Latch Handle: [_____].
12. Cylinder(s)/Thumbturn: [_____].
13. Electric Strike/Strike Keeper: [_____].

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ EL CONCEALED ROD EXIT DEVICE OR OTHER ELECTRONIC SECURITY ITEMS.

D. Access Control Entrance Hardware:

1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
3. Proximity Cards.
4. Exit Device: Kawneer Paneline™ EL.
5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
6. Power supply for Electric Strike: Altronix AL UL 175.
7. Power Transfer [_____]. One per EL Exit Device required for access control:
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
8. Interior push button release.
9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed entrance doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.

- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrances. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Aluminum Entrances include.
 - a. 350 IR Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 1-3/4" (44.5) mm depth, high traffic applications.
 - b. 500 IR Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 1-3/4" (44.5) mm depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections.
 - 1. 072700 "Air Barriers".
 - 2. 079200 "Joint Sealants".
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors".
 - 4. 084313 "Aluminum-Framed Storefronts".
 - 5. 084329 "Sliding Storefronts".
 - 6. 084413 "Glazed Aluminum Curtain Walls".
 - 7. 084433 "Sloped Glazing Assemblies".
 - 8. 085113 "Aluminum Windows".
 - 9. 086300 "Metal-Framed Skylights".
 - 10. 087000 "Hardware".
 - 11. 088000 "Glazing".
 - 12. 280000 "Electronic Safety and Security".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum Framed Entrance Performance Requirements.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for single doors and pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].
4. Uniform Load: A static air design load of 85 psf (4070 Pa), (65 psf (3113 Pa) for laminated infill) shall be applied in the positive and negative direction in accordance with Florida Building Code TAS202 and ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage shall occur.
5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.3 Standard 12 for Exterior Doors and Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis.
 - b. Section B-3.1.2 Testing.
 - c. Section B-3.1.3 ASTM F2248 Design Approach.
7. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance doors and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following.
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals.
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - 2. The door stile and rail face dimensions of the 350IR/500IR entrance door will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
350 IR	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 IR	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)
 - 3. Major portions of the door members to be 0.125" (4) nominal in thickness and glazing molding to be 0.05" (1.5) thick.
 - 4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
 - 5. Structural silicone sealant to be Dow Corning 983, 995 or Tremco Proglaze SSG.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following.
 - 1. Manufacturer: (_____).
 - 2. Series: (_____).
 - 3. Profile dimension: (_____).
 - 4. Performance Grade: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" wall thickness at any location for the main frame and door leaf members.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing.
 - 1. Trifab™ VG 450/451/451T.
 - 2. IR500/501.
 - 3. IR501UT/IR501T.
 - 4. Trifab™ 601/601T.
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after aluminum-framed entrance door installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glass.
 - 1. 9/16" laminated infill with .090" (3) PVB interlayer.
 - 2. 9/16" laminated infill with Solutia Vanceva .075" (2) interlayer, Dupont SGP .090" (3) interlayer.
- C. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- D. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware.
 - 1. Weather-stripping.
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 - 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 - 4. Offset Pivots: [_____].
 - 5. Butt Hinge: [_____].

6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: Kawneer 1686 Concealed Rod Exit Device, Paneline™ Concealed Rod Exit Device, Adams Rite G86 Concealed Rod Exit Device, Calibre 9100 Concealed Rod Exit Device, Falcon HH1690 Concealed Rod Exit Device, Jackson 2080 Concealed Rod Exit Device, Sargent 8400AD Concealed Rod Exit Device or Von Duprin HH9947 Concealed Rod Exit Device.
9. Closer: Surface or concealed closer (concealed closer with non-transom and non-sidelite Trifab™ VG 450 (Center) and 1600 Wall sub-frames only).
10. Security Lock/Dead Lock: MS 1850A lock with 3-point active stile locking and hurricane flushbolts on pairs, Adams Rite 2180 2-Point Dead Lock or MS 1850A with 1871 cylinder operated flushbolts.
11. Cylinder(s)/Thumbturn: Kawneer standard.
12. Cylinder Guard: Kawneer standard.

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ EL CONCEALED ROD EXIT DEVICE OR OTHER ELECTRONIC SECURITY ITEMS.

C. Access Control Entrance Hardware.

1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
3. Proximity Cards.
4. Exit Device: Kawneer Paneline™ EL.
5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
6. Power supply for Electric Strike: Altronix AL UL 175.
7. Power Transfer [_____]. One per EL Exit Device required for access control.
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
8. Interior push button release.
9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed glass entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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PART 3 - EXECUTION**3.1 Examination**

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrance doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Fixed Window
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 6' x 6' (1829 x 1829 mm) for F-HC100 and 5' x 8' (1524 x 2438 mm) for F-AW100. The air infiltration rate shall not exceed 0.06 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 6' x 6' (1829 x 1829 mm) for F-HC100 and 5' x 8' (1524 x 2438 mm) for F-AW100. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI/AAMA 101.
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Fixed
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 7225 (Non-Thermal) Fixed Window

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 1" (25,4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS, SEE THE PANNINGS AND TRIMS SECTION OF THE KAWNEER ARCHITECTURAL WINDOWS MANUAL.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.

3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: When closed and locked, test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 3' x 5' (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² of vent perimeter at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 3' x 5' (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: When closed and locked, a minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Uniform Load Structural Test: When closed and locked, a minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, hardware parts, support arms, actuating mechanisms or any other damage which would cause the window to be inoperable, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Inswing and Outswing Casement
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW SYSTEM

- A. Series 7225 Non-Thermal Windows - Inswing and Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Roto-Operator
 - e. Multipoint Lock
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Butt Hinges
 - c. Friction Adjusters
 - d. Limit Stop
- 3. Other:
 - a. Pole Ring

b. Pole

C. Optional Egress Hardware Set:

1. Locking:
 - a. Multipoint Lock
2. Hinging:
 - a. Butt Hinges
3. Friction Adjusters

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

D. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:

1. True Muntins
2. Between The Glass Muntins
3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

E. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.

F. Optional Venetian Blinds: 1" aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

G. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:

1. Profiles that are sharp, straight, and free of defects or deformations.
2. Accurately fit joints; make joints flush, hairline and weatherproof.
3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
4. Physical and thermal isolation of glazing from framing members.
5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
6. Provisions for field replacement of glazing.
7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints

C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.

G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).

H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
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5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
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7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
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 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
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- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
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END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

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 - b. Project-In and Project-Out Windows
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG90-AP

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 - 1. 072700 "Air Barriers"
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 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
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 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: When closed and locked, test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 5' x 3' (1524 x 914 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² of vent perimeter at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 5' x 3' (1524 x 914 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: When closed and locked, a minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: When closed and locked, a minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, hardware parts, support arms, actuating mechanisms or any other damage which would cause the window to be inoperable, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Project-In and Project-Out
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG90-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 7225 Non-Thermal Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Projected Windows Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Pivot Shoe Roto-Operator
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- D. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- E. Optional Venetian Blinds: 1" aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8225TL Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG90-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 36" x 60" (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 36" x 60" (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of $L/175$ of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. Outswing Casement: U-Factor not more than .60 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
 - b. Inswing Casement: U-Factor not more than .62 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. Outswing Casement: (CRF_f) frame not less than 56 with clear glass.
Outswing Casement: (CRF_g) glass not less than 55 with clear glass.
 - b. Inswing Casement: (CRF_f) not less than 56 with clear glass.
Inswing Casement: (CRF_g) not less than 55 with clear glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Inswing and Outswing Casement
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be a Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Inswing and Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Roto-Operator
 - e. Multipoint Lock
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Butt Hinges
 - c. Friction Adjusters
 - d. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole
- C. Optional Egress Hardware Set:
 - 1. Locking:
 - a. Multipoint Lock
 - 2. Hinging:
 - a. Butt Hinges
 - b. Friction Adjusters
- D. Other:
 - 1. "Escape/Rescue Window" Label

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- E. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 - 1. True Muntins
 - 2. Between The Glass Muntins
 - 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- F. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- G. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- H. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.

- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- 1. Types of aluminum windows include:
 - a. Series 8225TL Thermal Windows
 - b. Fixed Window
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 60" x 99" (1524 x 2515 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 60" x 99" (1524 x 2515 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .58 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503 with clear glass, the condensation resistance factor (CRF) shall not be less than (CRF_f 59) frame and (CRF_g 57) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Sound Performance: When tested in accordance with ASTM E 90, the STC shall not be less than (34) and OITC not less than (28) based on 1" (25.4 mm) IG with 1/2" (12.7 mm) air space.
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Fixed
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
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3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
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- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8225TL Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG90-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG90-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 36" x 60" (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 36" x 60" (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. Project-Out: U-Factor not more than .60 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
 - b. Project-In: U-Factor not more than .62 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. Project-Out: (CRF_f) frame not less than 56 with clear glass.
Project-Out: (CRF_g) glass not less than 55 with clear glass.
 - b. Project-In: (CRF_f) not less than 56 with clear glass.
Project-In: (CRF_g) not less than 55 with clear glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out with 0.125" wall thickness).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Project-Out with 0.125" wall thickness).
10. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8225TL Thermal Windows - Project-In and Project-Out
 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 4. AW-PG90-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Project-In and Project-Out

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Windows Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Pivot Shoe Roto-Operator
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 - 1. True Muntins
 - 2. Between The Glass Muntins
 - 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- D. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- E. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.

7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:

1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8430TL Single Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG70-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG70-H

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .51 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 55) (Glass = 62).

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
 To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.
13. Sound: Testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (34 STC) and (29 OITC).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8400TL Thermal Windows
 3. Model 8430TL Single Hung Window
 4. 4" (101.6 mm) frame depth
 5. AW-PG70-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 1/4" (6.35 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window System

- A. Series 8400TL Thermal Windows - Single Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8450TL Double Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. H-HC70 / H-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: H-HC70
 - b. Performance Class and Grade: H-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 51) (Glass = 63) .
8. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .52 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Sound: testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (33 STC) and (29 OITC).
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8400TL Thermal Windows
 3. Model 8450TL Double Hung Window
 4. 4" (101.6 mm) frame depth
 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Double Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom and top sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
6. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8410TL Fixed Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 60" x 99" (1524 x 2515 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 60" x 99" (1524 x 2515 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .48 BTU/hr/sf/°F or (____) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503 with 1" (25,4 mm) insulating clear glass, the condensation resistance factor shall not be less than (CRF_f 67) frame and (CRF_g 66) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Sound Performance: When tested in accordance with ASTM E 90 and E 413, the sound transmission loss (STL) shall not be less than 39.
10. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8410TL Fixed Window
 - 4. 4" (101.6 mm) frame depth
 - 5. AW-PG100FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Fixed Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- C. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and mechanically clipped and/or staked, factory sealed frame and vent corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8470TL Horizontal Sliding Window
 - c. 4" (101.6 mm) frame depth
 - d. HS-HC70 / HS-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: HS-HC70
 - b. Performance Class and Grade: HS-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 96" x 80" (2438 x 2032 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 PA).

3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 96" x 80" (2438 x 2032 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Temperature Index Test: (CRF) when tested in accordance with CAN/CSA A440, the Temperature Index shall not be less than (CRF_f 38.2) frame and (CRF_g 61.2) glass
8. Thermal Transmittance Test: (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .55 BTU/hr/sf/°F or () BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test: (CRF) when tested in accordance with AAMA 1503, the condensation resistance factor shall not be less than (CRF_f 50) frame and (CRF_g 61) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound: Testing per ASTM 1801 with 1" insulating glass made with (1/4" annealed exterior with, 1/2" airspace, 1/4" annealed interior): minimum (34 STC) and (29 OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems..

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8470TL Horizontal Sliding Window
 - 4. 4" (101.6 mm) frame depth
 - 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Window - Horizontal Sliding Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Continuous Integral Pulls
2. Stainless Steel Ball Bearing Rollers
3. Stainless Steel Roller Track
4. Plunger Lock

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints.

- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 1011/1.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar material to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.

- b. **Water Infiltration Test:** Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. **Testing Extent:** Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. **Test Reports:** Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 083213 - SLIDING ALUMINUM-FRAMED GLASS DOORS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Sliding aluminum-framed glass doors, including factory glazing, operating hardware and accessories designed for exterior applications.
 - 1. Types of sliding aluminum-framed glass doors include:
 - a. Kawneer Series AA™3200 Thermal Sliding Doors
 - b. 6-3/4" (171.5 mm) frame depth
 - c. AW-PG135-SD

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 084113 "Aluminum-Framed Entrances and Storefronts"
- 4. 084313 "Aluminum-Framed Storefronts"
- 5. 084329 "Sliding Storefronts"
- 6. 084413 "Glazed Aluminum Curtain Walls"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 087000 "Hardware"
- 11. 088000 "Glazing"
- 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Sliding aluminum-framed glass door system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Sliding Aluminum-Framed Glass Door Performance Requirements:
 - 1. Performance Requirements: Provide sliding aluminum-framed glass doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG135-SD

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR SLIDING ALUMINUM-FRAMED GLASS DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide sliding door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s•m²) at a static air pressure differential of 1.56 psf (75 Pa).

4. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331. There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).
 - a. Water performance for optional low profile sill of 4 psf (192 Pa).
5. Uniform Load: A static air design load of 40 PSF (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing member in excess of 0.2% of the clear spans shall occur.
6. Forced Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 842.
7. Operating Force: Tested according to and complying with ASTM E2068.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" HIGH PERFORMANCE (HP) INSULATING GLASS (1/4" CLEAR WITH $\epsilon=0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS, 1/4" CLEAR).

8. Thermal Transmittance (U-Factor): The thermal transmittance (U-Factor) shall not be more than 0.45 when tested to AAMA 1503.

EDITOR NOTE: SELECT CONDENSATION PERFORMANCE BASED ON U.S STANDARD (CRF) OR CANADIAN STANDARD (I) FROM BELOW.

9. Condensation Resistance Factor (CRF): When tested to AAMA 1503, the Condensation Resistance Factor shall not be less than:
 - a. 57_{frame} and 66_{glass}.
10. The Condensation Index (I): When tested to CSA-A440 shall not be less than:
 - a. 39_{frame} and 53_{glass}.

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

11. Sound Transmission class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with ASTM E90, the STC and OITC rating shall not be less than:
 - a. 38 (STC) and 33 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

12. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding aluminum-framed glass door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding aluminum-framed glass door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding aluminum-framed glass doors. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 1. Sliding Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding door hardware, as well as procedures and diagrams. Coordinate final sliding door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding aluminum-framed glass doors that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding aluminum-framed glass door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding aluminum-framed glass doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of sliding door(s) indicated, in location(s) shown on Drawings.

- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding aluminum-framed glass door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™3200 Thermal Sliding Doors
 - 3. 6-3/4" (171.5 mm) frame depth
 - 4. AW-PG135-SD

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding aluminum-framed glass doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed glass door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding door, provide sliding door manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Sliding Door

- A. Sliding Aluminum-Framed Glass Doors:
1. AA™3200 Thermal Sliding Doors.
 2. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
 3. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
 4. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
 5. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
 6. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle sliding door material and components to avoid damage. Protect sliding door material against damage from elements, construction activities, and other hazards before, during and after sliding door installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding aluminum-framed glass doors units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding aluminum-framed glass doors.
- B. Standard Hardware:
1. One pair of stainless steel tandem rollers per sliding panel.
 2. Stainless steel roller track.
 3. Hookbolt lock: [1-point Hookbolt lock] or [2-point Hookbolt lock].
 4. Pull handle exterior: [Flush finger pull] or ["D" Pull].
 5. Pull handle interior: [Flush finger pull] or ["D" Pull].

2.6 Insect Screens

- A. Optional Insect Screens: Extruded aluminum frames, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum sliding doors; splines shall be extruded vinyl, removable to permit rescreening.
- B. Hardware: Manufacturer's standard flush pull, adjustable stainless steel or steel rollers and continuous EPDM closure strip at jamb.

2.7 Fabrication

- A. Fabricate sliding aluminum-framed glass doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate sliding aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
1. Master Frame: Joined together with butt type joints, neatly sealed and assembled by a minimum of 2 stainless steel fasteners per joint anchored into continuous integral screw raceways.
 2. Sliding Panels: Shall have coped butt type joinery secured with stainless steel fasteners. Sliding panels shall not be removable when in a locked position.
 3. Fixed Panels: Shall have coped butt type joinery secured with stainless steel fasteners.
- C. Weather Stripping: Provide weather stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.
- D. Weep Holes: Provide weep holes and internal drainage passages to conduct infiltrating water to exterior as detailed.
- E. Factory-Glazed Fabrication: Glaze sliding aluminum-framed glass doors in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding doors, hardware, accessories, and other components.
- B. Install sliding doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding doors and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed sliding doors shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct in accordance with ASTM E 783. Tests shall be conducted at a minimum uniform static test pressure of 1.57 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted at a static test pressure equal to 2/3 of the tested laboratory performance test pressure.
 - 2. Testing Extent: Architect shall select sliding door units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured and prior to the installation of interior finishes and trim. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding doors. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect sliding door surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding door surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding door surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 083213

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. C-HC90 / C-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/11.S.2/A440 (NAFS).
 - a. Performance Class and Grade: C-HC90
 - b. Performance Class and Grade: C-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.

4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 720 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Inswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 61 (53.2 I-frame).
- b. Inswing Casement: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Inswing and Outswing Casement
 - 3. 2-5/8" (67 mm) frame depth
 - 4. C-HC90 / C-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.

- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:

1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
 - c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:

1. True muntins.
2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.

- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Fixed window
 - c. 2-5/8" (67 mm) frame depth
 - d. AW-PG90-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-FW
 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
 5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.

6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than .34 BTU/hr/ft²/°F.
9. Condensation Resistance (CRF): When tested to AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than 67 (66 I-Frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Fixed
 - 3. 2-5/8" (67 mm) frame depth
 - 4. AW-PG90-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. AP-HC90 / AP-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AP-HC90
 - b. Performance Class and Grade: AP-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 6.24 psf (300 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Project-In: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: CRF not less than 61 (53.2 I-frame).
- b. Project-In: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Project-Out only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Project-In and Project-Out
 - 3. 2-5/8" (67 mm) frame depth
 - 4. AP-HC90 / AP-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window System

- A. Series AA™ 900 Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
- c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
3. Other
 - a. Roto Operator (Project-Out)
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.

2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.

- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. This Section includes Kawneer Flushline™ Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Flushline™ Entrances include:
 - a. Flushline™ Entrance; urethane foam-filled door, flush face design, high traffic and high abuse.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084313 "Aluminum-Framed Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"
12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed flush entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283.
3. Uniform Load: The test specimen shall be tested in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
4. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Aluminum-Framed Flush Entrance Doors with glass lites – with Aluminum Panel = 0.82 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.

- b. Aluminum-Framed Flush Entrance Doors with glass lites – with FRP Panel = 0.66 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
5. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F2927, ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
- To meet UFC 04-010-01, B-3.3 Standard 12 for exterior doors and Standard 10 for glazing and frame bite provisions, the following options are available:
- a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
6. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed flush entrance doors indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed flush entrance doors and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 - 1. Joinery, including welds.
 - 2. Flush face panel.
- G. Other Action Submittals:
 - 1. Aluminum-Framed Flush Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed flush entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports and calculations.
- C. Source Limitations: Obtain aluminum-framed flush entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed flush entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed flush entrance doors openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE FACE SHEET TYPE (FRP OR ALUMINUM) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. The door stile and rail face dimensions of the Flushline™ Entrance door will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail
Flushline™	5" (127 mm)	5" (127 mm)	5" (127 mm)
 3. The door face sheet shall be () (specify one of the following).
 - a. Pebble textured fiberglass reinforced polyester (FRP) 0.090" (2.3 mm).
 - b. Architectural quality aluminum sheet 0.090" (2.3 mm) thick (specify: embossed or plain unpatterned).
 4. Vision lites, if required:
 - a. Aluminum-framed vision lite (AVL)
 5. Glass for vision lites to be () (specify 1/4" (6.4 mm), 1" (25.4 mm) insulated clear tempered glass or 1" (25.4 mm) impact glass).
 6. Vision lite glazing shall be with foam glazing tape.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: ()
 2. Series: ()
 3. Profile dimension: ()
 4. Performance Grade: ()
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed flush entrance and storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum entrances and storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed flush door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Aluminum-Framed Flush Entrance Door Core: Shall be urethane foam injected at 2.5 lb./cu.ft. density and shall have "0" O.D.P. = "Zero" Ozone Depletion Potential and contains no Chlorofluorocarbons (CFC's) or Hydro chlorofluorocarbons (HCFC's).
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed flush entrance door members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing Non-Thermal (Trifab™ VG 450, Trifab™ VG 451 or Trifab™ 601)
- B. Storefront Entrance Framing Thermal (Trifab™ 451UT or Trifab™ 601T/601UT)
1. Thermally Broken Entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density urethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- C. Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- E. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- F. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- G. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed flush entrance doors.
- B. Standard Hardware:
 - 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (necessary to meet specified performance tests).
 - 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 - 4. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
 - 5. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
 - 6. Continuous Hinge: [_____].
 - 7. Push/Pull: [_____] style.
 - 8. Exit Device: [_____].
 - 9. Closer: [_____].
 - 10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 - 11. Latch Handle: [_____].
 - 12. Cylinder(s)/Thumbturn: [_____].
 - 13. Electric Strike/Strike Keeper: [_____].

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ CONCEALED ROD EXIT DEVICE OR OTHER ELECTORIC SECURITY ITEMS.

- C. Access Control Entrance Hardware
 - 1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
 - 2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
 - 3. Proximity Cards.
 - 4. Exit Device: Kawneer Paneline™ EL.
 - 5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
 - 6. Power supply for Electric Strike: Altronix AL UL 175.
 - 7. Power Transfer [_____]. One per EL Exit Device required for access control:
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
 - 8. Interior push button release.
 - 9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed flush entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed flush entrance doors that are reglazable, when vision lites are used, without dismantling perimeter framing.
 - 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners.
 - 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.

3. Face sheets shall lap and interlock with stile and rails to create a hollow cavity for the froth-in-place urethane core.
 4. Prepare components with internal reinforcement for door hardware.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
- Kawneer Permanodic™ AA-M10C21A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
- Kawneer Permanodic™ AA-M10C21A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
- Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
- Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
- Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
- Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
- Other: Manufacturer _____ Type _____ Color _____.
- C. Face Sheets:
1. Pebble texture (FRP) fiberglass reinforced polyester (Color _____) (select from list)
Beige, Dark Bronze, Light Grey and White.
 2. Kawneer Aluminum (select one of the finishes previously stated for exposed aluminum from above).

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed flush entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed flush entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed flush entrance doors and storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 083213 - SLIDING ALUMINUM-FRAMED GLASS DOORS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Aluminum Sliding Glass Doors, including factory glazing, operating hardware and accessories designed for exterior applications.

- 1. Types of sliding aluminum-framed glass doors include:
 - a. Kawneer Series HPS™ Monumental Sliding Doors
 - b. 6-1/2" (165 mm) sill frame depth
 - c. SGD-HC60 / SGD-HC80 / SGD-HC100 / SGD-HC120

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 084113 "Aluminum-Framed Entrances and Storefronts"
- 4. 084313 "Aluminum-Framed Storefronts"
- 5. 084329 "Sliding Storefronts"
- 6. 084413 "Glazed Aluminum Curtain Walls"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 087000 "Hardware"
- 11. 088000 "Glazing"
- 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Sliding aluminum-framed glass door system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Sliding Aluminum-Framed Glass Door Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS SGD-HC60 / SGD-HC80 / SGD-HC100 / SGD-HC120 BASED ON PROJECT REQUIREMENTS.

- 1. Performance Requirements: Provide sliding aluminum-framed glass doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: SGD-HC60
 - b. Performance Class and Grade: SGD-HC80
 - c. Performance Class and Grade: SGD-HC100
 - d. Performance Class and Grade: SGD-HC120

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR SLIDING ALUMINUM-FRAMED GLASS DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide sliding aluminum-framed glass door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 6.24 psf (300 Pa).
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
5. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
6. Forced Entry Resistance: Comply with Performance Grade 10 requirements when tested according to AAMA 1303.5.
7. Deglazing Force: When tested in accordance with ASTM E 987, the panel shall not move from their original position, in relation to the glazing materials, by more than the original glass bite.
8. Operating Force: With each movable panel adjusted, the maximum force to open shall not exceed 40 lbf (178 N) and the force to keep in motion shall not exceed 25 lbf (111 N).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding aluminum-framed glass doors indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding aluminum-framed glass door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding aluminum-framed glass doors. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 1. Sliding Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding door hardware, as well as procedures and diagrams. Coordinate final sliding door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding aluminum-framed glass doors that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding aluminum-framed glass door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding aluminum-framed glass doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of sliding door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding aluminum-framed glass door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) BASED ON PROJECT REQUIREMENTS

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series HPS™ Monumental Sliding Doors
 - 3. 6-1/2" (165 mm) sill frame depth
 - 4. SGD-HC-60 / SGD-HC-80 / SGD-HC-100 / SGD-HC-120

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding aluminum-framed glass doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed glass door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding door, provide sliding door manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Sliding Door

- A. Sliding Aluminum-Framed Glass Doors:
 - 1. HPS™ Monumental Sliding Doors.
 - 2. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
 - 3. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
 - 4. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

5. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
6. Storage and Protection: Store sliding door materials protected from exposure to harmful weather conditions. Handle material and components to avoid damage. Protect material against damage from elements, construction activities, and other hazards before, during and after sliding door installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding aluminum-framed glass doors units.
- B. Glazing System: Glazing method for operable panel shall be a channel type PVC gasket (marine glazed) which is compatible with aluminum and shall be resistant to deterioration by all forms of weathering and suitably retained to maintain a watertight seal between the glass and the surrounding frame. Glazing method for fixed panel shall be manufacturer's standard compression types; replaceable, extruded EPDM rubber.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding aluminum-framed glass doors.
- B. Standard Hardware:
 1. One pair of stainless steel tandem rollers per sliding panel.
 2. Stainless steel roller track.
 3. Adams Rite 1847 Stainless Steel Deadlock.
 4. Extruded pull handle exterior.
- C. Optional Hardware:

EDITOR NOTE: SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Adams Rite MS 1850A-505 Hookbolt Lock.
2. Mortise cylinder, interior or exterior.
3. Thumbturn, interior.
4. Flush pull.

2.6 Insect Screens

- A. Optional Insect Screens: Extruded aluminum frames, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum sliding doors; splines shall be extruded vinyl, removable to permit rescreening.
- B. Hardware: Manufacturer's standard flush pull, adjustable stainless steel or steel rollers and continuous EPDM closure strip at jamb.

2.7 Fabrication

- A. Fabricate sliding aluminum-framed glass doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate sliding aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
 1. Master Frame: Joined together with butt type joints, neatly sealed and assembled by a minimum of 2 stainless steel fasteners per joint anchored into continuous integral screw raceways.
 2. Sliding Panels: Shall have coped butt type joinery secured by means of 2 stainless steel fasteners per joint. Sliding panels shall not be removable when in a locked position.
 3. Fixed Panels: Shall have coped butt type joinery secured by means of 2 stainless steel fasteners per joint.
- C. Weather Stripping: Provide weather stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.
- D. Weep Holes: Provide weep holes and internal drainage passages to conduct infiltrating water to exterior as detailed.
- E. Factory-Glazed Fabrication: Glaze sliding aluminum-framed glass doors in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding doors, hardware, accessories, and other components.
- B. Install sliding doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding doors and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed sliding doors shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct in accordance with ASTM E 783. Tests shall be conducted at a minimum uniform static test pressure of 1.57 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted at a static test pressure equal to 2/3 of the tested laboratory performance test pressure.
 - 2. Testing Extent: Architect shall select sliding door units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured and prior to the installation of interior finishes and trim. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding doors. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect sliding door surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding door surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding door surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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END OF SECTION 083213

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 083213 - SLIDING ALUMINUM-FRAMED GLASS DOORS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Sliding Aluminum-Framed Glass Doors, including factory glazing, operating hardware and accessories designed for exterior applications.

1. Types of sliding aluminum-framed glass doors include:
 - a. Kawneer Series HPX Monumental Sliding Doors
 - b. 6-3/4" (171.5 mm) sill frame depth
 - c. SGD-HC115 / SGD-HC125 / SGD-HC137 / SGD-HC160

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 084113 "Aluminum-Framed Entrances and Storefronts"
4. 084313 "Aluminum-Framed Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"
12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Sliding aluminum-framed glass door system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Sliding Aluminum-Framed Glass Door Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS SGD-HC115 / SGD-HC125 / SGD-HC137 / SGD-HC160 BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide sliding aluminum-framed glass doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: SGD-HC115
 - b. Performance Class and Grade: SGD-HC125
 - c. Performance Class and Grade: SGD-HC137
 - d. Performance Class and Grade: SGD-HC160

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR SLIDING ALUMINUM-FRAMED GLASS DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide sliding aluminum-framed glass door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 6.24 psf (300 Pa).
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
5. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
6. Forced Entry Resistance: Comply with Performance Grade 30 requirements when tested according to ASTM F 842.
7. Deglazing Force: When tested in accordance with ASTM E 987, the panel shall not move from their original position, in relation to the glazing materials, by more than the original glass bite.
8. Operating Force: With each movable panel adjusted, the maximum force to open shall not exceed 40 lbf (178 N) and the force to keep in motion shall not exceed 25 lbf (111 N).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding aluminum-framed glass doors indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding aluminum-framed glass door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding aluminum-framed glass doors. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 1. Sliding Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding door hardware, as well as procedures and diagrams. Coordinate final sliding door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding aluminum-framed glass doors that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding aluminum-framed glass door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding aluminum-framed glass doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of sliding door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding aluminum-framed glass door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) BASED ON PROJECT REQUIREMENTS

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series HPX Monumental Sliding Doors
 - 3. 6-3/4" (171.5 mm) sill frame depth
 - 4. SGD-HC115 / SGD-HC125 / SGD-HC137 / SGD-HC160

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding aluminum-framed glass doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed glass door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding door, provide sliding door manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Sliding Door

- A. Sliding Aluminum-Framed Glass Doors:
 - 1. HPX Monumental Sliding Doors.
 - 2. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
 - 3. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
 - 4. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
6. Storage and Protection: Store sliding door materials protected from exposure to harmful weather conditions. Handle material and components to avoid damage. Protect material against damage from elements, construction activities, and other hazards before, during and after sliding door installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding aluminum-framed glass doors units.
- B. Glazing System: Glazing method shall be a channel type PVC gasket (marine glazed) which is compatible with aluminum and shall be resistant to deterioration by all forms of weathering and suitably retained to maintain a watertight seal between the glass and the surrounding frame.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding aluminum-framed glass doors.
- B. Standard Hardware:
 1. One pair of stainless steel tandem rollers per sliding panel.
 2. Stainless steel roller track.
 3. Adams Rite 1847 Stainless Steel Deadlock.
 4. Extruded pull handle.
- C. Optional Hardware:

EDITOR NOTE: SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Mortise cylinder, interior or exterior.
2. Thumbturn, interior.

2.6 Insect Screens

- A. Optional Insect Screens: Extruded aluminum frames, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum sliding doors; splines shall be extruded vinyl, removable to permit rescreening.
- B. Hardware: Manufacturer's standard flush pull, adjustable stainless steel or steel rollers and continuous EPDM closure strip at jamb.

2.7 Fabrication

- A. Fabricate sliding aluminum-framed glass doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate sliding aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
 1. Master Frame: Joined together with butt type joints, neatly sealed and assembled by a minimum of 2 stainless steel fasteners per joint anchored into continuous integral screw raceways.
 2. Sliding Panels: Shall have coped butt type joinery secured by means of 2 stainless steel fasteners per joint. Sliding panels shall not be removable when in a locked position
 3. Fixed Panels: Shall have coped butt type joinery secured by means of 2 stainless steel fasteners per joint.
- C. Weather Stripping: Provide weather stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.
- D. Weep Holes: Provide weep holes and internal drainage passages to conduct infiltrating water to exterior as detailed.
- E. Factory-Glazed Fabrication: Glaze sliding aluminum-framed glass doors in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding doors, hardware, accessories, and other components.
- B. Install sliding doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding doors and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed sliding doors shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct in accordance with ASTM E 783. Tests shall be conducted at a minimum uniform static test pressure of 1.57 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted at a static test pressure equal to 2/3 of the tested laboratory performance test pressure.
 2. Testing Extent: Architect shall select sliding door units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured and prior to the installation of interior finishes and trim. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding doors. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect sliding door surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding door surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding door surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 083213

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
 - 1. Types of Kawneer Aluminum Storefront Systems include.
 - a. IR 500 Framing – 2-1/2" x 5" (63.5 mm x 127 mm) nominal dimension; Non-Thermal; Center Plane for 9/16" (14.3 mm) Impact Resistant Glazing, Screw Spline Fabrication.
 - b. IR 501 Framing – 2-1/2" x 5" (63.5 mm x 127 mm) nominal dimension; Non-Thermal; Center Plane for 1-5/16" (33.4 mm) Impact Resistant Glazing, Screw Spline Fabrication.
 - c. IR 501 Framing – 2-1/2" x 5" (63.5 mm x 127 mm) nominal dimension; Non-Thermal; Center Plane for 1-5/16" (33.4 mm) Blast Mitigation Glazing, Screw Spline Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

- 1. 072700 "Air Barriers".
- 2. 079200 "Joint Sealants".
- 3. 083213 "Sliding Aluminum-Framed Glass Doors".
- 4. 084113 "Aluminum-Framed Entrances and Storefronts".
- 5. 084329 "Sliding Storefronts".
- 6. 084413 "Glazed Aluminum Curtain Walls".
- 7. 084433 "Sloped Glazing Assemblies".
- 8. 085113 "Aluminum Windows".
- 9. 086300 "Metal-Framed Skylights".
- 10. 088000 "Glazing".
- 11. 107113 "Exterior Sun Control Devices".
- 12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal.
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.

4. Uniform Load: A static air design load of 65 psf (3112 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.4% of their clear spans shall occur.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-frame storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following.
 1. Joinery.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.
- G. Other Action Submittals.
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. Structural-Sealant Glazing: Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.

- H. Structural-Sealant Joints: Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE IR 500 OR IR 501 FRAMING

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - 2. IR 500 Framing (Non-Thermal).
 - 3. IR 501 Framing (Non-Thermal).
 - 4. IR 501 Framing (Non-Thermal) - Blast Mitigation.
 - 5. System Dimensions: 2-1/2" x 5" (63.5 mm x 127 mm).
 - 6. Glass: Center Plane.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following.
 - 1. Manufacturer: (_____).
 - 2. Series: (_____).
 - 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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2.3 Storefront Framing System

- A. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposes shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black.
 2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of.
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be. (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including.
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

- B. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- C. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics.
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

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3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.

- 1. Types of Kawneer Aluminum Storefront Systems include:

- a. IR 501T/IR 501UT Framing – 2-3/4" x 5" (69.8 mm x 127 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.
- b. IR 501T/IR 501UT Framing – Impact Glazing
- c. IR 501T/IR 501UT Framing – Blast Mitigation

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084329 "Sliding Storefronts"
- 6. 084413 "Glazed Aluminum Curtain Walls"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 107113 "Exterior Sun Control Devices"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal.
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (720 Pa) as defined in AAMA 501.

4. Uniform Load: A static air design load of 30 psf (1436 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
5. Thermal Transmittance (U-Factor): When tested to AAMA specification 507 or NFRC100 the thermal transmittance (U-Factor) shall not be more than:

IR 501T:

 - a. (With 2-Piece Mullion) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.57 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 - b. (With 3-Piece Mullion) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.24 to 0.55 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
6. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW.

IR 501UT:

- a. 1" insulating glass:
 - i. U-Factor not more than .33 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" clear with e=0.035 low-e coating on surface #2, 1/2" air space with warm edge spacer and 90% argon gas fill, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

IR 501T:

- b. 1" insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:

IR 501UT:

- a. 68_{frame} and 70_{glass} (low-e).

8. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

IR 501UT:

- a. 59_{frame} and 65_{glass} (low-e).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

9. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:

IR 501UT:

- a. 38 (STC) and 33 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, b-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery, including concealed welds.
 - 2. Anchorage.
 - 3. Expansion provisions.
 - 4. Glazing.
 - 5. Flashing and drainage.
- G. Other Action Submittals:
 - 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. IR 501T/IR 501UT Framing
 - 3. IR 501T/IR 501UT Framing – Impact Glazing
 - 4. IR 501T/IR 501UT Framing – Blast Mitigation
 - 5. System Dimensions: 2-3/4" x 5" (69.8 mm x 127 mm)
 - 6. Glass: Center Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier:
 1. IR 501UT - Kawneer DUAL IsoLock™ Thermal Break with two (2) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
 2. IR 501T - Kawneer SINGLE IsoLock™ Thermal Break with one (1) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black

2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
3. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacturer of single-source for light shelf and framing system and compatibility between the system.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- E. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-3500 Windows
 - b. Project-Out Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG80-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTORS AND CFR.

8. U-Factor Simulation: thermal computer simulation per NFRC 100, at the prescribed 59" x 24" (1498 x 610) Non-Residential Size, glazed with 1" insulating glass made with exterior 1/4" Solarban 60, thermoplastic butyl spacer, argon gas, and interior 1/4" clear glass: Thermal Transmittance to be not less than 0.41 BTU/HR/SQ.FT/°F - U-Factor.
9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Sound: Testing per ASTM E90 with 1" insulating glass made with 1/8" – air – 1/4" glass: Minimum (34 STC).
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series NX-3500 Windows - Project-Out
 - 3. 3-1/4" (83 mm) frame depth
 - 4. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-3500 Windows - Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles and Strikes
 - b. Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with steel spring clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.

- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.

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2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9100 Windows
 - b. Single Hung Side Load Window
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG50-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG50-H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 50 psf (2400 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 75 psf (3600 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTORS AND CFR.

8. Thermal Test: Per AAMA 1503, at the prescribed 48" x 72" (1219 x 1829) test size glazed with 1" insulating glass made with 1/4" , argon gas, and 1/4" glass with low E coating:
 - a. Condensation Resistance Factor: Minimum (56 frame) and (62 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.51 BTU/HR/SQ.FT/°F.
9. U-Factor Simulation: Per NFRC 100, at the prescribed 48" x 72" (1219 x 1829) Non-Residential Size, glazed with 1" insulating glass made with exterior 1/4" , argon gas, and interior 1/4" glass with low E coating:
 - a. Thermal Transmittance to be maximum 0.51 BTU/HR/SQ.FT/°F.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
 13. Sound Test: Testing per ASTM E90 with 1" insulating glass made with exterior 1/4" laminated glass - 1/8" glass x .060 PVB interlayer x 1/8" glass - and interior 3/16" clear glass: Minimum (36 STC) and (31 OITC).
 14. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.

- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series TR-9100 Windows - Single Hung Side Load
 - 3. 3-1/4" (82.5 mm) frame depth
 - 4. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.062" (1.57 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9100 Windows - Single Hung Side Load

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Typical Hardware:
 - a. Aluminum Automatic Sill Locks
 - b. (Optional) White Bronze Automatic Sill Locks
 - c. (Optional) White Bronze Pole Ring on meeting rail
 - d. (Optional) Keyed plunger Limit Lock (Specify clear opening or travel distance in inches, e.g. 6")

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 - 1. True muntins.
 - 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in exterior applied PVC rigid tracks with two stainless steel leaf springs; 7/16" x 1-1/4" x .045 extruded tubular aluminum frame with window finish; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh secured to frame with PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.

- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:

1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
 1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ VG 450 Framing System – 1-3/4" x 4-1/2" (44.5 mm x 114.3 mm) nominal dimension; Non-Thermal; Front, Center, Back, Multi-Plane, Structural Silicone or Weatherseal Glazed (Type B); Screw Spline, Shear Block, Stick or Punched Opening Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 088000 "Glazing"
 11. 107113 "Exterior Sun Control Devices"
 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 8 psf (383 Pa) as defined in AAMA 501.
4. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Warranty: Special warranty specified in this Section.
- G. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery, including concealed welds.
 - 2. Anchorage.
 - 3. Expansion provisions.
 - 4. Glazing.
 - 5. Flashing and drainage.
- H. Other Action Submittals:
 - 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. Structural-Sealant Glazing: Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.
- H. Structural-Sealant Joints: Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 Manufacturers**

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Trifab™ VG 450 Framing System (Non-Thermal)

3. System Dimensions: 1-3/4" x 4-1/2" (44.5 mm x 114.3 mm)
4. Glass: Center, Exterior or Interior

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum framing members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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- a. Color: Black
2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- B. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront system installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.

- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.24 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM.

1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ VG 451 Framing System – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Non-Thermal; Front, Center, Back, Multi-Plane, Structural Silicone or Weatherseal Glazed (Type B); Screw Spline, Shear Block, Stick or Punched Opening Fabrication.
 - b. Trifab™ VG 451 Framing System – Impact Glazing and Blast Mitigation.
 - c. Trifab™ VG 451T Framing System – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Thermal; Front, Center, Back, Multi-Plane, Structural Silicone or Weatherseal Glazed (Type B); Screw Spline, Shear Block, Stick or Punched Opening Fabrication.
 - d. Trifab™ VG 451T Framing System – Impact Glazing and Blast Mitigation.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal. CSA A440 Fixed Rating.

3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 8 psf (383 Pa) as defined in AAMA 501.
4. Uniform Load: A static air design load of 35 psf (1680 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
5. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.
6. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
 - a. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 - b. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 - c. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $\epsilon = 0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

7. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Glass to Exterior – 0.47 (low-e) or 0.61 (clear) or Project Specific (____) BTU/hr/ft²/°F.
 - b. Glass to Center – 0.44 (low-e) or 0.61 (clear) or Project Specific (____) BTU/hr/ft²/°F.
 - c. Glass to Interior – 0.41 (low-e) or 0.56 (clear) or Project Specific (____) BTU/hr/ft²/°F.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Glass to Exterior – 70_{frame} and 69_{glass} (low-e) or 69_{frame} and 58_{glass} (clear).
 - b. Glass to Center – 62_{frame} and 68_{glass} (low-e) or 63_{frame} and 56_{glass} (clear).
 - c. Glass to Interior – 56_{frame} and 67_{glass} (low-e) or 54_{frame} and 58_{glass} (clear).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

9. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. Glass to Exterior – 38 (STC) and 31 (OITC).
 - b. Glass to Center – 37 (STC) and 30 (OITC).
 - c. Glass to Interior – 38 (STC) and 30 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following B options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.

5. Flashing and drainage.

G. Other Action Submittals:

1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. Structural-Sealant Glazing: Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.
- H. Structural-Sealant Joints: Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM AND GLASS ORIENTATION CENTER, EXTERIOR (FRONT), INTERIOR (BACK).

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Trifab™ VG 451 (Non-Thermal) or Trifab™ 451T (Thermal) Framing System
 3. Trifab™ VG 451 (Non-Thermal) or Trifab™ 451T (Thermal) Framing System (Impact Glazing and Blast Mitigation)
 4. System Dimensions: 2" x 4-1/2" (50.8 mm x 114.3 mm)
 5. Glass: Center, Exterior or Interior

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.

4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum framing members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier (Trifab™ VG 451T):
 1. Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black
 2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 - 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawings including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacturer of single-source for light shelf and framing system and compatibility between the system.
- C. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- D. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight framed aluminum storefront system installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 1. Types of Kawneer Aluminum Curtain Wall include.
 - a. 1600 Wall System™1 Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 1) System depth: 6" (152.4) or 7-1/2" (190.5) for 1" (25.4) insulating glazing and 1/4" (6.3) monolithic glazing.
 - b. 1600 Wall System™1 IR Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 2) System depth: 7-1/2" (190.5) depth for 9/16" (14.3) and 5/8" (15.9) monolithic glazing.
 - 3) System depth: 7-13/16" (198.4) or 10-13/16" (274.6) depth for 1-5/16" (33.3) insulating glazing.
 - c. 1600 Wall System™1 Curtain Wall Blast Mitigation – 2-1/2" (63.5) sightline, outside glazed pressure plate format.
 - 4) System depth: 7-1/2" (190.5) for 1" (25.4) insulating glazing.
 - d. 1600 Wall System™1 Ribbon Curtain Wall Blast Mitigation.
 - 5) System depth: 6" (152.4) for 1" (25.4) insulating glazing.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

1. 072700 "Air Barriers".
2. 079200 "Joint Sealants".
3. 083213 "Sliding Aluminum-Framed Glass Doors".
4. 084113 "Aluminum-Framed Entrances and Storefronts".
5. 084313 "Aluminum-Framed Storefronts".
6. 084329 "Sliding Storefronts".
7. 084433 "Sloped Glazing Assemblies".
8. 085113 "Aluminum Windows".
9. 086300 "Metal-Framed Skylights".
10. 088000 "Glazing".
11. 107113 "Exterior Sun Control Devices".
12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following.
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.

- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement (elastic) of 0.010 x the story height and ultimate displacement (inelastic) of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.66 (clear) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 66_{frame} and 60_{glass} (clear).

or

Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 68_{frame} and 54_{glass} (clear).

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR HIGH PERFORMANCE INSULATING GLASS, (1/4" (E=0.035,#2), 1/2" WARM EDGE SPACER AND ARGON GAS FILL, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- K. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.43 (HP glass) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- L. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 71_{frame} and 71_{glass} (HP glass).
- M. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than:
STC 31 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4"),
STC 37 or OITC 30 based upon 1" (25.4) laminated glass (1/4" laminated, 1/2" AS, 1/4" laminated).
- N. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
1. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
2. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
- O. Blast Mitigation performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- Section B-3.1.1 Dynamic analysis.
- Section B-3.1.2 Testing.
- Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following.
 - 1. Joinery.
 - 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - a. 1600 Wall System™1 Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 1) System depth: 6" (152.4) or 7-1/2" (190.5) for 1" (25.4) insulating glazing and 1/4" (6.3) monolithic glazing.
 - b. 1600 Wall System™1 IR Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 1) System depth: 7-1/2" (190.5) depth for 9/16" (14.3) and 5/8" (15.9) monolithic glazing.
 - 2) System depth: 7-13/16" (198.4) or 10-13/16" (274.6) depth for 1-5/16" (33.3) insulating glazing.
 - c. 1600 Wall System™1 Curtain Wall Blast Mitigation – 2-1/2" (63.5) sightline, outside glazed pressure plate format.
 - 1) System depth: 7-1/2" (190.5) for 1" (25.4) insulating glazing.
 - 2) Tested to AAMA 501, ASTM E 1886, E 1996 and TAS 201, 202, 203.
 - d. 1600 Wall System™1 Ribbon Curtain Wall Blast Mitigation.
 - 1) System depth: 6" (152.4) for 1" (25.4) insulating glazing.
 - 2) Tested to AAMA 501, ASTM E 1886, E 1996 and TAS 201, 202, 203.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following.
1. Manufacturer: (_____).
 2. Series: (_____).
 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" (6.3) separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1/4" (6.3), 9/16" (14.3), 5/8" (15.9) monolithic glass or 1" (25.4), 1-5/16" (33.3) insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600 Wall System™1 Curtain Wall.
 - a. System depth: 6" (152.4) or 7-1/2" (190.5) for 1" (25.4) insulating glazing and 1/4" (6.3) monolithic glazing.
 - 2. 1600 Wall System™1 IR Curtain Wall.
 - a. System depth: 7-1/2" (190.5) depth for 9/16" (14.3) and 5/8" (15.9) monolithic glazing.
 - b. System depth: 7-13/16" (198.4) or 10-13/16" (274.6) depth for 1-5/16" (33.3) insulating glazing.
 - 3. 1600 Wall System™1 Curtain Wall Blast Mitigation.
 - a. System depth: 7-1/2" (190.5) for 1" (25.4) insulating glazing.
 - 4. 1600 Wall System™1 Ribbon Curtain Wall Blast Mitigation.
 - a. System depth: 6" (152.4) for 1" (25.4) insulating glazing.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. 1600 PowerShade™ Sun Shade System: An aluminum sunshade consisting of strut anchors and strut arms and three louvers per bay with integral amorphous silicon (photovoltaic or P.V.) panels which produce nominal 45 watts of electrical generation per bay at peak performance. Optional aluminum panels are also available, if selected, in lieu of the P.V. panels. Strut anchors and strut arms shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- C. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- D. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of.
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system).
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 - 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including.
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics.
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION**3.1 Examination**

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements.
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.

- b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Thermally Broken Aluminum Entrances, glass and glazing, and door hardware and components.
 1. Types of Kawneer Thermally Broken Aluminum Entrances include:
 - a. AA™250 Thermal Entrance; Narrow stile, 2-1/2" (63.5 mm) vertical face dimension, 2-1/4" (57 mm) depth, moderate traffic applications.
 - b. AA™425 Thermal Entrance; Wide stile, 4-1/4" (108 mm) vertical face dimension, 2-1/4" (57 mm) depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084313 "Aluminum-Framed Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 087000 "Hardware"
 11. 088000 "Glazing"
 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance doors shall withstand the effects of the following performance requirements without exceeding performance criteria or failure due to defective manufacture, fabrication, installation, or other defects in construction:
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance

door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm per square foot.

3. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 for typical application or L/180 for Small-Missile and Large-Missile impact, of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
4. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.3 Standard 12 for exterior doors and Standard 10 for glazing and frame bite provisions, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
5. Forced Entry: Tested in accordance with AAMA 1304.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH e= 0.035 LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Insulated Glass – 0.43 (low-e) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per AAMA 507 per NFRC 100.
7. Solar Heat Gain Coefficient: Glazed thermally broken aluminum door and frame shall have a solar heat gain coefficient of no greater than (____) <Insert value> as determined according to NFRC 200.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Insulated Glass – 57_{frame} and 71_{glass} (low-e).
9. Condensation Resistance (I): When tested to CSA A440, the condensation resistance factor shall not be less than:
 - a. Insulated Glass – 48_{frame} and 69_{glass} (low-e).
10. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with ASTM E 90, the STC and OITC ratings shall not be less than:
 - a. 32 (STC) and 28 (OITC).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating thermally broken aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports and calculations.
- C. **Source Limitations:** Obtain thermally broken aluminum-framed door through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum-framed glass entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify actual dimensions of thermally broken aluminum-framed door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. The door stile and rail face dimensions of the [_____] (choose one: AA™250 or AA™425) Thermal Entrance will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
AA™250 Thermal Entrance	2-1/2" (63.5 mm)	2-1/2" (63.5 mm)	3-7/8" (99 mm)	10" (254 mm)
AA™425 Thermal Entrance	4-1/4" (108 mm)	4-1/4" (108 mm)	6-1/2" (166 mm)	10" (254 mm)
 - 3. Major portions of the door members to be 0.125" (4) nominal in thickness and glazing molding to be 0.05" (1.3 mm) thick
 - 4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
 - 5. Provide adjustable glass jacks to help center the glass in the door opening.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum entrance and storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum entrances and storefronts for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Slide-In-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing:
1. Trifab™ VG 451T
 2. Trifab™ 451UT
 3. Trifab™ 601/601T
 4. Thermally Broken entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware:
1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with two lines of weather-stripping utilizing wool pile with polymeric fin.

- b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing and a wool pile with polymeric fin.
 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 3. Threshold: Extruded aluminum, thermally broken, with ribbed surface.
 4. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
 5. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
 6. Continuous Hinge: [_____].
 7. Push/Pull: [_____] style.
 8. Exit Device: [_____].
 9. Closer: [_____].
 10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 11. Latch Handle: [_____].
 12. Cylinder(s)/Thumbturn: [_____].
 13. Electric Strike/Strike Keeper: [_____].
- C. Optional Hardware:

EDITOR NOTE: SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Adams Rite MS 1850A-505 Hookbolt Lock.
2. Mortise cylinder, interior or exterior.
3. Thumbturn, interior.
4. Flush pull.

2.6 Fabrication

- A. Fabricate thermally broken aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate thermally broken aluminum-framed doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1" (24 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufactures drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.

2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing thermally broken aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install thermally broken aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed door and storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ UT Windows (Structural Silicone Glazed)
 - b. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - c. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Performance Class and Grade:
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)
2. Air leakage: The test specimen shall be tested in accordance with ASTM E283. Air leakage rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.2 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.6 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa). The test specimen shall meet the B7 rating with no water leakage at 12 psf (575 Pa) when tested in accordance with CAN/CSA-A440-00 Windows;
4. Uniform Load Deflection: A minimum static air pressure difference [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C3, C4 or C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG70-C (with 3-Cam Handles); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-C (with 3-Cam handles); 90 psf (4309 Pa)
5. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.3% of span length.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 60 psf (2873 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 90 psf (4309 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 105 psf (5027 Pa)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-C (with 3-Cam Handles); 105 psf (5027 Pa)
6. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
 - a. Project-Out Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-AP (with 3-Cam handles); 135 psf (6464 Pa)

- b. Outswing Casement Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-C (with 3-Cam handles); 135 psf (6464 Pa)
- 7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
- 8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass:
 - 1) Project-Out: U-Factor not more than .56 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) clear glass, aluminum spacer, and interior 3/16" (4.76 mm) glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- b. 1-3/4" insulating glass:
 - 1) Project-Out and Outswing Casement: U-Factor not more than .23 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- 9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - i. Project-Out: CRF not less than 73 (frame) and 60 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: CRF not less than 80 (frame) and 82 (glass).
 - 2) Project-Out: CRF not less than 81 (frame) and 83 (glass).
- 10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - 1) Project-Out: (I) not less than 68 (frame) and 61 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: (I) not less than 70 (frame) and 73 (glass).
 - 2) Project-Out: (I) not less than 75 (frame) and 81 (glass).
- 11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass made with exterior 3/16" (4.76 mm) clear glass, 3/8" (9.52 mm) aluminum spacer, and interior 7/16" (11.11 mm) laminated clear glass:
 - 1) Project-Out: STC not less than 37; OITC not less than 30.
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 9/16" (14.29 mm) clear laminated glass, 7/8" (22.2 mm) aluminum spacer, and interior 5/16" (7.94 mm) clear laminated glass:
 - 1) Outswing Casement: STC not less than 41; OITC not less than 34.
- 12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
- 13. Blast Mitigation performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
- b. Section B-3.1.2 Testing
- c. Section B-3.1.3 ASTM F2248 Design Approach
- 14. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
- b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. GLASSvent™ UT Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 - a. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP
 - ii. CW-PG60-AP
 - iii. CW-PG70-AP
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP
 - ii. AW-PG90-AP
 - b. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C
 - ii. CW-PG70-C
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C

ii. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ UT Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.
- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
 - 1. Stainless Steel 4-Bar Hinges
 - 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- 3. Cast white Bronze Cam Handle with Pole Ring
- 4. Cast White Bronze Access Control (Custodial) Locks with Removable Handle

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T5 or 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.2 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 1600 SS Curtain Wall System - 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed pressure plate or structural silicone glazed (SSG) format.
 - b. 1600 SS Curtain Wall System Blast Mitigation - 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed pressure plate or tape glazed format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 107113 "Exterior Sun Control Devices"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): The thermal transmittance (U-factor) shall not be more than:
 1. Captured - 0.65 (clear) when tested to AAMA 1503
 2. SSG - 0.58 (clear) when tested to AAMA 1503,
 or
 Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 1. Captured - 68_{frame} and 60_{glass} (clear),
 2. SSG - 72_{frame} and 62_{glass} (clear),
 or
 Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
 1. Captured - 61_{frame} and 51_{glass} (clear).
 2. SSG - 64_{frame} and 54_{glass} (clear).
- K. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than:
 Captured - STC 31 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4"),
 SSG - STC 32 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4").
- L. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria. To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 1. Section B-3.1.1 Dynamic analysis
 2. Section B-3.1.2 Testing
 3. Section B-3.1.3 ASTM F2248 Design Approach

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1600 SS Curtain Wall.
 - 3. Frame depth options: 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed captured or structural silicone glazed (SSG) format.
 - 4. 1600 SS Curtain Wall Blast Mitigation
 - 5. Frame depth options: 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed captured or tape glazed format.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
1. 1600 SS Curtain Wall: Outside glazed format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.

- a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 - GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall units.
1. Types of Kawneer Curtain Wall and Glazed Assemblies include:
 - a. 1630 SS IR Curtain Wall System: (Hurricane Impact and Blast Mitigation) - 3" x 7-13/16" (76.2 x 198.4) or 8-13/16" (76.2 x 223.8), outside glazed pressure plate format, with 1-5/16" (33.3) laminated insulating glass.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY CONTROL.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Structural-Test Performance: Test according to ASTM E 330 and TAS 202 as follows:
1. When tested at positive and negative wind load design pressures, assemblies do not evidence deflection exceeding L/180 of clear span.
 2. A static air design load of 130 psf (6224.4 Pa) shall be applied in the positive and negative direction.

- a. When tested at 150% of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2% percent of clear span.
 - b. Minimum test duration according to TAS 202 is 30 seconds.
- E. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Normal to Wall Plane: Limited to edge of glass in a direction perpendicular to glass plane not exceeding L/180 of the glass edge length for each individual glazing lite, or an amount that restricts edge deflection of individual glazing lites to 3/4 inch (19 mm), whichever is less. Limit deflection of clear span of framing members to L/180 for spans less than or equal to 13'-6" (4.11 meters) and L/240 + 1/4" for spans greater than 13'-6" (4.11 meters).
 2. Deflection Parallel to Glazing Plane: Limited to [L/360 of clear span or 1/8" (3.2 mm), whichever is smaller] [amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8" (3.2 mm)].
 - a. Operable Units: Provide a minimum 1/16" (1.6 mm) clearance between framing members and operable units.
 3. Cantilever Deflection: Where framing members overhang an anchor point, limit deflection to two times the length of cantilevered member, divided by 175.
- F. Water Penetration under Static Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to ASTM E 331 and TAS 202 at 15psf (720 Pa).
- G. Water Penetration under Dynamic Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to AAMA 501.1 at dynamic pressure equal to 15psf (720 Pa).
1. Maximum Water Leakage: [According to AAMA 501.1] [No uncontrolled water penetrating assemblies or water appearing on assemblies' normally exposed interior surfaces from sources other than condensation]. Water leakage does not include water controlled by flashing and gutters that is drained to exterior.
- H. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)].
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.
- I. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
1. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 2. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
- J. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria. To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
1. Section B-3.1.1 Dynamic analysis
 2. Section B-3.1.2 Testing
 3. Section B-3.1.3 ASTM F2248 Design Approach
- K. Energy Performance: Glazed aluminum curtain walls shall be tested in accordance with NFRC and AAMA Standards.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" OR 1-3/4" CLEAR HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E, ARGON FILLED, WITH WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

1. Thermal Transmittance (U-factor):
 - a. 1630 SS IR Curtain Wall System:
 - 1) Glass and framing areas shall have U-factor of no greater than 0.44 with 1-5/16" (33.3) High Performance (HP) Glass as determined according to AAMA 1503 or Project specific (___) BTU/Hr/Ft²/°F per AAMA 507 or (___) BTU/Hr/Ft²/°F per NFRC 100.
 2. Solar Heat Gain Coefficient: Glass and framing areas shall have a solar heat gain coefficient of no greater than [0.20] [0.25] [0.30] <Insert value> as determined according to NFRC 200.
 3. Air Infiltration: Maximum air leakage through fixed glazing and framing areas of 0.06 cfm/sq.ft. (0.31 l/s.m²) of fixed wall area as determined according to ASTM E 283 and TAS 202 at a minimum static-air-pressure differential of 6.24 psf (300 Pa).
 4. Condensation Resistance: When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 1630 SS IR:
 - 1) CRF_{glass} (1-5/16" 1G HP) = 70, CRF_{frame} = 74
 5. Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
 - a. 1630 SS IR aluminum pressure plate:
 - 1) I_{glass} (1-5/16" 1G HP) = 63, I_{frame} = 67
- L. Sound Transmission: Provide glazed aluminum curtain walls with fixed glazing and framing areas having the following sound-transmission characteristics:
1. 1630 SS IR:
 - a. (STC = 37) or (OITC = 32) when tested for laboratory sound transmission loss according to AAMA 1801, ASTM E 90 and ASTM E 1425, and based on 1-5/16" (33.3) laminated insulating glass (1/4", 1/2" AS, 1/4").

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery
 - 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR'S NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1630 SS IR Curtain Wall System: 3" (76.2) sightline.
 - 3. Frame depth options:
 - a. Hurricane Impact and Blast Mitigation: 7-13/16" and 8-13/16" with 1-5/16" (33.3) Laminated Insulating Glass.
 - 4. Tested to AAMA 501-05 and ASTM E 1886, E 1996 and TAS 201, 202, 203.

EDITOR'S NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal barrier consists of 9/16" (14.25 mm) separation between the interior and exterior metal members in a typical condition.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1-5/16" (33.3) laminated insulating glass for vision and Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1630 SS IR Curtain Wall: Outside glazed pressure plate format with 1-5/16" (33.3) laminated insulating glass.
 - 2. 1630 SS IR Curtain Wall Blast Mitigation: Outside glazed pressure plate format with 1" laminated insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using screw spline system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
1. Comply with manufacturer's written instructions.
 2. Do not install damaged components.
 3. Fit joints to produce hairline joints free of burrs and distortion.
 4. Rigidly secure non-movement joints.
 5. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 6. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 7. Seal joints watertight unless otherwise indicated.
- B. Metal Protection:
1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- D. Install components plumb and true in alignment with established lines and grades.
- E. Install operable units level and plumb, securely anchored, and without distortion. Adjust weather-stripping contact and hardware movement to produce proper operation.
- F. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- G. Install glazing as specified in Division 08 Section "Glazing."

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 10 psf (479 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Aluminum Entrances include:
 - a. 350 Heavy Wall™ Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - b. 500 Heavy Wall™ Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - c. 350 Heavy Wall™ IR Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - d. 500 Heavy Wall™ IR Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084313 "Aluminum-Framed Storefronts"
 - 5. 084329 "Sliding Storefronts"
 - 6. 084413 "Glazed Aluminum Curtain Walls"
 - 7. 084433 "Sloped Glazing Assemblies"
 - 8. 085113 "Aluminum Windows"
 - 9. 086300 "Metal-Framed Skylights"
 - 10. 087000 "Hardware"
 - 11. 088000 "Glazing"
 - 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction:
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide aluminum-framed entrance door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for single doors and for pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].
4. Uniform Load: A static air design load of 85 psf (4070 Pa), (65 psf (3113 Pa) for laminated infill) shall be applied in the positive and negative direction in accordance with Florida Building Code TAS202 and ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage shall occur.
5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
7. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.

1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of aluminum-framed entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:

1. Kawneer Company Inc.
2. The door stile and rail face dimensions of the [_____] (choose from below) entrance door will be as follows

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
350 Heavy Wall™	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 Heavy Wall™	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)
350 Heavy Wall™ IR	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 Heavy Wall™ IR	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)

3. Major portions of the door members to be 0.188" (5 mm) nominal in thickness and glazing molding to be 0.05" (1.5 mm) thick.
4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
5. (350/500 Heavy Wall™) Provide adjustable glass jacks to help center the glass in the door opening.
6. (350/500 Heavy Wall™ IR) Structural silicone sealant to be DOW 995 or Tremco Proglaze SSG.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
2. Series: (_____)
3. Profile dimension: (_____)
4. Performance Grade: (_____)

- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed entrance door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing:
 - 1. Trifab™ 450/451/451T
 - 2. Trifab™ 601/601T
 - 3. IR 500/501
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle aluminum-framed entrance door material and components to avoid damage. Protect aluminum-framed entrance door material against damage from elements, construction activities, and other hazards before, during and after aluminum-framed entrance door installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
 - 1. 350/500 Heavy Wall IR: 9/16" (14.3 mm) laminated infill with 0.090" (3 mm) PVB interlayer.
 - 2. 350/500 Heavy Wall IR: 9/16" (14.3 mm) laminated infill with Solutia Vanceva 0.075" (2 mm) interlayer, Dupont SG 0.090" (3 mm) interlayer.
 - 3. 350/500 Heavy Wall IR: 0.090" (3 mm) PVB interlayer, Dupont SG 0.090" (3 mm) interlayer.
 - 4. 350/500 Heavy Wall IR BLAST: 9/16" (14.3 mm) laminated infill with 0.090" (3 mm) PVB interlayer.
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware (350/500 Heavy Wall™):
 - 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).

3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
4. Offset Pivots: [_____].
5. Butt Hinge: [_____].
6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: [_____].
9. Closer: [_____].
10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
11. Latch Handle: [_____].
12. Cylinder(s)/Thumbturn: [_____].
13. Electric Strike/Strike Keeper: [_____].

C. Standard Hardware (350/500 Heavy Wall™ IR):

1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
4. Offset Pivots: [_____].
5. Butt Hinge: [_____].
6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: [_____].
 - a. Concealed Rod Device; Kawneer 1686, Jackson 2086, Paneline™, Falcon HH1690, Von Duprin 9947HH.
 - b. Rim Exit Device; Von Duprin 98/99.
9. Closer: [_____].
10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
11. Latch Handle: [_____].
12. Cylinder(s)/Thumbturn: [_____].
13. Electric Strike/Strike Keeper: [_____].

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ EL CONCEALED ROD EXIT DEVICE OR OTHER ELECTRONIC SECURITY ITEMS.

D. Access Control Entrance Hardware:

1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
3. Proximity Cards.
4. Exit Device: Kawneer Paneline™ EL.
5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
6. Power supply for Electric Strike: Altronix AL UL 175.
7. Power Transfer [_____]. One per EL Exit Device required for access control:
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
8. Interior push button release.
9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed entrance doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.

- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrances. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Aluminum Entrances include.
 - a. 350 IR Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 1-3/4" (44.5) mm depth, high traffic applications.
 - b. 500 IR Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 1-3/4" (44.5) mm depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections.
 - 1. 072700 "Air Barriers".
 - 2. 079200 "Joint Sealants".
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors".
 - 4. 084313 "Aluminum-Framed Storefronts".
 - 5. 084329 "Sliding Storefronts".
 - 6. 084413 "Glazed Aluminum Curtain Walls".
 - 7. 084433 "Sloped Glazing Assemblies".
 - 8. 085113 "Aluminum Windows".
 - 9. 086300 "Metal-Framed Skylights".
 - 10. 087000 "Hardware".
 - 11. 088000 "Glazing".
 - 12. 280000 "Electronic Safety and Security".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum Framed Entrance Performance Requirements.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for single doors and pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].
4. Uniform Load: A static air design load of 85 psf (4070 Pa), (65 psf (3113 Pa) for laminated infill) shall be applied in the positive and negative direction in accordance with Florida Building Code TAS202 and ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage shall occur.
5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.3 Standard 12 for Exterior Doors and Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis.
 - b. Section B-3.1.2 Testing.
 - c. Section B-3.1.3 ASTM F2248 Design Approach.
7. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance doors and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following.
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals.
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - 2. The door stile and rail face dimensions of the 350IR/500IR entrance door will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
350 IR	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 IR	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)
 - 3. Major portions of the door members to be 0.125" (4) nominal in thickness and glazing molding to be 0.05" (1.5) thick.
 - 4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
 - 5. Structural silicone sealant to be Dow Corning 983, 995 or Tremco Proglaze SSG.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following.
 - 1. Manufacturer: (_____).
 - 2. Series: (_____).
 - 3. Profile dimension: (_____).
 - 4. Performance Grade: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" wall thickness at any location for the main frame and door leaf members.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing.
 - 1. Trifab™ VG 450/451/451T.
 - 2. IR500/501.
 - 3. IR501UT/IR501T.
 - 4. Trifab™ 601/601T.
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after aluminum-framed entrance door installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glass.
 - 1. 9/16" laminated infill with .090" (3) PVB interlayer.
 - 2. 9/16" laminated infill with Solutia Vanceva .075" (2) interlayer, Dupont SGP .090" (3) interlayer.
- C. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- D. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware.
 - 1. Weather-stripping.
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 - 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 - 4. Offset Pivots: [_____].
 - 5. Butt Hinge: [_____].

6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: Kawneer 1686 Concealed Rod Exit Device, Paneline™ Concealed Rod Exit Device, Adams Rite G86 Concealed Rod Exit Device, Calibre 9100 Concealed Rod Exit Device, Falcon HH1690 Concealed Rod Exit Device, Jackson 2080 Concealed Rod Exit Device, Sargent 8400AD Concealed Rod Exit Device or Von Duprin HH9947 Concealed Rod Exit Device.
9. Closer: Surface or concealed closer (concealed closer with non-transom and non-sidelite Trifab™ VG 450 (Center) and 1600 Wall sub-frames only).
10. Security Lock/Dead Lock: MS 1850A lock with 3-point active stile locking and hurricane flushbolts on pairs, Adams Rite 2180 2-Point Dead Lock or MS 1850A with 1871 cylinder operated flushbolts.
11. Cylinder(s)/Thumbturn: Kawneer standard.
12. Cylinder Guard: Kawneer standard.

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ EL CONCEALED ROD EXIT DEVICE OR OTHER ELECTRONIC SECURITY ITEMS.

C. Access Control Entrance Hardware.

1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
3. Proximity Cards.
4. Exit Device: Kawneer Paneline™ EL.
5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
6. Power supply for Electric Strike: Altronix AL UL 175.
7. Power Transfer [_____]. One per EL Exit Device required for access control.
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
8. Interior push button release.
9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed glass entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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PART 3 - EXECUTION**3.1 Examination**

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrance doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8430TL Single Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG70-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG70-H

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .51 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 55) (Glass = 62).

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
 To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.
13. Sound: Testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (34 STC) and (29 OITC).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8430TL Single Hung Window
 - 4. 4" (101.6 mm) frame depth
 - 5. AW-PG70-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 1/4" (6.35 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window System

- A. Series 8400TL Thermal Windows - Single Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8450TL Double Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. H-HC70 / H-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: H-HC70
 - b. Performance Class and Grade: H-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 51) (Glass = 63) .
8. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .52 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Sound: testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (33 STC) and (29 OITC).
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8400TL Thermal Windows
 3. Model 8450TL Double Hung Window
 4. 4" (101.6 mm) frame depth
 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Double Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom and top sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
6. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8410TL Fixed Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 60" x 99" (1524 x 2515 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 60" x 99" (1524 x 2515 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .48 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503 with 1" (25,4 mm) insulating clear glass, the condensation resistance factor shall not be less than (CRF_f 67) frame and (CRF_g 66) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Sound Performance: When tested in accordance with ASTM E 90 and E 413, the sound transmission loss (STL) shall not be less than 39.
10. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8410TL Fixed Window
 - 4. 4" (101.6 mm) frame depth
 - 5. AW-PG100FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Fixed Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- C. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and mechanically clipped and/or staked, factory sealed frame and vent corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8470TL Horizontal Sliding Window
 - c. 4" (101.6 mm) frame depth
 - d. HS-HC70 / HS-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: HS-HC70
 - b. Performance Class and Grade: HS-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 96" x 80" (2438 x 2032 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 PA).

3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 96" x 80" (2438 x 2032 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Temperature Index Test: (CRF) when tested in accordance with CAN/CSA A440, the Temperature Index shall not be less than (CRF_f 38.2) frame and (CRF_g 61.2) glass
8. Thermal Transmittance Test: (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .55 BTU/hr/sf/°F or () BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test: (CRF) when tested in accordance with AAMA 1503, the condensation resistance factor shall not be less than (CRF_f 50) frame and (CRF_g 61) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound: Testing per ASTM 1801 with 1" insulating glass made with (1/4" annealed exterior with, 1/2" airspace, 1/4" annealed interior): minimum (34 STC) and (29 OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems..

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8470TL Horizontal Sliding Window
 - 4. 4" (101.6 mm) frame depth
 - 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Window - Horizontal Sliding Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Continuous Integral Pulls
2. Stainless Steel Ball Bearing Rollers
3. Stainless Steel Roller Track
4. Plunger Lock

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints.

- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar material to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.

- b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. This Section includes Kawneer Flushline™ Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Flushline™ Entrances include:
 - a. Flushline™ Entrance; urethane foam-filled door, flush face design, high traffic and high abuse.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084313 "Aluminum-Framed Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"
12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed flush entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283.
3. Uniform Load: The test specimen shall be tested in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
4. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Aluminum-Framed Flush Entrance Doors with glass lites – with Aluminum Panel = 0.82 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.

- b. Aluminum-Framed Flush Entrance Doors with glass lites – with FRP Panel = 0.66 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
5. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F2927, ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
- To meet UFC 04-010-01, B-3.3 Standard 12 for exterior doors and Standard 10 for glazing and frame bite provisions, the following options are available:
- a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
6. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed flush entrance doors indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed flush entrance doors and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 - 1. Joinery, including welds.
 - 2. Flush face panel.
- G. Other Action Submittals:
 - 1. Aluminum-Framed Flush Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed flush entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports and calculations.
- C. Source Limitations: Obtain aluminum-framed flush entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed flush entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed flush entrance doors openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE FACE SHEET TYPE (FRP OR ALUMINUM) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. The door stile and rail face dimensions of the Flushline™ Entrance door will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail
Flushline™	5" (127 mm)	5" (127 mm)	5" (127 mm)
 3. The door face sheet shall be () (specify one of the following).
 - a. Pebble textured fiberglass reinforced polyester (FRP) 0.090" (2.3 mm).
 - b. Architectural quality aluminum sheet 0.090" (2.3 mm) thick (specify: embossed or plain unpatterned).
 4. Vision lites, if required:
 - a. Aluminum-framed vision lite (AVL)
 5. Glass for vision lites to be () (specify 1/4" (6.4 mm), 1" (25.4 mm) insulated clear tempered glass or 1" (25.4 mm) impact glass).
 6. Vision lite glazing shall be with foam glazing tape.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: ()
 2. Series: ()
 3. Profile dimension: ()
 4. Performance Grade: ()
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed flush entrance and storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum entrances and storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed flush door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Aluminum-Framed Flush Entrance Door Core: Shall be urethane foam injected at 2.5 lb./cu.ft. density and shall have "0" O.D.P. = "Zero" Ozone Depletion Potential and contains no Chlorofluorocarbons (CFC's) or Hydro chlorofluorocarbons (HCFC's).
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed flush entrance door members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing Non-Thermal (Trifab™ VG 450, Trifab™ VG 451 or Trifab™ 601)
- B. Storefront Entrance Framing Thermal (Trifab™ 451UT or Trifab™ 601T/601UT)
1. Thermally Broken Entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density urethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- C. Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- E. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- F. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- G. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed flush entrance doors.
- B. Standard Hardware:
 - 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (necessary to meet specified performance tests).
 - 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 - 4. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
 - 5. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
 - 6. Continuous Hinge: [_____].
 - 7. Push/Pull: [_____] style.
 - 8. Exit Device: [_____].
 - 9. Closer: [_____].
 - 10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 - 11. Latch Handle: [_____].
 - 12. Cylinder(s)/Thumbturn: [_____].
 - 13. Electric Strike/Strike Keeper: [_____].

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ CONCEALED ROD EXIT DEVICE OR OTHER ELECTORIC SECURITY ITEMS.

- C. Access Control Entrance Hardware
 - 1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
 - 2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
 - 3. Proximity Cards.
 - 4. Exit Device: Kawneer Paneline™ EL.
 - 5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
 - 6. Power supply for Electric Strike: Altronix AL UL 175.
 - 7. Power Transfer [_____]. One per EL Exit Device required for access control:
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
 - 8. Interior push button release.
 - 9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed flush entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed flush entrance doors that are reglazable, when vision lites are used, without dismantling perimeter framing.
 - 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners.
 - 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.

3. Face sheets shall lap and interlock with stile and rails to create a hollow cavity for the froth-in-place urethane core.
 4. Prepare components with internal reinforcement for door hardware.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
- Kawneer Permanodic™ AA-M10C21A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - Kawneer Permanodic™ AA-M10C21A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - Other: Manufacturer _____ Type _____ Color _____.
- C. Face Sheets:
1. Pebble texture (FRP) fiberglass reinforced polyester (Color _____) (select from list)
Beige, Dark Bronze, Light Grey and White.
 2. Kawneer Aluminum (select one of the finishes previously stated for exposed aluminum from above).

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed flush entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed flush entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed flush entrance doors and storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ Windows (Structural Silicone Glazed)
 - b. Project-Out and Outswing Casement Windows
 - c. 2-11/16" (68.3 mm) system depth (1/4" Infill), 3-7/16" (87.3 mm) system depth (1" Infill)
 - d. AW-PG90-AP/AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 078466 "Fire-Resistant Joint systems"
 3. 079200 "Joint Sealants"
 4. 083213 "Sliding Aluminum-Framed Glass Doors"
 5. 084113 "Aluminum-Framed Entrances and Windows"
 6. 084313 "Aluminum-Framed Windows"
 7. 084329 "Sliding Windows"
 8. 084413 "Glazed Aluminum Curtain Walls"
 9. 084433 "Sloped Glazing Assemblies"
 10. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-AP/AW-PG90-C
2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914) Project-Out or 36" x 60" (914 x 1524) Casement Outswing. Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914) Project-Out or 36" x 60" (914 x 1524) Casement Outswing. There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of $L/175$ of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6464 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
7. Thermal testing per AAMA 1503 within 1600 Wall System™1, at the prescribed 59" x 24" (1500 x 600) test size glazed using a single lite of 1" insulating glass composed of 1/4" clear low-E .035 #2, 1/2" air space with warm edge spacer, 1/4" clear with the following results:
 - a. Condensation Resistance Factor: Minimum (51 frame) and (63 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.72 BTU/hr/ft²/°F U-value

or

Thermal Transmittance Test: (U-Factor): The conductive thermal transmittance (U-Factor) shall not be more than (____) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

8. Sound: Testing per ASTM E 90 glazed with 1" insulating glass made with exterior 1/4" laminated glass x 1/2" air space x interior 1/4" laminated glass: Minimum (31 STC) and (26 OITC).
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Blast Mitigation performance: Tested per ASTM F 1642, GSA-TS01, and UFC 04-010-01 at a peak pressure of 6 psi and a 41 psi-msec impulse. The system shall achieve a minimum "Low Hazard" rating per ASTM F1642-04, a "Performance Condition 3b" per GSA and a "Low Level of Protection" per UFC 4-010-01 (Project-Out only).

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
- b. Section B-3.1.2 Testing
- c. Section B-3.1.3 ASTM F2248 Design Approach

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. GLASSvent™ Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 3. 2-11/16" (68.3 mm) system depth (1/4" Infill), 3-7/16" (87.3 mm) system depth (1" Infill)
 4. AW-PG90-AP/AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.
- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
 1. 4-Bar Hinges
 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

3. Stainless Steel 4-Bar Hinges
4. Cast white Bronze Cam Handle with Pole Ring
5. Cast White Bronze Access Control (Custodial) Locks with Removable Handle
6. Cast White Bronze Concealed Lock and Key

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION**3.1 Examination**

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
 - 1. Types of Kawneer Aluminum Storefront Systems include.
 - a. IR 500 Framing – 2-1/2" x 5" (63.5 mm x 127 mm) nominal dimension; Non-Thermal; Center Plane for 9/16" (14.3 mm) Impact Resistant Glazing, Screw Spline Fabrication.
 - b. IR 501 Framing – 2-1/2" x 5" (63.5 mm x 127 mm) nominal dimension; Non-Thermal; Center Plane for 1-5/16" (33.4 mm) Impact Resistant Glazing, Screw Spline Fabrication.
 - c. IR 501 Framing – 2-1/2" x 5" (63.5 mm x 127 mm) nominal dimension; Non-Thermal; Center Plane for 1-5/16" (33.4 mm) Blast Mitigation Glazing, Screw Spline Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

- 1. 072700 "Air Barriers".
- 2. 079200 "Joint Sealants".
- 3. 083213 "Sliding Aluminum-Framed Glass Doors".
- 4. 084113 "Aluminum-Framed Entrances and Storefronts".
- 5. 084329 "Sliding Storefronts".
- 6. 084413 "Glazed Aluminum Curtain Walls".
- 7. 084433 "Sloped Glazing Assemblies".
- 8. 085113 "Aluminum Windows".
- 9. 086300 "Metal-Framed Skylights".
- 10. 088000 "Glazing".
- 11. 107113 "Exterior Sun Control Devices".
- 12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal.
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.

4. Uniform Load: A static air design load of 65 psf (3112 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.4% of their clear spans shall occur.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-frame storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following.
 1. Joinery.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.
- G. Other Action Submittals.
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. Structural-Sealant Glazing: Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.

- H. Structural-Sealant Joints: Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE IR 500 OR IR 501 FRAMING

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - 2. IR 500 Framing (Non-Thermal).
 - 3. IR 501 Framing (Non-Thermal).
 - 4. IR 501 Framing (Non-Thermal) - Blast Mitigation.
 - 5. System Dimensions: 2-1/2" x 5" (63.5 mm x 127 mm).
 - 6. Glass: Center Plane.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following.
 - 1. Manufacturer: (_____).
 - 2. Series: (_____).
 - 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Storefront Framing System

- A. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposes shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black.
 2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of.
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be. (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including.
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

- B. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- C. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics.
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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END OF SECTION 084113

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1.1 Related Documents

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1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
 - 1. Types of Kawneer Aluminum Storefront Systems include:
 - a. IR 501T/IR 501UT Framing – 2-3/4" x 5" (69.8 mm x 127 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.
 - b. IR 501T/IR 501UT Framing – Impact Glazing
 - c. IR 501T/IR 501UT Framing – Blast Mitigation

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084329 "Sliding Storefronts"
 - 6. 084413 "Glazed Aluminum Curtain Walls"
 - 7. 084433 "Sloped Glazing Assemblies"
 - 8. 085113 "Aluminum Windows"
 - 9. 086300 "Metal-Framed Skylights"
 - 10. 088000 "Glazing"
 - 11. 107113 "Exterior Sun Control Devices"
 - 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal.
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (720 Pa) as defined in AAMA 501.

4. Uniform Load: A static air design load of 30 psf (1436 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
5. Thermal Transmittance (U-Factor): When tested to AAMA specification 507 or NFRC100 the thermal transmittance (U-Factor) shall not be more than:

IR 501T:

 - a. (With 2-Piece Mullion) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.57 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 - b. (With 3-Piece Mullion) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.24 to 0.55 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
6. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW.

IR 501UT:

- a. 1" insulating glass:
 - i. U-Factor not more than .33 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" clear with e=0.035 low-e coating on surface #2, 1/2" air space with warm edge spacer and 90% argon gas fill, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

IR 501T:

- b. 1" insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:

IR 501UT:

- a. 68_{frame} and 70_{glass} (low-e).

8. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

IR 501UT:

- a. 59_{frame} and 65_{glass} (low-e).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

9. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:

IR 501UT:

- a. 38 (STC) and 33 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, b-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery, including concealed welds.
 - 2. Anchorage.
 - 3. Expansion provisions.
 - 4. Glazing.
 - 5. Flashing and drainage.
- G. Other Action Submittals:
 - 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. IR 501T/IR 501UT Framing
 - 3. IR 501T/IR 501UT Framing – Impact Glazing
 - 4. IR 501T/IR 501UT Framing – Blast Mitigation
 - 5. System Dimensions: 2-3/4" x 5" (69.8 mm x 127 mm)
 - 6. Glass: Center Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier:
 1. IR 501UT - Kawneer DUAL IsoLock™ Thermal Break with two (2) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
 2. IR 501T - Kawneer SINGLE IsoLock™ Thermal Break with one (1) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black

2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
3. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacturer of single-source for light shelf and framing system and compatibility between the system.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- E. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-3500 Windows
 - b. Project-Out Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG80-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTORS AND CFR.

8. U-Factor Simulation: thermal computer simulation per NFRC 100, at the prescribed 59" x 24" (1498 x 610) Non-Residential Size, glazed with 1" insulating glass made with exterior 1/4" Solarban 60, thermoplastic butyl spacer, argon gas, and interior 1/4" clear glass: Thermal Transmittance to be not less than 0.41 BTU/HR/SQ.FT/°F - U-Factor.
9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Sound: Testing per ASTM E90 with 1" insulating glass made with 1/8" – air – 1/4" glass: Minimum (34 STC).
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series NX-3500 Windows - Project-Out
 - 3. 3-1/4" (83 mm) frame depth
 - 4. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-3500 Windows - Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles and Strikes
 - b. Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

2.6 Accesories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with steel spring clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.

- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.

2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Fixed Window
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-FW.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .19 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
(CRF_f) frame not less than 78.
(CRF_g) glass not less than 82.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass:
Temperature Index (I_f) frame not less than 67.
Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.

- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Fixed
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 5/8" (15.9 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.

2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Inswing or Outswing Casement Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).

5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade (Outswing Casement only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Outswing Casement only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass: 33 (STC) and 26 (OITC).

- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...

Enter the following for an AAMA 2605 70% fluoropolymer paint finish

- 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.4) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**

4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
6. Coating: **consult your Kawneer representative**

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 3. Patterns: grid patterns to be designated by architect.
 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 3. Interior: (two-piece snap trim;) (stool cover).
 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access **Enter wicket color choice: white, bronze, or black** wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.)

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800-07, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Project-Out only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 33 (STC) and 26 (OITC).
 - b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...
Enter the following for an AAMA 2605 70% fluoropolymer paint finish
 - 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.5) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
 1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].

- c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
- 6. Coating: *consult your Kawneer representative*

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 - 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 - 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 - 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 - 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 - 3. Patterns: grid patterns to be designated by architect.
 - 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 - 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 - 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 - 3. Interior: (two-piece snap trim;) (stool cover).
 - 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access *Enter wicket color choice: white, bronze, or black* wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.

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6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
 - C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
 - D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
 - E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
 - F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
 - G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
 - H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
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 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9100 Windows
 - b. Single Hung Side Load Window
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG50-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG50-H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 50 psf (2400 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 75 psf (3600 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CRF.

8. Thermal Test: Per AAMA 1503, at the prescribed 48" x 72" (1219 x 1829) test size glazed with 1" insulating glass made with 1/4" , argon gas, and 1/4" glass with low E coating:
 - a. Condensation Resistance Factor: Minimum (56 frame) and (62 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.51 BTU/HR/SQ.FT/°F.
9. U-Factor Simulation: Per NFRC 100, at the prescribed 48" x 72" (1219 x 1829) Non-Residential Size, glazed with 1" insulating glass made with exterior 1/4" , argon gas, and interior 1/4" glass with low E coating:
 - a. Thermal Transmittance to be maximum 0.51 BTU/HR/SQ.FT/°F.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
 13. Sound Test: Testing per ASTM E90 with 1" insulating glass made with exterior 1/4" laminated glass - 1/8" glass x .060 PVB interlayer x 1/8" glass - and interior 3/16" clear glass: Minimum (36 STC) and (31 OITC).
 14. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.

- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series TR-9100 Windows - Single Hung Side Load
 - 3. 3-1/4" (82.5 mm) frame depth
 - 4. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.062" (1.57 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9100 Windows - Single Hung Side Load

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Typical Hardware:
 - a. Aluminum Automatic Sill Locks
 - b. (Optional) White Bronze Automatic Sill Locks
 - c. (Optional) White Bronze Pole Ring on meeting rail
 - d. (Optional) Keyed plunger Limit Lock (Specify clear opening or travel distance in inches, e.g. 6")

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 - 1. True muntins.
 - 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in exterior applied PVC rigid tracks with two stainless steel leaf springs; 7/16" x 1-1/4" x .045 extruded tubular aluminum frame with window finish; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh secured to frame with PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.

- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:

1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ 451UT Framing – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.
 - b. Trifab™ 451UT Framing – Blast Mitigation, 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal. CSA A440 Fixed Rating.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 10 psf (479 Pa) as defined in AAMA 501.
4. Uniform Load: A static air design load of 30 psf (1436 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

5. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.
6. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
 - a. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 - b. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 - c. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $\epsilon = 0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

7. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. 0.32 (low-e) or Project Specific (____) BTU/hr/ft²/°F.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 68_{frame} and 68_{glass} (low-e).
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 - a. 60_{frame} and 62_{glass} (low-e).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

10. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. 37 (STC) and 30 (OITC).

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.

- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Trifab™ 451UT Framing (Thermal)
 - 3. Trifab™ 451UT Framing (Thermal) - Blast Mitigation
 - 4. System Dimensions: 2" x 4-1/2" (50.8 mm x 114.3 mm)
 - 5. Glass: Center Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier (Trifab™ 451UT):
 - 1. Kawneer DUAL IsoLock™ Thermal Break with two (2) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
 - 1)
- B. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type, and as follows:
 - 1. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)

- a. Curtain Wall framing system.
- b. Storefront framing system.
- 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.
- C. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- D. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.

- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM.

1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ VG 451 Framing System – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Non-Thermal; Front, Center, Back, Multi-Plane, Structural Silicone or Weatherseal Glazed (Type B); Screw Spline, Shear Block, Stick or Punched Opening Fabrication.
 - b. Trifab™ VG 451 Framing System – Impact Glazing and Blast Mitigation.
 - c. Trifab™ VG 451T Framing System – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Thermal; Front, Center, Back, Multi-Plane, Structural Silicone or Weatherseal Glazed (Type B); Screw Spline, Shear Block, Stick or Punched Opening Fabrication.
 - d. Trifab™ VG 451T Framing System – Impact Glazing and Blast Mitigation.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 088000 "Glazing"
 11. 107113 "Exterior Sun Control Devices"
 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal. CSA A440 Fixed Rating.

3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 8 psf (383 Pa) as defined in AAMA 501.
4. Uniform Load: A static air design load of 35 psf (1680 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
5. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.
6. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
 - a. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 - b. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)].
 - c. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $\epsilon = 0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

7. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Glass to Exterior – 0.47 (low-e) or 0.61 (clear) or Project Specific (____) BTU/hr/ft²/°F.
 - b. Glass to Center – 0.44 (low-e) or 0.61 (clear) or Project Specific (____) BTU/hr/ft²/°F.
 - c. Glass to Interior – 0.41 (low-e) or 0.56 (clear) or Project Specific (____) BTU/hr/ft²/°F.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Glass to Exterior – 70_{frame} and 69_{glass} (low-e) or 69_{frame} and 58_{glass} (clear).
 - b. Glass to Center – 62_{frame} and 68_{glass} (low-e) or 63_{frame} and 56_{glass} (clear).
 - c. Glass to Interior – 56_{frame} and 67_{glass} (low-e) or 54_{frame} and 58_{glass} (clear).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

9. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. Glass to Exterior – 38 (STC) and 31 (OITC).
 - b. Glass to Center – 37 (STC) and 30 (OITC).
 - c. Glass to Interior – 38 (STC) and 30 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following B options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.

5. Flashing and drainage.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. Structural-Sealant Glazing: Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.
- H. Structural-Sealant Joints: Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM AND GLASS ORIENTATION CENTER, EXTERIOR (FRONT), INTERIOR (BACK).

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Trifab™ VG 451 (Non-Thermal) or Trifab™ 451T (Thermal) Framing System
 3. Trifab™ VG 451 (Non-Thermal) or Trifab™ 451T (Thermal) Framing System (Impact Glazing and Blast Mitigation)
 4. System Dimensions: 2" x 4-1/2" (50.8 mm x 114.3 mm)
 5. Glass: Center, Exterior or Interior

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.

4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum framing members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier (Trifab™ VG 451T):
 1. Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black
 2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 - 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawings including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacturer of single-source for light shelf and framing system and compatibility between the system.
- C. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- D. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight framed aluminum storefront system installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Thermally Broken Aluminum Entrances, glass and glazing, and door hardware and components.
- Types of Kawneer Thermally Broken Aluminum Entrances include:
 - AA™250 Thermal Entrance; Narrow stile, 2-1/2" (63.5 mm) vertical face dimension, 2-1/4" (57 mm) depth, moderate traffic applications.
 - AA™425 Thermal Entrance; Wide stile, 4-1/4" (108 mm) vertical face dimension, 2-1/4" (57 mm) depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 072700 "Air Barriers"
- 079200 "Joint Sealants"
- 083213 "Sliding Aluminum-Framed Glass Doors"
- 084313 "Aluminum-Framed Storefronts"
- 084329 "Sliding Storefronts"
- 084413 "Glazed Aluminum Curtain Walls"
- 084433 "Sloped Glazing Assemblies"
- 085113 "Aluminum Windows"
- 086300 "Metal-Framed Skylights"
- 087000 "Hardware"
- 088000 "Glazing"
- 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance doors shall withstand the effects of the following performance requirements without exceeding performance criteria or failure due to defective manufacture, fabrication, installation, or other defects in construction:
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance

door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm per square foot.

3. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 for typical application or L/180 for Small-Missile and Large-Missile impact, of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
4. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.3 Standard 12 for exterior doors and Standard 10 for glazing and frame bite provisions, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
5. Forced Entry: Tested in accordance with AAMA 1304.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $e=0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Insulated Glass – 0.43 (low-e) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per AAMA 507 per NFRC 100.
7. Solar Heat Gain Coefficient: Glazed thermally broken aluminum door and frame shall have a solar heat gain coefficient of no greater than (____) <Insert value> as determined according to NFRC 200.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Insulated Glass – 57_{frame} and 71_{glass} (low-e).
9. Condensation Resistance (I): When tested to CSA A440, the condensation resistance factor shall not be less than:
 - a. Insulated Glass – 48_{frame} and 69_{glass} (low-e).
10. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with ASTM E 90, the STC and OITC ratings shall not be less than:
 - a. 32 (STC) and 28 (OITC).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating thermally broken aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports and calculations.
- C. **Source Limitations:** Obtain thermally broken aluminum-framed door through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum-framed glass entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify actual dimensions of thermally broken aluminum-framed door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. The door stile and rail face dimensions of the [_____] (choose one: AA™250 or AA™425) Thermal Entrance will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
AA™250 Thermal Entrance	2-1/2" (63.5 mm)	2-1/2" (63.5 mm)	3-7/8" (99 mm)	10" (254 mm)
AA™425 Thermal Entrance	4-1/4" (108 mm)	4-1/4" (108 mm)	6-1/2" (166 mm)	10" (254 mm)
 - 3. Major portions of the door members to be 0.125" (4) nominal in thickness and glazing molding to be 0.05" (1.3 mm) thick
 - 4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
 - 5. Provide adjustable glass jacks to help center the glass in the door opening.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum entrance and storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum entrances and storefronts for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Slide-In-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing:
 - 1. Trifab™ VG 451T
 - 2. Trifab™ 451UT
 - 3. Trifab™ 601/601T
 - 4. Thermally Broken entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware:
 - 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with two lines of weather-stripping utilizing wool pile with polymeric fin.

- b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing and a wool pile with polymeric fin.
2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
3. Threshold: Extruded aluminum, thermally broken, with ribbed surface.
4. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
5. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: [_____].
9. Closer: [_____].
10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
11. Latch Handle: [_____].
12. Cylinder(s)/Thumbturn: [_____].
13. Electric Strike/Strike Keeper: [_____].

C. Optional Hardware:

EDITOR NOTE: SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Adams Rite MS 1850A-505 Hookbolt Lock.
2. Mortise cylinder, interior or exterior.
3. Thumbturn, interior.
4. Flush pull.

2.6 Fabrication

- A. Fabricate thermally broken aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate thermally broken aluminum-framed doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1" (24 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufactures drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.

2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing thermally broken aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install thermally broken aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed door and storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Aluminum Entrances include:
 - a. 190 Swing Door; Narrow stile, 2-1/8" (54 mm) vertical face dimension, 1-3/4" (44.5 mm) depth, moderate traffic applications.
 - b. 350 Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 1-3/4" (44.5 mm) depth, high traffic applications.
 - c. 500 Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 1-3/4" (44.5 mm) depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084313 "Aluminum-Framed Storefronts"
- 5. 084329 "Sliding Storefronts"
- 6. 084413 "Glazed Aluminum Curtain Walls"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 087000 "Hardware"
- 11. 088000 "Glazing"
- 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

- 1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 PA) for single and pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

A. Basis-of-Design Product:

1. Kawneer Company Inc.
2. The door stile and rail face dimensions of the [_____] (choose one: 190-350-500) entrance door will be as follows

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
190	2-1/8" (54 mm)	2-1/4" (58 mm)	3-7/8" (99 mm)	10" (254 mm)
350	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)

3. Major portions of the door members to be 0.125" (3.2) nominal in thickness and glazing molding to be 0.05" (1.3) thick.
4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
5. Provide adjustable glass jacks to help center the glass in the door opening.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
2. Series: (_____)
3. Profile dimension: (_____)
4. Performance Grade: (_____)

C. Substitutions: Refer to Substitutions Section for procedures and submission requirements

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed entrance door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

A. Storefront Entrance Framing:

1. Trifab™ VG 450/451/451T or Trifab™ 451UT.
2. Trifab™ 601/601T/601UT.

3. Thermally Broken entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware:
 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 4. Center Pivots: [_____].
 5. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
 6. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
 7. Continuous Hinge: [_____].
 8. Push/Pull: [_____] style.
 9. Exit Device: [_____].
 10. Closer: [_____].
 11. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 12. Latch Handle: [_____].
 13. Cylinder(s)/Thumbturn: [_____].
 14. Electric Strike/Strike Keeper: [_____].
- C. Optional Hardware:

EDITOR NOTE SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Adams Rite MS 1850A-505 Hookbolt Lock.
2. Mortise cylinder, interior or exterior.
3. Thumbturn, interior.
4. Flush pull.

- D. Access Control Entrance Hardware:
1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
 2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
 3. Proximity Cards.
 4. Exit Device: Kawneer Paneline™ EL
 5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
 6. Power supply for Electric Strike: Altronix AL UL 175.
 7. Power Transfer [_____]. One per EL Exit Device required for access control.
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
 8. Interior push button release.
 9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.

- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrance doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
1. Types of Kawneer Aluminum Thermal Entrances include:
 - a. Insulclad™ 260 Swing Door; Narrow stile, 2-11/16" (68.3 mm) vertical face dimension, 2-1/4" (57.2 mm) depth, moderate traffic applications.
 - b. Insulclad™ 360 Swing Door; Medium stile, 4-1/16" (103.2 mm) vertical face dimension, 2-1/4" (57.2 mm) depth, high traffic applications.
 - c. Insulclad™ 560 Swing Door; Wide stile, 5-9/16" (141.3 mm) vertical face dimension, 2-1/4" (57.2 mm) depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084313 "Aluminum-Framed Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 087000 "Hardware"
 11. 088000 "Glazing"
 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for single doors and pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].
4. Thermal Performance: Computer simulation testing shall be in accordance with NFRC 100/200/500 and AAMA 507-03.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrances and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

A. Basis-of-Design Product:

1. Kawneer Company Inc.
2. The door stile and rail face dimensions of the [] (choose one: Insulclad™ 260, 360, or 560) thermal entrance door will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
260 Door	2-11/16" (68.3 mm)	2-12/16" (71.4 mm)	4-7/16" (112.7 mm)	10" (254 mm)
360 Door	4-1/16" (103.2 mm)	4-1/16" (103.2 mm)	7-1/16" (179.4 mm)	10" (254 mm)
560 Door	5-9/16" (141.3 mm)	5-9/16" (141.3 mm)	7-1/16" (179.4 mm)	10" (254 mm)

3. Major portions of the door members to be 0.125" (3.2 mm) nominal in thickness and glazing molding to be 0.05" (1.3 mm) thick.
4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
5. Provide adjustable glass jacks to help center the glass in the door opening.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: ()
2. Series: ()
3. Profile dimension: ()
4. Performance Grade: ()

C. Substitutions: Refer to Substitutions Section for procedures and submission requirements

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed entrance door performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance door for a period of not less than ten (10) years. (Company Name)
5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

A. Storefront Entrance Framing:

1. Trifab™ VG 450/451/451T.
2. Trifab™ 601/601T.

3. Thermally Broken Entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware:
 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 4. Center Pivots: [_____].
 5. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
 6. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
 7. Continuous Hinge: [_____].
 8. Push/Pull: [_____] style.
 9. Exit Device: [_____].
 10. Closer: [_____].
 11. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 12. Latch Handle: [_____].
 13. Cylinder(s)/Thumbturn: [_____].

2.6 Fabrication

- A. Fabricate aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed entrance doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacture's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrance doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Aluminum Entrances include.
 - a. 350 Heavy Wall™ Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - b. 500 Heavy Wall™ Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - c. 350 Heavy Wall™ IR Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - d. 500 Heavy Wall™ IR Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections.
 - 1. 072700 "Air Barriers".
 - 2. 079200 "Joint Sealants".
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors".
 - 4. 084313 "Aluminum-Framed Storefronts".
 - 5. 084329 "Sliding Storefronts".
 - 6. 084413 "Glazed Aluminum Curtain Walls".
 - 7. 084433 "Sloped Glazing Assemblies".
 - 8. 085113 "Aluminum Windows".
 - 9. 086300 "Metal-Framed Skylights".
 - 10. 087000 "Hardware".
 - 11. 088000 "Glazing".
 - 12. 280000 "Electronic Safety and Security".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum-Framed Entrance Performance Requirements.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide aluminum-framed entrance door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for single doors and for pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].
4. Uniform Load: A static air design load of 85 psf (4070 Pa), (65 psf (3113 Pa) for laminated infill) shall be applied in the positive and negative direction in accordance with Florida Building Code TAS202 and ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage shall occur.
5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis.
 - b. Section B-3.1.2 Testing.
 - c. Section B-3.1.3 ASTM F2248 Design Approach.
7. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following.
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals.
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.

1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of aluminum-framed entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:

1. Kawneer Company Inc..
2. The door stile and rail face dimensions of the [_____] (choose from below) entrance door will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
350 Heavy Wall™	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 Heavy Wall™	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)
350 Heavy Wall™ IR	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 Heavy Wall™ IR	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)

3. Major portions of the door members to be 0.188" (5 mm) nominal in thickness and glazing molding to be 0.05" (1.5 mm) thick.
4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
5. (350/500 Heavy Wall™) Provide adjustable glass jacks to help center the glass in the door opening.
6. (350/500 Heavy Wall™ IR) Structural silicone sealant to be DOW 995 or Tremco Proglaze SSG.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following.

1. Manufacturer: (_____).
2. Series: (_____).
3. Profile dimension: (_____).
4. Performance Grade: (_____).

- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed entrance door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing.
 - 1. Trifab™ 450/451/451T.
 - 2. Trifab™ 601/601T.
 - 3. IR 500/501.
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle aluminum-framed entrance door material and components to avoid damage. Protect aluminum-framed entrance door material against damage from elements, construction activities, and other hazards before, during and after aluminum-framed entrance door installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
 - 1. 350/500 Heavy Wall IR: 9/16" (14.3 mm) laminated infill with 0.090" (3 mm) PVB interlayer.
 - 2. 350/500 Heavy Wall IR: 9/16" (14.3 mm) laminated infill with Solutia Vanceva 0.075" (2 mm) interlayer, Dupont SG 0.090" (3 mm) interlayer.
 - 3. 350/500 Heavy Wall IR: 0.090" (3 mm) PVB interlayer, Dupont SG 0.090" (3 mm) interlayer.
 - 4. 350/500 Heavy Wall IR BLAST: 9/16" (14.3 mm) laminated infill with 0.090" (3 mm) PVB interlayer.
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware (350/500 Heavy Wall™).
 - 1. Weather-stripping.
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).

3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
4. Offset Pivots: [_____].
5. Butt Hinge: [_____].
6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: [_____].
9. Closer: [_____].
10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
11. Latch Handle: [_____].
12. Cylinder(s)/Thumbturn: [_____].
13. Electric Strike/Strike Keeper: [_____].

C. Standard Hardware (350/500 Heavy Wall™ IR).

1. Weather-stripping.
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
4. Offset Pivots: [_____].
5. Butt Hinge: [_____].
6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: [_____].
 - a. Concealed Rod Device; Kawneer 1686, Jackson 2086, Paneline™, Falcon HH1690, Von Duprin 9947HH.
 - b. Rim Exit Device; Von Duprin 98/99.
9. Closer: [_____].
10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
11. Latch Handle: [_____].
12. Cylinder(s)/Thumbturn: [_____].
13. Electric Strike/Strike Keeper: [_____].

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ EL CONCEALED ROD EXIT DEVICE OR OTHER ELECTRONIC SECURITY ITEMS.

D. Access Control Entrance Hardware.

1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
3. Proximity Cards.
4. Exit Device: Kawneer Paneline™ EL.
5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
6. Power supply for Electric Strike: Altronix AL UL 175.
7. Power Transfer [_____]. One per EL Exit Device required for access control.
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
8. Interior push button release.
9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed entrance doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrances. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Aluminum Entrances include:
 - a. 350 Heavy Wall™ Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - b. 500 Heavy Wall™ Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - c. 350 Heavy Wall™ IR Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.
 - d. 500 Heavy Wall™ IR Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 2" (51 mm) depth, 3/16" (5 mm) wall thickness high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084313 "Aluminum-Framed Storefronts"
 - 5. 084329 "Sliding Storefronts"
 - 6. 084413 "Glazed Aluminum Curtain Walls"
 - 7. 084433 "Sloped Glazing Assemblies"
 - 8. 085113 "Aluminum Windows"
 - 9. 086300 "Metal-Framed Skylights"
 - 10. 087000 "Hardware"
 - 11. 088000 "Glazing"
 - 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction:
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide aluminum-framed entrance door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for single doors and for pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].
4. Uniform Load: A static air design load of 85 psf (4070 Pa), (65 psf (3113 Pa) for laminated infill) shall be applied in the positive and negative direction in accordance with Florida Building Code TAS202 and ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage shall occur.
5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
7. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.

1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of aluminum-framed entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:

1. Kawneer Company Inc.
2. The door stile and rail face dimensions of the [_____] (choose from below) entrance door will be as follows

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
350 Heavy Wall™	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 Heavy Wall™	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)
350 Heavy Wall™ IR	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 Heavy Wall™ IR	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)

3. Major portions of the door members to be 0.188" (5 mm) nominal in thickness and glazing molding to be 0.05" (1.5 mm) thick.
4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
5. (350/500 Heavy Wall™) Provide adjustable glass jacks to help center the glass in the door opening.
6. (350/500 Heavy Wall™ IR) Structural silicone sealant to be DOW 995 or Tremco Proglaze SSG.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
2. Series: (_____)
3. Profile dimension: (_____)
4. Performance Grade: (_____)

- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed entrance door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing:
 - 1. Trifab™ 450/451/451T
 - 2. Trifab™ 601/601T
 - 3. IR 500/501
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle aluminum-framed entrance door material and components to avoid damage. Protect aluminum-framed entrance door material against damage from elements, construction activities, and other hazards before, during and after aluminum-framed entrance door installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
 - 1. 350/500 Heavy Wall IR: 9/16" (14.3 mm) laminated infill with 0.090" (3 mm) PVB interlayer.
 - 2. 350/500 Heavy Wall IR: 9/16" (14.3 mm) laminated infill with Solutia Vanceva 0.075" (2 mm) interlayer, Dupont SG 0.090" (3 mm) interlayer.
 - 3. 350/500 Heavy Wall IR: 0.090" (3 mm) PVB interlayer, Dupont SG 0.090" (3 mm) interlayer.
 - 4. 350/500 Heavy Wall IR BLAST: 9/16" (14.3 mm) laminated infill with 0.090" (3 mm) PVB interlayer.
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware (350/500 Heavy Wall™):
 - 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).

3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
4. Offset Pivots: [_____].
5. Butt Hinge: [_____].
6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: [_____].
9. Closer: [_____].
10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
11. Latch Handle: [_____].
12. Cylinder(s)/Thumbturn: [_____].
13. Electric Strike/Strike Keeper: [_____].

C. Standard Hardware (350/500 Heavy Wall™ IR):

1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
4. Offset Pivots: [_____].
5. Butt Hinge: [_____].
6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: [_____].
 - a. Concealed Rod Device; Kawneer 1686, Jackson 2086, Paneline™, Falcon HH1690, Von Duprin 9947HH.
 - b. Rim Exit Device; Von Duprin 98/99.
9. Closer: [_____].
10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
11. Latch Handle: [_____].
12. Cylinder(s)/Thumbturn: [_____].
13. Electric Strike/Strike Keeper: [_____].

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ EL CONCEALED ROD EXIT DEVICE OR OTHER ELECTRONIC SECURITY ITEMS.

D. Access Control Entrance Hardware:

1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
3. Proximity Cards.
4. Exit Device: Kawneer Paneline™ EL.
5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
6. Power supply for Electric Strike: Altronix AL UL 175.
7. Power Transfer [_____]. One per EL Exit Device required for access control:
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
8. Interior push button release.
9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed entrance doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.

- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrances. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Aluminum Entrances include.
 - a. 350 IR Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 1-3/4" (44.5) mm depth, high traffic applications.
 - b. 500 IR Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 1-3/4" (44.5) mm depth, high traffic applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections.
 - 1. 072700 "Air Barriers".
 - 2. 079200 "Joint Sealants".
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors".
 - 4. 084313 "Aluminum-Framed Storefronts".
 - 5. 084329 "Sliding Storefronts".
 - 6. 084413 "Glazed Aluminum Curtain Walls".
 - 7. 084433 "Sloped Glazing Assemblies".
 - 8. 085113 "Aluminum Windows".
 - 9. 086300 "Metal-Framed Skylights".
 - 10. 087000 "Hardware".
 - 11. 088000 "Glazing".
 - 12. 280000 "Electronic Safety and Security".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum Framed Entrance Performance Requirements.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for single doors and pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].
4. Uniform Load: A static air design load of 85 psf (4070 Pa), (65 psf (3113 Pa) for laminated infill) shall be applied in the positive and negative direction in accordance with Florida Building Code TAS202 and ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage shall occur.
5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
 To meet UFC 04-010-01, B-3.3 Standard 12 for Exterior Doors and Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis.
 - b. Section B-3.1.2 Testing.
 - c. Section B-3.1.3 ASTM F2248 Design Approach.
7. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance doors and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following.
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals.
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - 2. The door stile and rail face dimensions of the 350IR/500IR entrance door will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
350 IR	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 IR	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)
 - 3. Major portions of the door members to be 0.125" (4) nominal in thickness and glazing molding to be 0.05" (1.5) thick.
 - 4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
 - 5. Structural silicone sealant to be Dow Corning 983, 995 or Tremco Proglaze SSG.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following.
 - 1. Manufacturer: (_____).
 - 2. Series: (_____).
 - 3. Profile dimension: (_____).
 - 4. Performance Grade: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" wall thickness at any location for the main frame and door leaf members.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed entrance door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing.
 - 1. Trifab™ VG 450/451/451T.
 - 2. IR500/501.
 - 3. IR501UT/IR501T.
 - 4. Trifab™ 601/601T.
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after aluminum-framed entrance door installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glass.
 - 1. 9/16" laminated infill with .090" (3) PVB interlayer.
 - 2. 9/16" laminated infill with Solutia Vanceva .075" (2) interlayer, Dupont SGP .090" (3) interlayer.
- C. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- D. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Hardware.
 - 1. Weather-stripping.
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 - 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 - 4. Offset Pivots: [_____].
 - 5. Butt Hinge: [_____].

6. Continuous Hinge: [_____].
7. Push/Pull: [_____] style.
8. Exit Device: Kawneer 1686 Concealed Rod Exit Device, Paneline™ Concealed Rod Exit Device, Adams Rite G86 Concealed Rod Exit Device, Calibre 9100 Concealed Rod Exit Device, Falcon HH1690 Concealed Rod Exit Device, Jackson 2080 Concealed Rod Exit Device, Sargent 8400AD Concealed Rod Exit Device or Von Duprin HH9947 Concealed Rod Exit Device.
9. Closer: Surface or concealed closer (concealed closer with non-transom and non-sidelite Trifab™ VG 450 (Center) and 1600 Wall sub-frames only).
10. Security Lock/Dead Lock: MS 1850A lock with 3-point active stile locking and hurricane flushbolts on pairs, Adams Rite 2180 2-Point Dead Lock or MS 1850A with 1871 cylinder operated flushbolts.
11. Cylinder(s)/Thumbturn: Kawneer standard.
12. Cylinder Guard: Kawneer standard.

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ EL CONCEALED ROD EXIT DEVICE OR OTHER ELECTRONIC SECURITY ITEMS.

C. Access Control Entrance Hardware.

1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
3. Proximity Cards.
4. Exit Device: Kawneer Paneline™ EL.
5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
6. Power supply for Electric Strike: Altronix AL UL 175.
7. Power Transfer [_____]. One per EL Exit Device required for access control.
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
8. Interior push button release.
9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed glass entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Prepare components with internal reinforcement for door hardware.
 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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PART 3 - EXECUTION**3.1 Examination**

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrance doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE DOOR TYPE (MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

- A. This Section includes Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 1. Types of Kawneer Aluminum Entrances include:
 - a. 350 Tuffline™ Swing Door; Medium stile, 3-1/2" (89 mm) vertical face dimension, 2" (51mm) depth, 3/16" (5mm) wall thickness, high traffic and high abuse applications.
 - b. 500 Tuffline™ Swing Door; Wide stile, 5" (127 mm) vertical face dimension, 2" (51mm) depth, 3/16" (5mm) wall thickness, high traffic and high abuse applications.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084313 "Aluminum-Framed Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"
12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction:
- B. Aluminum Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide aluminum-framed entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

2. Air Infiltration: For single acting offset pivot or butt hung entrances in the closed and locked position, the test specimen shall be tested in accordance with ASTM E 283 at a pressure differential of 1.57 psf (75 Pa) for single doors and pairs of doors. A single 3'0" x 7'0" (915 mm x 2134 mm) entrance door and frame shall not exceed 1.0 cfm/ft². A pair of 6'0" x 7'0" (1830 mm x 2134 mm) entrance doors and frame shall not exceed 1.0 cfm/ft².
3. Structural Performance: Corner strength shall be tested per the Kawneer dual moment load test procedure and certified by an independent testing laboratory to ensure weld compliance and corner integrity [Testing procedure and certified test results available upon request].

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed entrance door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed entrance doors and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 1. Joinery, including welds.
 2. Glazing.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed entrance door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE DOOR TYPE (NARROW, MEDIUM, WIDE) BASED ON PROJECT REQUIREMENTS.

A. Basis-of-Design Product:

1. Kawneer Company Inc.
2. The door stile and rail face dimensions of the [] (choose one: 350 Tuffline™ or 500 Tuffline™) entrance door will be as follows

Door	Vertical Stile	Top Rail	Bottom Rail	Optional Bottom Rail
350 Tuffline™	3-1/2" (89 mm)	3-1/2" (89 mm)	6-1/2" (166 mm)	10" (254 mm)
500 Tuffline™	5" (127 mm)	5" (127 mm)	6-1/2" (166 mm)	10" (254 mm)

3. Major portions of the door members to be 0.188" (4.8mm) nominal in thickness and glazing molding to be 0.05" (1.5mm) thick.
4. Glazing gaskets shall be either EPDM elastomeric extrusions or a thermoplastic elastomer.
5. Provide adjustable glass jacks to help center the glass in the door opening.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: ()
2. Series: ()
3. Profile dimension: ()
4. Performance Grade: ()

C. Substitutions: Refer to Substitutions Section for procedures and submission requirements

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid aluminum-framed entrance door installation and construction delays.
3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum-framed entrance doors for a period of not less than ten (10) years. (Company Name)
5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed entrance door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.

2.3 Storefront Framing System

- A. Storefront Entrance Framing: Entrance framing to be 2" x 4-1/2" (50.8 mm x 114.3 mm) heavy duty framing.
- B. Non-Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed entrance doors.
- B. Standard Tuffline™ Entrance Hardware:
 - 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (Necessary to meet specified performance tests).
 - 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 - 4. Heavy Duty Offset Pivots.
 - 5. Butt Hinge: Full mortised 5" x 4-1/2" (127 mm x 115 mm) ball bearing type.
 - 6. Continuous Hinge: [_____].
 - 7. Push/Pull: [_____] style.
 - 8. Exit Device: [_____].
 - 9. Closer: [_____].
 - 10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 - 11. Latch Handle: [_____].
 - 12. Cylinder(s)/Thumbturn: [_____].
 - 13. Electric Strike/Strike Keeper: [_____].

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE® EL CONCEALED ROD EXIT DEVICE OR OTHER ELECTRONIC SECURITY ITEMS.

- C. Access Control Entrance Hardware:
 - 1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
 - 2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
 - 3. Proximity Cards.
 - 4. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
 - 5. Power supply for Electric Strike: Altronix AL UL 175.
 - 6. Exit Device: Kawneer Paneline™ EL, DOM 1690 and DOM 1790.
 - 7. Power Transfer [_____]. One per EL Exit Device required for access control:
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
 - 8. Interior push button release.
 - 9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed entrance doors that are reglazable without dismantling perimeter framing.
 - 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners. Glazing stops shall be hook-in type with EPDM glazing gaskets reinforced with non-stretchable cord.
 - 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 - 3. Prepare components with internal reinforcement for door hardware.
 - 4. Arrange fasteners and attachments to conceal from view.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufactures drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed entrance doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. This Section includes Kawneer Flushline™ Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Flushline™ Entrances include:
 - a. Flushline™ Entrance; urethane foam-filled door, flush face design, high traffic and high abuse.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084313 "Aluminum-Framed Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"
12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT ENTRANCE SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Aluminum-framed flush entrance system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Aluminum-Framed Entrance Performance Requirements:

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide entrance system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283.
3. Uniform Load: The test specimen shall be tested in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
4. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Aluminum-Framed Flush Entrance Doors with glass lites – with Aluminum Panel = 0.82 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.

- b. Aluminum-Framed Flush Entrance Doors with glass lites – with FRP Panel = 0.66 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- 5. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F2927, ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.3 Standard 12 for exterior doors and Standard 10 for glazing and frame bite provisions, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
- b. Section B-3.1.2 Testing
- c. Section B-3.1.3 ASTM F2248 Design Approach
- 6. Forced Entry: Tested in accordance with AAMA 1304.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed flush entrance doors indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed flush entrance doors and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed entrance doors.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 - 1. Joinery, including welds.
 - 2. Flush face panel.
- G. Other Action Submittals:
 - 1. Aluminum-Framed Flush Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum-framed flush entrance doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports and calculations.
- C. Source Limitations: Obtain aluminum-framed flush entrance doors through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed flush entrance doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of swing entrance door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed flush entrance doors openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE FACE SHEET TYPE (FRP OR ALUMINUM) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. The door stile and rail face dimensions of the Flushline™ Entrance door will be as follows:

Door	Vertical Stile	Top Rail	Bottom Rail
Flushline™	5" (127 mm)	5" (127 mm)	5" (127 mm)
 3. The door face sheet shall be () (specify one of the following).
 - a. Pebble textured fiberglass reinforced polyester (FRP) 0.090" (2.3 mm).
 - b. Architectural quality aluminum sheet 0.090" (2.3 mm) thick (specify: embossed or plain unpatterned).
 4. Vision lites, if required:
 - a. Aluminum-framed vision lite (AVL)
 5. Glass for vision lites to be () (specify 1/4" (6.4 mm), 1" (25.4 mm) insulated clear tempered glass or 1" (25.4 mm) impact glass).
 6. Vision lite glazing shall be with foam glazing tape.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: ()
 2. Series: ()
 3. Profile dimension: ()
 4. Performance Grade: ()
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for aluminum-framed flush entrance and storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum entrances and storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum-framed flush door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and door leaf members.
- B. Aluminum-Framed Flush Entrance Door Core: Shall be urethane foam injected at 2.5 lb./cu.ft. density and shall have "0" O.D.P. = "Zero" Ozone Depletion Potential and contains no Chlorofluorocarbons (CFC's) or Hydro chlorofluorocarbons (HCFC's).
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum-framed flush entrance door members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

2.3 Storefront Framing System

EDITOR NOTE: CHOOSE ENTRANCE FRAMING TYPE BASED ON PROJECT REQUIREMENTS.

- A. Storefront Entrance Framing Non-Thermal (Trifab™ VG 450, Trifab™ VG 451 or Trifab™ 601)
- B. Storefront Entrance Framing Thermal (Trifab™ 451UT or Trifab™ 601T/601UT)
1. Thermally Broken Entrance Framing - Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density urethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- C. Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- E. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- F. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- G. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum-framed flush entrance doors.
- B. Standard Hardware:
 - 1. Weather-stripping:
 - a. Meeting stiles on pairs of doors shall be equipped with an adjustable astragal utilizing wool pile with polymeric fin.
 - b. The door weathering on a single acting offset pivot or butt hung door and frame (single or pairs) shall be comprised of a thermoplastic elastomer weathering on a tubular shape with a semi-rigid polymeric backing.
 - 2. Sill Sweep Strips: EPDM blade gasket sweep strip in an aluminum extrusion applied to the interior exposed surface of the bottom rail with concealed fasteners (necessary to meet specified performance tests).
 - 3. Threshold: Extruded aluminum, one piece per door opening, with ribbed surface.
 - 4. Offset Pivots: [_____]. (Note: EL Offset Pivot available for access control)
 - 5. Butt Hinge: [_____]. Kawneer Standard is Stainless Steel w/ Powder Coating & Non Removable Pin (NRP) (NOTE: EL Hinge available for access control)
 - 6. Continuous Hinge: [_____].
 - 7. Push/Pull: [_____] style.
 - 8. Exit Device: [_____].
 - 9. Closer: [_____].
 - 10. Security Lock/Dead Lock: Active Leaf [_____]; Inactive Leaf [_____].
 - 11. Latch Handle: [_____].
 - 12. Cylinder(s)/Thumbturn: [_____].
 - 13. Electric Strike/Strike Keeper: [_____].

EDITOR NOTE: BELOW HARDWARE SCHEDULE TO BE USED WHEN SPECIFYING PANELINE™ CONCEALED ROD EXIT DEVICE OR OTHER ELECTORIC SECURITY ITEMS.

- C. Access Control Entrance Hardware
 - 1. Stand alone Key Pad: AC-G43 Key Pad System – Kawneer Standard.
 - 2. Stand alone Key Pad (with Optional Proximity Card Reader): AC-G44 Key Pad/ Reader (Note: Proximity Cards not included).
 - 3. Proximity Cards.
 - 4. Exit Device: Kawneer Paneline™ EL.
 - 5. Power supply for Exit Device: SP 1000X (One per pair. Max of 2 doors per power supply) **Required for Paneline™ EL.**
 - 6. Power supply for Electric Strike: Altronix AL UL 175.
 - 7. Power Transfer [_____]. One per EL Exit Device required for access control:
 - a. EPT (Electric Power Transfer) Note: EPT used for continuous geared hinge applications.
 - b. EL Intermediate Pivot.
 - c. EL Butt Hinge.
 - 8. Interior push button release.
 - 9. Point to Point wiring diagram.

2.6 Fabrication

- A. Fabricate aluminum-framed flush entrance doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate aluminum-framed flush entrance doors that are reglazable, when vision lites are used, without dismantling perimeter framing.
 - 1. Door corner construction shall consist of mechanical clip fastening, SIGMA deep penetration plug welds and 1-1/8" (29 mm) long fillet welds inside and outside of all four corners.
 - 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.

3. Face sheets shall lap and interlock with stile and rails to create a hollow cavity for the froth-in-place urethane core.
 4. Prepare components with internal reinforcement for door hardware.
- C. Weather-stripping: Provide weather-stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
- Kawneer Permanodic™ AA-M10C21A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
- Kawneer Permanodic™ AA-M10C21A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
- Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
- Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
- Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
- Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
- Other: Manufacturer _____ Type _____ Color _____.
- C. Face Sheets:
1. Pebble texture (FRP) fiberglass reinforced polyester (Color _____) (select from list)
Beige, Dark Bronze, Light Grey and White.
 2. Kawneer Aluminum (select one of the finishes previously stated for exposed aluminum from above).

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed flush entrance doors, hardware, accessories, and other components.
- B. Install aluminum-framed flush entrance doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed flush entrance doors and storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM

1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ 601 Framing System – 2" x 6" (50.8 mm x 152.4 mm) nominal dimension; Non-Thermal; Center Plane; Screw Spline Fabrication.
 - b. Trifab™ 601T Framing System – 2" x 6" (50.8 mm x 152.4 mm) nominal dimension; Thermal; Center Plane; Screw Spline Fabrication.
 - c. Trifab™ 601T Framing System – Impact Glazing
 - d. Trifab™ 601UT Framing System – 2" x 6" (50.8 mm x 152.4 mm) nominal dimension; Thermal; Center Plane; Screw Spline Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal. CSA A440 Fixed Rating.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 10 psf (500 Pa) as defined in AAMA 501. CSA A440 B5 Rating.

4. Uniform Load: A static air design load of 30 psf (1437 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur. CSA A440 C2 Rating.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $\epsilon = 0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

5. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Trifab™ 601 – 0.53 (low-e) or Project Specific (____) BTU/hr/ft²/°F. As determined per AAMA 507 or NFRC 100.
 - b. Trifab™ 601T – 0.35 (low-e) or Project Specific (____) BTU/hr/ft²/°F. As determined per AAMA 507 or NFRC 100.
 - c. Trifab™ 601UT – 0.33 (low-e) or Project Specific (____) BTU/hr/ft²/°F. As determined per AAMA 507 or NFRC 100.
6. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Trifab™ 601 – 41_{frame} and 63_{glass} (low-e).
 - b. Trifab™ 601T – 69_{frame} and 70_{glass} (low-e).
 - c. Trifab™ 601UT – 74_{frame} and 70_{glass} (low-e).
7. Condensation Resistance (I): When tested to CSA A-440.2, the condensation index shall not be less than:
 - a. 63_{frame} and 68_{glass} (low-e).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

8. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. Trifab™ 601/601T/601UT – 37 (STC) and 31 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery, including concealed welds.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.

1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Trifab™ 601 Framing System (Non-Thermal)
 3. Trifab™ 601T Framing System (Thermal)
 4. Trifab™ 601T Framing System (Thermal) – Impact Glazing
 5. Trifab™ 601UT Framing System (Thermal)
 6. System Dimensions: 2" x 6" (50.8 mm x 152.4 mm)
 7. Glass: Center Plane, Exterior or Interior Glazed

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier (Trifab™ 601T & 601UT):
 1. Trifab™ 601T: Kawneer IsoLock™ Thermal Break with a nominal 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 2. Trifab™ 601UT: Kawneer IsoLock™ Thermal Break with dual nominal 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.

- f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
- g. Panel /Shelf projection shall not exceed 30" (762mm).
- h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
- i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
- 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
- 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.
- C. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- D. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight framed aluminum-storefront system installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
 1. Types of Kawneer Aluminum Storefront Systems include:
 - a. EnCORE™ Framing System – 1-3/4" (44.5) x 3-9/16" (90.5), 4-1/2" (114.3) or 6" (228.6) nominal dimension; Thermally improved; Front, Center, or Structural Silicone Glazed; Screw Spline, Shear Block, or Punched Opening (Type B) Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 088000 "Glazing"
 11. 107113 "Exterior Sun Control Devices"
 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 8 psf (383 Pa) as defined in AAMA 501
4. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $\epsilon=0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

5. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Glass to Exterior – 0.46 (low-e) or 0.63 (clear) or Project Specific (____) BTU/hr/ft²/°F.
6. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Glass to Exterior – 60_{frame} and 63_{glass} (low-e) or 60_{frame} and 58_{glass} (clear).

1.5 Submittal

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery, including concealed welds.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. Structural-Sealant Glazing: Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.
- H. Structural-Sealant Joints: Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. EnCORE™ Framing System (Thermally improved)
 3. System Dimensions: 1-3/4" (44.5) x 3-9/16" (90.5), 4-1/2" (114.3) or 6" (228.6) nominal dimension
 4. Glass: Center or Exterior

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Thermal Barrier: A minimum 1/4" (6.4) separation between the interior and exterior aluminum created by intermittent polymer clips.
- G. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposes shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing"
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 - 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black
 - 2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- B. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront system installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.24 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
1. Types of Kawneer Aluminum Storefront Systems include.
 - a. IR 500 Framing – 2-1/2" x 5" (63.5 mm x 127 mm) nominal dimension; Non-Thermal; Center Plane for 9/16" (14.3 mm) Impact Resistant Glazing, Screw Spline Fabrication.
 - b. IR 501 Framing – 2-1/2" x 5" (63.5 mm x 127 mm) nominal dimension; Non-Thermal; Center Plane for 1-5/16" (33.4 mm) Impact Resistant Glazing, Screw Spline Fabrication.
 - c. IR 501 Framing – 2-1/2" x 5" (63.5 mm x 127 mm) nominal dimension; Non-Thermal; Center Plane for 1-5/16" (33.4 mm) Blast Mitigation Glazing, Screw Spline Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

1. 072700 "Air Barriers".
2. 079200 "Joint Sealants".
3. 083213 "Sliding Aluminum-Framed Glass Doors".
4. 084113 "Aluminum-Framed Entrances and Storefronts".
5. 084329 "Sliding Storefronts".
6. 084413 "Glazed Aluminum Curtain Walls".
7. 084433 "Sloped Glazing Assemblies".
8. 085113 "Aluminum Windows".
9. 086300 "Metal-Framed Skylights".
10. 088000 "Glazing".
11. 107113 "Exterior Sun Control Devices".
12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.

4. Uniform Load: A static air design load of 65 psf (3112 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/180 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.4% of their clear spans shall occur.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

5. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

6. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-frame storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following.
 1. Joinery.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.
- G. Other Action Submittals.
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. Structural-Sealant Glazing: Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.

H. Structural-Sealant Joints: Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.

1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE IR 500 OR IR 501 FRAMING

- A. Basis-of-Design Product.
1. Kawneer Company Inc..
 2. IR 500 Framing (Non-Thermal).
 3. IR 501 Framing (Non-Thermal).
 4. IR 501 Framing (Non-Thermal) - Blast Mitigation.
 5. System Dimensions: 2-1/2" x 5" (63.5 mm x 127 mm).
 6. Glass: Center Plane.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following.
1. Manufacturer: (_____).
 2. Series: (_____).
 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Storefront Framing System

- A. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposes shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 - 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black.
 - 2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of.
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be. (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 - 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including.
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

- B. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- C. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics.
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

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3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.

- 1. Types of Kawneer Aluminum Storefront Systems include:
 - a. IR 501T/IR 501UT Framing – 2-3/4" x 5" (69.8 mm x 127 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.
 - b. IR 501T/IR 501UT Framing – Impact Glazing
 - c. IR 501T/IR 501UT Framing – Blast Mitigation

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084329 "Sliding Storefronts"
- 6. 084413 "Glazed Aluminum Curtain Walls"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 107113 "Exterior Sun Control Devices"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal.
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (720 Pa) as defined in AAMA 501.

4. Uniform Load: A static air design load of 30 psf (1436 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
5. Thermal Transmittance (U-Factor): When tested to AAMA specification 507 or NFRC100 the thermal transmittance (U-Factor) shall not be more than:

IR 501T:

 - a. (With 2-Piece Mullion) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.57 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 - b. (With 3-Piece Mullion) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.24 to 0.55 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
6. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW.

IR 501UT:

- a. 1" insulating glass:
 - i. U-Factor not more than .33 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" clear with e=0.035 low-e coating on surface #2, 1/2" air space with warm edge spacer and 90% argon gas fill, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

IR 501T:

- b. 1" insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:

IR 501UT:

- a. 68_{frame} and 70_{glass} (low-e).

8. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

IR 501UT:

- a. 59_{frame} and 65_{glass} (low-e).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

9. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:

IR 501UT:

- a. 38 (STC) and 33 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, b-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery, including concealed welds.
 - 2. Anchorage.
 - 3. Expansion provisions.
 - 4. Glazing.
 - 5. Flashing and drainage.
- G. Other Action Submittals:
 - 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. IR 501T/IR 501UT Framing
 - 3. IR 501T/IR 501UT Framing – Impact Glazing
 - 4. IR 501T/IR 501UT Framing – Blast Mitigation
 - 5. System Dimensions: 2-3/4" x 5" (69.8 mm x 127 mm)
 - 6. Glass: Center Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

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1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier:
 1. IR 501UT - Kawneer DUAL IsoLock™ Thermal Break with two (2) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
 2. IR 501T - Kawneer SINGLE IsoLock™ Thermal Break with one (1) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black

2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
3. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacturer of single-source for light shelf and framing system and compatibility between the system.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- E. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

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3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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END OF SECTION 084113

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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
- Types of Kawneer Aluminum Storefront Systems include:
 - Trifab™ 400 Framing System – 1-3/4" x 4" (44.5 mm x 101.6 mm) nominal dimension; Non-Thermal; Center Plane, Screw Spline, Shear Block, Stick or Punched Opening Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
- 072700 "Air Barriers"
 - 079200 "Joint Sealants"
 - 083213 "Sliding Aluminum-Framed Glass Doors"
 - 084113 "Aluminum-Framed Entrances and Storefronts"
 - 084329 "Sliding Storefronts"
 - 084413 "Glazed Aluminum Curtain Walls"
 - 084433 "Sloped Glazing Assemblies"
 - 085113 "Aluminum Windows"
 - 086300 "Metal-Framed Skylights"
 - 088000 "Glazing"
 - 107113 "Exterior Sun Control Devices"
 - 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

- Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 8 psf (383 Pa) as defined in AAMA 501
- Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

1.5 Submittals

- A. **Product Data:** Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. **Shop Drawings:** Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. **Samples for Initial Selection:** For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. **Samples for Verification:** For aluminum-framed storefront system and components required.
- E. **Product Test Reports:** Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum-framed storefront.
- F. **Fabrication Sample:** Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery, including concealed welds.
 - 2. Anchorage.
 - 3. Expansion provisions.
 - 4. Glazing.
 - 5. Flashing and drainage.
- G. **Other Action Submittals:**
 - 1. **Entrance Door Hardware Schedule:** Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. **Installer Qualifications:** An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. **Manufacturer Qualifications:** A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. **Field Measurements:** Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 Manufacturers**

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. Trifab™ 400 Framing System (Non-Thermal)
 - 3. System Dimensions: 1-3/4" x 4" (44.5 mm x 101.6 mm)
 - 4. Glass: Center Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum framing members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 - 1. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- B. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Extrude aluminum shapes before finishing.
- B. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- C. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- D. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- E. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- F. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION**3.1 Examination**

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.

- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.24 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
 1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ 451UT Framing – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.
 - b. Trifab™ 451UT Framing – Blast Mitigation, 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Thermal; Center Plane, Screw Spline Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal. CSA A440 Fixed Rating.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 10 psf (479 Pa) as defined in AAMA 501.
4. Uniform Load: A static air design load of 30 psf (1436 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

5. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.
6. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
 - a. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 - b. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 - c. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $\epsilon = 0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

7. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. 0.32 (low-e) or Project Specific (____) BTU/hr/ft²/°F.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 68_{frame} and 68_{glass} (low-e).
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 - a. 60_{frame} and 62_{glass} (low-e).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

10. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. 37 (STC) and 30 (OITC).

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.
- G. Other Action Submittals:
 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.

- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Trifab™ 451UT Framing (Thermal)
 - 3. Trifab™ 451UT Framing (Thermal) - Blast Mitigation
 - 4. System Dimensions: 2" x 4-1/2" (50.8 mm x 114.3 mm)
 - 5. Glass: Center Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier (Trifab™ 451UT):
 - 1. Kawneer DUAL IsoLock™ Thermal Break with two (2) 1/4" (6.4 mm) separations consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
 - 1)
- B. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type, and as follows:
 - 1. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)

- a. Curtain Wall framing system.
- b. Storefront framing system.
- 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.
- C. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- D. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.

- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ VG 450 Framing System – 1-3/4" x 4-1/2" (44.5 mm x 114.3 mm) nominal dimension; Non-Thermal; Front, Center, Back, Multi-Plane, Structural Silicone or Weatherseal Glazed (Type B); Screw Spline, Shear Block, Stick or Punched Opening Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084329 "Sliding Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 088000 "Glazing"
 11. 107113 "Exterior Sun Control Devices"
 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 8 psf (383 Pa) as defined in AAMA 501.
4. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Warranty: Special warranty specified in this Section.
- G. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery, including concealed welds.
 - 2. Anchorage.
 - 3. Expansion provisions.
 - 4. Glazing.
 - 5. Flashing and drainage.
- H. Other Action Submittals:
 - 1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. Structural-Sealant Glazing: Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.
- H. Structural-Sealant Joints: Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 Manufacturers**

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Trifab™ VG 450 Framing System (Non-Thermal)

3. System Dimensions: 1-3/4" x 4-1/2" (44.5 mm x 114.3 mm)
4. Glass: Center, Exterior or Interior

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum framing members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- a. Color: Black
2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- B. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront system installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.

- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.24 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ VG 450 (2" Sightline) Framing System – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Non-Thermal; Front Plane, Structural Silicone or Weatherseal Glazed, Stick Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 8 psf (383 Pa) as defined in AAMA 501.
4. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

1.5 Submittals

- A. **Product Data:** Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. **Shop Drawings:** Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. **Samples for Initial Selection:** For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. **Samples for Verification:** For aluminum-framed storefront system and components required.
- E. **Product Test Reports:** Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. **Fabrication Sample:** Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery, including concealed welds.
 - 2. Anchorage.
 - 3. Expansion provisions.
 - 4. Glazing.
 - 5. Flashing and drainage.
- G. **Other Action Submittals:**
 - 1. **Entrance Door Hardware Schedule:** Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. **Installer Qualifications:** An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. **Manufacturer Qualifications:** A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. **Structural-Sealant Glazing:** Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.
- H. **Structural-Sealant Joints:** Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

- A. **Field Measurements:** Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Trifab™ VG 450 Framing System (Non-Thermal, 2" Sightline)
 - 3. System Dimensions: 2" x 4-1/2" (50.8 mm x 114.3 mm)
 - 4. Glass: Front Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum framing members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 - 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black
 - 2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- B. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum-framed storefront system installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront system to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.24 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, And Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 084113 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM.

1. Types of Kawneer Aluminum Storefront Systems include:
 - a. Trifab™ VG 451 Framing System – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Non-Thermal; Front, Center, Back, Multi-Plane, Structural Silicone or Weatherseal Glazed (Type B); Screw Spline, Shear Block, Stick or Punched Opening Fabrication.
 - b. Trifab™ VG 451 Framing System – Impact Glazing and Blast Mitigation.
 - c. Trifab™ VG 451T Framing System – 2" x 4-1/2" (50.8 mm x 114.3 mm) nominal dimension; Thermal; Front, Center, Back, Multi-Plane, Structural Silicone or Weatherseal Glazed (Type B); Screw Spline, Shear Block, Stick or Punched Opening Fabrication.
 - d. Trifab™ VG 451T Framing System – Impact Glazing and Blast Mitigation.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084329 "Sliding Storefronts"
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7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. Storefront System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR STOREFRONT FRAMING SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

1. Wind loads: Provide storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
2. Air Leakage: The test specimen shall be tested in accordance with ASTM E 283. Air Leakage rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa) with interior seal, or, rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 1.6 psf (75 Pa) without interior seal. CSA A440 Fixed Rating.

3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 8 psf (383 Pa) as defined in AAMA 501.
4. Uniform Load: A static air design load of 35 psf (1680 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
5. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.
6. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
 - a. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 - b. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)].
 - c. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS (1/4" CLEAR WITH $\epsilon = 0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS FILL, 1/4" CLEAR).

7. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 - a. Glass to Exterior – 0.47 (low-e) or 0.61 (clear) or Project Specific (____) BTU/hr/ft²/°F.
 - b. Glass to Center – 0.44 (low-e) or 0.61 (clear) or Project Specific (____) BTU/hr/ft²/°F.
 - c. Glass to Interior – 0.41 (low-e) or 0.56 (clear) or Project Specific (____) BTU/hr/ft²/°F.
8. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. Glass to Exterior – 70_{frame} and 69_{glass} (low-e) or 69_{frame} and 58_{glass} (clear).
 - b. Glass to Center – 62_{frame} and 68_{glass} (low-e) or 63_{frame} and 56_{glass} (clear).
 - c. Glass to Interior – 56_{frame} and 67_{glass} (low-e) or 54_{frame} and 58_{glass} (clear).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

9. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. Glass to Exterior – 38 (STC) and 31 (OITC).
 - b. Glass to Center – 37 (STC) and 30 (OITC).
 - c. Glass to Interior – 38 (STC) and 30 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

EDITOR NOTE: CHOOSE BLAST MITIGATION PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following B options are available:

- a. Section B-3.1.1 Dynamic analysis.
- b. Section B-3.1.2 Testing.
- c. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum-framed storefront system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum-framed storefront system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type of aluminum-framed storefront.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.

5. Flashing and drainage.

G. Other Action Submittals:

1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum-framed storefront system that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum-framed storefront system through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum-framed storefront system and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".
- G. Structural-Sealant Glazing: Comply with ASTM C 1401, "Guide for Structural Sealant Glazing" for design and installation of structural-sealant-glazed systems.
- H. Structural-Sealant Joints: Design reviewed and approved by structural-sealant manufacturer.

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum-framed storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE NON-THERMAL OR THERMAL SYSTEM AND GLASS ORIENTATION CENTER, EXTERIOR (FRONT), INTERIOR (BACK).

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Trifab™ VG 451 (Non-Thermal) or Trifab™ 451T (Thermal) Framing System
 3. Trifab™ VG 451 (Non-Thermal) or Trifab™ 451T (Thermal) Framing System (Impact Glazing and Blast Mitigation)
 4. System Dimensions: 2" x 4-1/2" (50.8 mm x 114.3 mm)
 5. Glass: Center, Exterior or Interior

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.

4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefronts for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum framing members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Thermal Barrier (Trifab™ VG 451T):
 1. Kawneer IsoLock™ Thermal Break with a 1/4" (6.4 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum storefront sections.
 - a. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- B. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action
- E. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 1. Structural Sealant: ASTM C 1184, single-component neutral-curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by a structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: Black
 2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".
- B. Entrance Door Hardware: As specified in Division 084113 Section "Door Hardware".

2.6 Accessory Materials

- A. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations), that is anchored directly to the vertical mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request or Kawneer's anodized finishes).
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront framing system.
 - 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawings including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacturer of single-source for light shelf and framing system and compatibility between the system.
- C. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- D. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- C. Structural-Sealant-Glazed Framing Members: Include accommodations for using temporary support device to retain glazing in place while structural sealant cures.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
- E. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight framed aluminum storefront system installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum-framed storefront system, accessories, and other components.
- B. Install aluminum-framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within aluminum-framed storefront to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Field Tests: Architect shall select storefront units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements. Testing Standard per AAMA 503, including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 Water Infiltration Test.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 6.2 psf (300 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum-framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084329 - SLIDING STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Sliding Storefronts, including perimeter trims, and accessories.
 1. Types of Kawneer Aluminum Sliding Storefronts include:
 - a. Series 1010 Sliding Mall Front
 - b. 1-3/8" (34.9 mm) Deep Frame

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084313 "Aluminum-Framed Storefronts"
5. 084113 "Aluminum-Framed Entrances and Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"
12. 280000 "Electronic Safety and Security"

1.3 Definitions

1. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance:
 1. Provide aluminum sliding storefronts which have been manufactured, fabricated and installed to withstand the specified uniform loads and to maintain the manufacturer's performance criteria without defects, damage or failure.
- B. Sliding Storefront Performance Requirements:
 1. The 1010 Sliding Mall Front is not intended to be used as an exterior front. It can be used as an exterior front only when air, water penetration and deflection are not critical.
 2. Operating Force: With each movable panel adjusted, the maximum force to open shall not exceed 40 lbf (178 N) and the force to keep in motion shall not exceed 25 lbf (111 N).
 3. Deglazing Force: When tested in accordance with ASTM E 987, the panel members shall not move from their original position, in relation to the glazing materials, by more than the original glazing bite.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding storefronts indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding storefronts and components required.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding storefronts. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding storefront through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding storefronts and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
1. Build mockup for type(s) of sliding storefront(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 1010 Sliding Mall Front
 3. Framing Member Profile: 1-3/8" (34.9) Deep Frame

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding storefront for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.

- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding storefront members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding storefront, provide sliding storefront manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Sliding Storefronts

- A. The 1010 Sliding Mall Front is not intended to be used as an exterior front. It can be used as an exterior front only when air, water penetration and deflection are not critical.

2.4 Glazing

- A. Glass and Glazing System: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding storefront units.
- B. Glass: Comply with Division 08 Section "Glazing" for requirements applicable to safety glazing, insulating-glass units, and laminated glass units.
- C. Glazing System: Glazing method shall be a channel type PVC gasket (marine glazed) which is compatible with aluminum and shall be resistant to deterioration by all forms of weathering and suitably retained to maintain a watertight seal between the glass and the surrounding frame.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding storefronts.
- B. Standard Hardware:
 - 1. One pair of stainless steel tandem rollers per sliding panel
 - 2. Stainless steel roller track
 - 3. Adams Rite MS 1850A-505 Hookbolt Lock
 - 4. Interior and Exterior Cylinders
 - 5. Flush Face Pulls.

2.6 Accessories

- A. Not available.

2.7 Fabrication

- A. General:
 - 1. Fabricate Components per the Manufacturer's most current Installation Instruction manuals with minimum suggested clearances and shim spacing around the perimeter of the assembly while enabling installation and dynamic movement of the perimeter seal.
 - 2. Accurately fit and secure all joints and corners. Make joints flush, hairline and waterproof.
 - 3. Prepare frames to receive anchor devices as required.
 - 4. When possible, arrange fasteners and attachments to conceal from view.
 - 5. Shop assemble frames to the greatest extent possible and shop seal all horizontal to vertical joints.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).

3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding storefront installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding storefronts, hardware, accessories, and other components.
- B. Install sliding storefronts level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding storefronts and components to drain condensation, water penetrating joints, and moisture migrating within sliding storefront to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding storefronts. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect sliding storefront surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding storefront surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding storefront surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084329

SECTION 084329 - SLIDING STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Sliding Storefronts, including perimeter trims, and accessories.
 1. Types of Kawneer Aluminum Sliding Storefronts include:
 - a. Series 1010C Sliding Mall Front
 - b. 1-3/8" (34.9 mm) Deep Frame

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084313 "Aluminum-Framed Storefronts"
5. 084113 "Aluminum-Framed Entrances and Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"
12. 280000 "Electronic Safety and Security"

1.3 Definitions

1. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance:
 1. Provide aluminum sliding storefronts which have been manufactured, fabricated and installed to withstand the specified uniform loads and to maintain the manufacturer's performance criteria without defects, damage or failure.
- B. Sliding Storefront Performance Requirements:
 1. The 1010C Sliding Mall Front is not intended to be used as an exterior front. It can be used as an exterior front only when air, water penetration and deflection are not critical.
 2. Operating Force: With each movable panel adjusted, the maximum force to open shall not exceed 40 lbf (178 N) and the force to keep in motion shall not exceed 25 lbf (111 N).
 3. Deglazing Force: When tested in accordance with ASTM E 987, the panel members shall not move from their original position, in relation to the glazing materials, by more than the original glazing bite.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding storefront indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding storefronts and components required.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding storefronts. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding storefront through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding storefronts and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
1. Build mockup for type(s) of sliding door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 1010C Sliding Mall Front
 3. Framing Member Profile: 1-3/8" (34.9) Deep Frame

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding storefront for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding storefront members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
 - 2. Sealant: For sealants required within fabricated sliding storefront, provide sliding storefront manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Sliding Storefronts

- A. The 1010C Sliding Mall Front is not intended to be used as an exterior front. It can be used as an exterior front only when air, water penetration and deflection are not critical.

2.4 Glazing

- A. Glass and Glazing System: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding storefront units.
- B. Glass: Comply with Division 08 Section "Glazing" for requirements applicable to safety glazing, insulating-glass units, and laminated glass units.
- C. Glazing System: Glazing method shall be a channel type PVC gasket (marine glazed) which is compatible with aluminum and shall be resistant to deterioration by all forms of weathering and suitably retained to maintain a watertight seal between the glass and the surrounding frame.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding storefronts.
- B. Standard Hardware:
 - 1. One pair of stainless steel tandem rollers per sliding panel
 - 2. Stainless steel roller track
 - 3. Adams Rite MS 1850A-505 Hookbolt Lock
 - 4. Interior and Exterior Cylinders
 - 5. Flush Face Pulls.

2.6 Accessories

- A. Not available.

2.7 Fabrication

- A. General:
 - 1. Fabricate Components per the Manufacturer's most current Installation Instruction manuals with minimum suggested clearances and shim spacing around the perimeter of the assembly while enabling installation and dynamic movement of the perimeter seal.
 - 2. Accurately fit and secure all joints and corners. Make joints flush, hairline and waterproof.
 - 3. Prepare frames to receive anchor devices as required.
 - 4. When possible, arrange fasteners and attachments to conceal from view.
 - 5. Shop assemble frames to the greatest extent possible and shop seal all horizontal to vertical joints.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding storefront installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding storefronts, hardware, accessories, and other components.
- B. Install sliding storefronts level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding storefronts and components to drain condensation, water penetrating joints, and moisture migrating within sliding storefront to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding storefronts. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect sliding storefront surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding storefront surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding storefront surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084329

SECTION 084329 - SLIDING STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Sliding Storefronts, including perimeter trims, and accessories.
 1. Types of Kawneer Aluminum Sliding Storefronts include:
 - a. Series 1040 Sliding Mall Front
 - b. 1-3/4" (44.5 mm) Deep Frame

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084313 "Aluminum-Framed Storefronts"
 5. 084113 "Aluminum-Framed Entrances and Storefronts"
 6. 084413 "Glazed Aluminum Curtain Walls"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 087000 "Hardware"
 11. 088000 "Glazing"
 12. 280000 "Electronic Safety and Security"

1.3 Definitions

1. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance:
 1. Provide aluminum sliding storefronts which have been manufactured, fabricated and installed to withstand the specified uniform loads and to maintain the manufacturer's performance criteria without defects, damage or failure.
- B. Sliding Storefront Performance Requirements:
 1. Wind loads: Provide sliding storefront system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
 2. Operating Force: With each movable panel adjusted, the maximum force to open shall not exceed 40 lbf (178 N) and the force to keep in motion shall not exceed 25 lbf (111 N).
 3. Deglazing Force: When tested in accordance with ASTM E 987, the panel members shall not move from their original position, in relation to the glazing materials, by more than the original glazing bite. The load for the vertical rails shall be 70 lbf and 50 lbf for all other rails.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding storefronts indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding storefronts and components required.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding storefronts. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 - 1. Sliding Storefront Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding storefront hardware, as well as procedures and diagrams. Coordinate final sliding storefront hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding storefront hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding storefront through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding storefronts and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of sliding storefront(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding storefront openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 1040 Sliding Mall Front
 - 3. Framing Member Profile: 1-3/4" (44.5) Deep Frame

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding storefront installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding storefront for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding storefront members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
 - 2. Sealant: For sealants required within fabricated sliding storefront, provide sliding storefront manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Sliding Storefront

- A. 1040 Sliding Mall Front Performance Requirements:
 - 1. Single track; parallel staggered, even and perpendicular 90 degree angle.

2.4 Glazing

- A. Glass and Glazing System: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding storefront units.
- B. Glass: Comply with Division 08 Section "Glazing" for requirements applicable to safety glazing, insulating-glass units, and laminated glass units.
- C. Glazing System: Glazing method shall be a channel type PVC gasket (marine glazed) which is compatible with aluminum and shall be resistant to deterioration by all forms of weathering and suitably retained to maintain a watertight seal between the glass and the surrounding frame.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding storefronts.
- B. Standard Hardware:
 - 1. Inboard and Outboard Casters.
 - 2. Inboard and Outboard Head Guides.
 - 3. Adams Rite MS 1850A-505 Hookbolt Lock..
 - 4. Interior and Exterior Cylinders.
 - 5. Edge Pull.
- C. Egress Door:
 - 1. Maximum door opening width: (Per Uniform Building Code) 36" (914.4) - 32" (812.8) clear at 90 degrees.
 - 2. Maximum door opening width: 42" (1066.8) (requires sidelight and/or transom for stability).
 - 3. Minimum door opening height: (Per Uniform Building Code) 80" (2032).
 - 4. Maximum door opening height: 90" (2286).
 - 5. Maximum threshold height: (Per uniform Building Code) 1/2" (12.7).
 - 6. Door cannot be hinged off of sidelight.
 - 7. Minimum light opening width of sidelight: 6-1/4" (158.8).
 - 8. Maximum light opening width of sidelight: 18" (457.2).
 - 9. Standard Hardware:
 - a. Walking beam top pivot with modified center bottom pivot.
 - b. Adams Rite M.S. 1850 A lock with two (2) cylinders.
 - 10. Optional Hardware:
 - a. Thumbturn inside in lieu of cylinder.
 - b. Adams Rite 4510 latchlock with 4656 handle in lieu of A.R.M.S.1850 A.
 - c. Adams Rite 4089 exit indicator.
 - d. Cylinder guard.
 - e. Flush pull in door.
 - 11. Not available:
 - a. Closers.
 - b. Panic Decives.
 - c. Push-pull Hardware.
 - d. Pairs of doors or double sidelighted units.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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12. Door is not intended for use by general public.
13. Door is to be locked closed before moving panel.

2.6 Accessories

- A. Not available.

2.7 Fabrication

- A. General:
 1. Fabricate Components per the Manufacturer's most current Installation Instruction manuals with minimum suggested clearances and shim spacing around the perimeter of the assembly while enabling installation and dynamic movement of the perimeter seal.
 2. Accurately fit and secure all joints and corners. Make joints flush, hairline and waterproof.
 3. Prepare frames to receive anchor devices as required.
 4. When possible, arrange fasteners and attachments to conceal from view.
 5. Shop assemble frames to the greatest extent possible and shop seal all horizontal to vertical joints.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding storefront installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding storefronts, hardware, accessories, and other components.
- B. Install sliding storefronts level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding storefronts and components to drain condensation, water penetrating joints, and moisture migrating within sliding storefront to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding storefronts. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect sliding storefront surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding storefront surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding storefront surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084329

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 1. Types of Kawneer Aluminum Curtain Wall include.
 - a. 1600 Wall System™1 Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 1) System depth: 6" (152.4) or 7-1/2" (190.5) for 1" (25.4) insulating glazing and 1/4" (6.3) monolithic glazing.
 - b. 1600 Wall System™1 IR Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 2) System depth: 7-1/2" (190.5) depth for 9/16" (14.3) and 5/8" (15.9) monolithic glazing.
 - 3) System depth: 7-13/16" (198.4) or 10-13/16" (274.6) depth for 1-5/16" (33.3) insulating glazing.
 - c. 1600 Wall System™1 Curtain Wall Blast Mitigation – 2-1/2" (63.5) sightline, outside glazed pressure plate format.
 - 4) System depth: 7-1/2" (190.5) for 1" (25.4) insulating glazing.
 - d. 1600 Wall System™1 Ribbon Curtain Wall Blast Mitigation.
 - 5) System depth: 6" (152.4) for 1" (25.4) insulating glazing.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

1. 072700 "Air Barriers".
2. 079200 "Joint Sealants".
3. 083213 "Sliding Aluminum-Framed Glass Doors".
4. 084113 "Aluminum-Framed Entrances and Storefronts".
5. 084313 "Aluminum-Framed Storefronts".
6. 084329 "Sliding Storefronts".
7. 084433 "Sloped Glazing Assemblies".
8. 085113 "Aluminum Windows".
9. 086300 "Metal-Framed Skylights".
10. 088000 "Glazing".
11. 107113 "Exterior Sun Control Devices".
12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following.
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.

- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement (elastic) of 0.010 x the story height and ultimate displacement (inelastic) of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.66 (clear) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 66_{frame} and 60_{glass} (clear).

or

Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 68_{frame} and 54_{glass} (clear).

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR HIGH PERFORMANCE INSULATING GLASS, (1/4" (E=0.035,#2), 1/2" WARM EDGE SPACER AND ARGON GAS FILL, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- K. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.43 (HP glass) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- L. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 71_{frame} and 71_{glass} (HP glass).
- M. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than:
STC 31 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4"),
STC 37 or OITC 30 based upon 1" (25.4) laminated glass (1/4" laminated, 1/2" AS, 1/4" laminated).
- N. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
1. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
2. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
- O. Blast Mitigation performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

1. Section B-3.1.1 Dynamic analysis.
2. Section B-3.1.2 Testing.
3. Section B-3.1.3 ASTM F2248 Design Approach.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.

- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following.
 - 1. Joinery.
 - 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - a. 1600 Wall System™1 Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 1) System depth: 6" (152.4) or 7-1/2" (190.5) for 1" (25.4) insulating glazing and 1/4" (6.3) monolithic glazing.
 - b. 1600 Wall System™1 IR Curtain Wall – 2-1/2" (63.5), outside glazed pressure plate format.
 - 1) System depth: 7-1/2" (190.5) depth for 9/16" (14.3) and 5/8" (15.9) monolithic glazing.
 - 2) System depth: 7-13/16" (198.4) or 10-13/16" (274.6) depth for 1-5/16" (33.3) insulating glazing.
 - c. 1600 Wall System™1 Curtain Wall Blast Mitigation – 2-1/2" (63.5) sightline, outside glazed pressure plate format.
 - 1) System depth: 7-1/2" (190.5) for 1" (25.4) insulating glazing.
 - 2) Tested to AAMA 501, ASTM E 1886, E 1996 and TAS 201, 202, 203.
 - d. 1600 Wall System™1 Ribbon Curtain Wall Blast Mitigation.
 - 1) System depth: 6" (152.4) for 1" (25.4) insulating glazing.
 - 2) Tested to AAMA 501, ASTM E 1886, E 1996 and TAS 201, 202, 203.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following.
1. Manufacturer: (_____).
 2. Series: (_____).
 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" (6.3) separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1/4" (6.3), 9/16" (14.3), 5/8" (15.9) monolithic glass or 1" (25.4), 1-5/16" (33.3) insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600 Wall System™1 Curtain Wall.
 - a. System depth: 6" (152.4) or 7-1/2" (190.5) for 1" (25.4) insulating glazing and 1/4" (6.3) monolithic glazing.
 - 2. 1600 Wall System™1 IR Curtain Wall.
 - a. System depth: 7-1/2" (190.5) depth for 9/16" (14.3) and 5/8" (15.9) monolithic glazing.
 - b. System depth: 7-13/16" (198.4) or 10-13/16" (274.6) depth for 1-5/16" (33.3) insulating glazing.
 - 3. 1600 Wall System™1 Curtain Wall Blast Mitigation.
 - a. System depth: 7-1/2" (190.5) for 1" (25.4) insulating glazing.
 - 4. 1600 Wall System™1 Ribbon Curtain Wall Blast Mitigation.
 - a. System depth: 6" (152.4) for 1" (25.4) insulating glazing.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. 1600 PowerShade™ Sun Shade System: An aluminum sunshade consisting of strut anchors and strut arms and three louvers per bay with integral amorphous silicon (photovoltaic or P.V.) panels which produce nominal 45 watts of electrical generation per bay at peak performance. Optional aluminum panels are also available, if selected, in lieu of the P.V. panels. Strut anchors and strut arms shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- C. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- D. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of.
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system).
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 - 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including.
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics.
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION**3.1 Examination**

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements.
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.

- b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 1. Types of Kawneer Aluminum Curtain Wall include.
 - a. 1600 Wall System™2 Curtain Wall – 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed, structural silicone glazed (SSG) format with 1" (25.4) insulating glass and 1/4" (6.3) monolithic glazing.
 - b. 1600 Wall System™2 IR Curtain Wall – 2-1/2" x 7-13/16" (63.5 x 198.4), outside glazed, structural silicone glazed (SSG) format with 1-5/16" (33.3) insulating glass.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

1. 072700 "Air Barriers".
2. 079200 "Joint Sealants".
3. 083213 "Sliding Aluminum-Framed Glass Doors".
4. 084113 "Aluminum-Framed Entrances and Storefronts".
5. 084313 "Aluminum-Framed Storefronts".
6. 084329 "Sliding Storefronts".
7. 084433 "Sloped Glazing Assemblies".
8. 085113 "Aluminum Windows".
9. 086300 "Metal-Framed Skylights".
10. 088000 "Glazing".
11. 107113 "Exterior Sun Control Devices".
12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following.
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____) Pa, inward and (____) lbs./sq. ft. (____) Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement (elastic) of 0.010 x the story height and ultimate displacement (inelastic) of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.57 (clear glass) or Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 68_{frame} and 59_{glass} (clear glass).

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR HIGH PERFORMANCE INSULATING GLASS, (1/4" (E=0.035,#2), 1/2" WARM EDGE SPACER AND ARGON GAS FILL, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- K. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.36 (HP glass) or Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- L. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 75_{frame} and 72_{glass} (HP glass).
or
Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 65_{frame} and 62.2_{glass} (HP glass).
- M. Sound Transmission Loss: When tested to ASTM E90, the Sound Transmission Class (STC) shall not be less than 31 and the outdoor-indoor transmission class (OITC) shall not be less than 25 based upon 1" (25.4) laminated glass (1/4" laminated, 1/2" AS, 1/4" laminated).
- N. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 1. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 2. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following.
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.

- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product.
 - 1. Kawneer Company Inc..
 - 2. 1600 Wall System™2 Curtain Wall.
 - a. Frame depth options: 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed, structural silicone glazed (SSG) format, with 1" (25.4) insulating glass and 1/4" (6.3) monolithic glazing.
 - 3. 1600 Wall System™2 IR Curtain Wall.
 - a. Frame depth options: 2-1/2" x 7-13/16" (63.5 x 198.4), outside glazed, structural silicone glazed (SSG) format, with 1-5/16" (33.3) insulating glass.
 - 4. Tested to AAMA 501, ASTM E 1886, E 1996 and TAS 201, 202, 203.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following.
 - 1. Manufacturer: (_____).
 - 2. Series: (_____).
 - 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" (6.3) separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: Structural silicone glazed (SSG).
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) and 1-5/16" (33.3) insulating glass option. 1/4" (6.3) or 1" (25.4) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600 Wall System™2 Curtain Wall: Outside glazed, structural silicone glazed (SSG) format with 1" (25.4) insulating glass.
 - 2. 1600 Wall System™2 IR Curtain Wall: Outside glazed, structural silicone glazed (SSG) format with 1-5/16" (33.3) insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes).
- C. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of.
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system).
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 - 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including.
 - 1) Plans, elevations, sections, fabrication and installation details.
 - 2) Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics.
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION**3.1 Examination**

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements.
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 1600 LR Wall™ Curtain Wall System – 2-1/2" x 5-3/4" (63.5 x 146.1) or 2-1/2" x 7-1/4" (63.5 x 184.2), outside glazed pressure plate system.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 30 psf (1437 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 1. Captured - 0.63 (clear) or Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
 2. SSG - 0.58 (clear) or Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 1. Captured - 69_{frame} and 57_{glass} (clear)
 2. SSG - 73_{frame} and 60_{glass} (clear)
 or
 Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
 1. Captured - 57_{frame} and 50_{glass} (clear)
 2. SSG - 63_{frame} and 52_{glass} (clear)

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1600 LR Wall™ Curtain Wall System.
 - 3. Frame depth options: 2-1/2" x 5-3/4" (63.5 x 146.1) or 2-1/2" x 7-1/4" (63.5 x 184.2), outside glazed pressure plate system.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Improvement: Thermal separator shall be extruded of a silicone compatible elastomer rubber that provides a minimum 3/16" separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600 LR Wall™ Curtain Wall System: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 - 4. Submittals.

- a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- C. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fitted joints.
 3. Physical and thermal isolation of glazing from framing members.
 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 5. Provisions for field replacement of glazing from exterior.
 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 2. Glass: Refer to Glass and Glazing Section.

- a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 1600 SS Curtain Wall System - 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed pressure plate or structural silicone glazed (SSG) format.
 - b. 1600 SS Curtain Wall System Blast Mitigation - 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed pressure plate or tape glazed format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 107113 "Exterior Sun Control Devices"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): The thermal transmittance (U-factor) shall not be more than:
 1. Captured - 0.65 (clear) when tested to AAMA 1503
 2. SSG - 0.58 (clear) when tested to AAMA 1503,
 or
 Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 1. Captured - 68_{frame} and 60_{glass} (clear),
 2. SSG - 72_{frame} and 62_{glass} (clear),
 or
 Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
 1. Captured - 61_{frame} and 51_{glass} (clear).
 2. SSG - 64_{frame} and 54_{glass} (clear).
- K. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than:
 Captured - STC 31 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4"),
 SSG - STC 32 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4").
- L. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria. To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 1. Section B-3.1.1 Dynamic analysis
 2. Section B-3.1.2 Testing
 3. Section B-3.1.3 ASTM F2248 Design Approach

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1600 SS Curtain Wall.
 - 3. Frame depth options: 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed captured or structural silicone glazed (SSG) format.
 - 4. 1600 SS Curtain Wall Blast Mitigation
 - 5. Frame depth options: 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed captured or tape glazed format.

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- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
1. 1600 SS Curtain Wall: Outside glazed format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.

- a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 1600 Wall System™3 Curtain Wall – 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), inside/outside glazed captured format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).

- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 50 psf (2394 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: Phase I: 3 stroke cycles using .005 x the story height – no damage or failure.
Phase II: 3 stroke cycles using .010 x the story height – no damage or failure.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.61 (clear) or Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 73_{frame} and 61_{glass} (clear),
or
Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 63_{frame} and 52_{glass} (clear).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1600 Wall System™3 Curtain Wall.
 - 3. Frame depth options: 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), inside/outside glazed captured format.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Verticals shall utilize Kawneer IsoStrut™ consisting of a rigid polymer that provides a mechanical and chemical bond between the thermal break material and extrusion. Horizontals shall utilize a silicone compatible elastomer thermal break separator which provides a minimum 14" (6.3) separation.

- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) or 1" (25.4) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 1. 1600 Wall System™3 Curtain Wall: Inside/outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.

- c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- C. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 1600 Wall System™4 Curtain Wall - 2-1/4" x 6" (57.2 x 152.4) or 2-1/4 x 7-1/2" (57.2 x 190.5), inside/outside glazed format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition

- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 50 psf (2394 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: Phase I: 3 stroke cycles using .005 x the story height – no damage or failure.
Phase II: 3 stroke cycles using .010 x the story height – no damage or failure.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.60 (clear) or Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 74_{frame} and 60_{glass} (clear),
or
Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 66_{frame} and 53_{glass} (clear).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1600 Wall System™4 Curtain Wall.
 - 3. Frame depth options: 2-1/4" x 6" (57.2 x 152.4) or 2-1/4 x 7-1/2" (57.2 x 190.5), inside/outside glazed format.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- G. Thermal Barrier: Thermal barrier shall utilize Kawneer IsoStrut™ consisting of a rigid polymer that provides a mechanical and chemical bond between the thermal break material and extrusion. Horizontals shall utilize a silicone compatible elastomer thermal break separator which provides a minimum 1/4" separation.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
1. 1600 Wall System™4 Curtain Wall: Inside/outside glazed captured format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain Wall framing system.
 - b. Storefront Framing System.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.

- c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- C. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 1600 Wall System™5 Curtain Wall – 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), inside glazed captured or outside glazed structural silicone glazed (SSG) format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
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8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition

- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 0.015 x the design displacement.
- I. Incidental Water Management Option: Head member shall be capable of directing condensation within the spandrel cavity to the exterior.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- J. Thermal Transmittance (U-factor): - When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 1. Captured - 0.74 (clear) or Project Specific (____) BTU/hr/ft² /°F per AAMA 507 or (____) BTU/hr/ft² /°F per NFRC 100.
 2. SSG - 0.62 (clear) or Project Specific (____) BTU/hr/ft² /°F per AAMA 507 or (____) BTU/hr/ft² /°F per NFRC 100.
- K. Condensation Resistance (CRF): - When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 1. Captured - 61_{frame} and 59_{glass} (clear).
 2. SSG - 71_{frame} and 62_{glass} (clear).
- L. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than:
 1. STC 32 or OITC 28 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4"),
 2. STC 37 or OITC 31 based upon 1" (25.4) laminated glass (1/4" laminated, 1/2" AS, 1/4" laminated).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.

- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1600 Wall System™5 Curtain Wall.
 - 3. Frame depth options: 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), inside glazed captured or outside glazed SSG format.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- F. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- G. Thermal Improvement: Vertical and horizontal covers shall utilize rigid PVC thermal isolator clips.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600 Wall System™5 Curtain Wall: inside glazed captured or outside glazed structural silicone glazed (SSG) format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- C. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).

- h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
- i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
- 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
- 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- D. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 6. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.

3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall units.
 1. Types of Kawneer Curtain Wall and Glazed Assemblies include:
 - a. 1600UT System™ 1 Curtain Wall:
 - 1) 1" (25.4 mm) double glazed insulating glass: 2-1/2" x 6" (63.5 mm x 152.4 mm) or 7-1/2" (63.5 mm x 190.5 mm), outside glazed pressure plate format.
 - 2) 1-3/4" (44.4 mm) triple glazed insulating glass: 2-1/2" x 6-3/4" (63.5 mm x 171.4 mm) or 8-1/4" (63.5 mm x 209.5 mm), outside glazed pressure plate format.
 - b. 1600UT System™ 2 Curtain Wall:
 - 1) 1" (25.4 mm) double glazed insulating glass: 2-1/2" x 6" (63.5 mm x 152.4 mm) or 7-1/2" (63.5 mm x 190.5 mm), outside glazed structural silicone glazed (SSG) format.
 - 2) 1-3/4" (44.4 mm) triple glazed insulating glass: 2-1/2" x 6-3/4" (63.5 mm x 171.4 mm) or 8-1/4" (63.5 mm x 209.5 mm), outside glazed structural silicone glazed (SSG) format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.

- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of () lbs./sq. ft. or () Pa, inward and () lbs./sq. ft. or () Pa, outward. The design pressures are based on the () Building Code; () Edition.
- D. Structural-Test Performance: Test according to ASTM E 330 and TAS 202 as follows:
1. When tested at positive and negative wind load design pressures, assemblies do not evidence deflection exceeding L/175 of clear span.
 2. A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction.
 - a. When tested at 150% of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2% percent of clear span.
 - b. Minimum test duration according to ASTM E 330 is 10 seconds.
- E. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Normal to Wall Plane: Limited to edge of glass in a direction perpendicular to glass plane not exceeding L/175 of the glass edge length for each individual glazing lite, or an amount that restricts edge deflection of individual glazing lites to 3/4 inch (19 mm), whichever is less. Limit deflection of clear span of framing members to L/175 for spans less than or equal to 13'-6" (4.11 meters) and L/240 + 1/4" for spans greater than 13'-6" (4.11 meters).
 2. Deflection Parallel to Glazing Plane: Limited to [L/360 of clear span or 1/8 inch (3.2 mm), whichever is smaller] [amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8 inch (3.2 mm)].
 - a. Operable Units: Provide a minimum 1/16-inch (1.6 mm) clearance between framing members and operable units.
 3. Cantilever Deflection: Where framing members overhang an anchor point, limit deflection to two times the length of cantilevered member, divided by 175.
- F. Seismic: When tested to AAMA 501.4, system must meet design displacement (elastic) of 0.010 x the story height and ultimate displacement (inelastic) of 1.5 x the design displacement.
- G. Water Penetration under Static Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to ASTM E 331 and TAS 202 at 15 psf (720 Pa).
- H. Water Penetration under Dynamic Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to AAMA 501.1 at dynamic pressure equal to 15 psf (720 Pa).
1. Maximum Water Leakage: [According to AAMA 501.1] [No uncontrolled water penetrating assemblies or water appearing on assemblies' normally exposed interior surfaces from sources other than condensation]. Water leakage does not include water controlled by flashing and gutters that is drained to exterior.
- I. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.
- J. Energy Performance: Glazed aluminum curtain walls shall be tested in accordance with NFRC and AAMA Standards.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" OR 1-3/4" CLEAR HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E, ARGON FILLED, WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

1. Thermal Transmittance (U-factor):
 - a. 1600UT System™1 Curtain Wall:
 - 1) Glass and framing areas shall have U-factor of no greater than 0.33 with 1" (25.4 mm) High Performance (HP) Glass as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.
 - 2) Glass and framing areas shall have U-factor of no greater than 0.24 with 1-3/4" (44.4 mm) High Performance (HP) Triple Glazed as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.

EDITOR NOTE: FOR IMPROVED U-FACTORS WITH FIBER GLASS PRESSURE PLATE BASED ON AAMA 507/NFRC100 SIMULATIONS PLEASE REFER TO THERMAL CHARTS IN ARCHITECTURAL DETAIL MANUAL, AVAILABLE ON KAWNEER.COM.

- b. 1600UT System™2 Curtain Wall:
 - 1) Project specific U-factor () BTU/Hr/Ft²/°F with 1" (25.4 mm) Glass as determined per AAMA 507 or NFRC 100.
 - 2) Project specific U-factor () BTU/Hr/Ft²/°F with 1-3/4" (44.4 mm) Triple Glazed Glass as determined per AAMA 507 or NFRC 100.

EDITOR NOTE: FOR IMPROVED U-FACTORS WITH FIBER GLASS PRESSURE PLATE BASED ON AAMA 507/NFRC100 SIMULATIONS PLEASE REFER TO THERMAL CHARTS IN ARCHITECTURAL DETAIL MANUAL, AVAILABLE ON KAWNEER.COM.

2. Solar Heat Gain Coefficient: Glass and framing areas shall have a solar heat gain coefficient of no greater than [0.35] [0.40] [0.45] <Insert value> as determined according to NFRC 200.

3. Air Leakage: Maximum air leakage through fixed glazing and framing areas of 0.06 cfm/sq.ft. (0.31 l/s.m²) of fixed wall area as determined according to ASTM E 283 and TAS 202 at a minimum static-air-pressure differential of 6.2 psf (300 Pa).
4. Condensation Resistance: When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 1600UT System™1 Curtain Wall:
 - 1) CRF_{glass} (1" [25.4 mm] Double Glazed HP) = 76, CRF_{frame} = 79
 - 2) CRF_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 81, CRF_{frame} = 82
5. Temperature Index (I): when tested to CSA-A440-00, the Temperature Index shall not be less than:
 - a. 1600UT System™1 Curtain Wall with aluminum pressure plate:
 - 1) I_{glass} (1" [25.4 mm] Double Glazed HP) = 67, I_{frame} = 71
 - 2) I_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 77, I_{frame} = 74
 - b. 1600UT System™1 Curtain Wall with fiber glass pressure plate:
 - 1) I_{glass} (1" [25.4 mm] Double Glazed HP) = 68, I_{frame} = 76
 - 2) I_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 78, I_{frame} = 76
- K. Storm Shelter Performance:
 1. Shall be tested to meet ICC500: ICC / NSSA Standard for the design and construction of storm shelters.
 2. Missile Criteria for tornado shelters.
 - a. Design Wind Speed:
 - 1) 200 mph (EF4)
 - 2) 240 mph (EF5)
 - b. Missile Speed:
 - 1) 90 mph (EF4)
 - 2) 100 mph (EF5)
- L. Sound Transmission: Provide glazed aluminum curtain walls with fixed glazing and framing areas having the following sound-transmission characteristics:
 1. 1600UT System™1 Curtain Wall:
 - a. STC-31 or OITC-25 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1" (25.4 mm) double insulating glass (1/4", 1/2" AS, 1/4")
 - b. STC-33 or OITC-27 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1-3/4" (44.4 mm) triple insulating glass (1/4", 1/2" AS, 1/4", 1/2" AS, 1/4").

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. 1600UT System™1 Curtain Wall or 1600UT System™2 Curtain Wall
 3. Frame depth options: 6" (152.4 mm) & 7-1/2" (190.5 mm) with 1" (25.4 mm) Double Glazed Insulating Glass; 6-3/4" (171.4 mm) & 8-1/4" (209.5 mm) with 1-3/4" (44.4 mm) Triple Glazed Insulating Glass
 4. Tested to AAMA 501-05 and TAS 202

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be either aluminum or fiberglass and fastened to the mullion with stainless steel screws. Fiberglass pressure plate shall be tested to ASTM D638, D790, D695, D953, D3846.

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- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal barrier consists of 1" (25.4 mm) separation between the interior and exterior metal members in a typical condition. Thermal barrier assembly shall be tested to the thermal cycling requirements of ASTM E2692 and show no sign of degradation following the test.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4-sided captured or 2-sided SSG.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4 mm) and 1-3/4" (44.4 mm) insulating glass option. 1/4" (6.3 mm) or 1" (25.4 mm) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600UT System™1 Curtain Wall: Outside glazed pressure plate format with 1" (25.4 mm) double glazed and 1-3/4" (44.4 mm) triple glazed insulating glass.
 - 2. 1600UT System™2 Curtain Wall: Outside glazed structural silicone glazed (SSG) format with 1" (25.4 mm) double glazed and 1-3/4" (44.4 mm) triple glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- C. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.

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- c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
- a. Curtain wall framing system.
 - b. Storefront Framing System.
4. Submittals.
- a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- D. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
- 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
 - 8. Double seal design with primary air and vapor barrier at interior side of glazed aluminum curtain wall and secondary seal weeped and vented to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
- 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
 - 1. Comply with manufacturer's written instructions.
 - 2. Do not install damaged components.
 - 3. Fit joints to produce hairline joints free of burrs and distortion.
 - 4. Rigidly secure non-movement joints.
 - 5. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 - 6. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 - 7. Seal joints watertight unless otherwise indicated.
- B. Metal Protection:
 - 1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 - 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- D. Install components plumb and true in alignment with established lines and grades.
- E. Install operable units level and plumb, securely anchored, and without distortion. Adjust weather-stripping contact and hardware movement to produce proper operation.
- F. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- G. Install glazing as specified in Division 08 Section "Glazing."

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Leakage Tests: Conduct tests in accordance with ASTM E 783. Allowable air leakage shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall units.
 1. Types of Kawneer Curtain Wall and Glazed Assemblies include:
 - a. 1600UT System™ 1 Curtain Wall:
 - 1) 1" (25.4 mm) double glazed insulating glass: 2-1/2" x 6" (63.5 mm x 152.4 mm) or 7-1/2" (63.5 mm x 190.5 mm), outside glazed pressure plate format.
 - 2) 1-3/4" (44.4 mm) triple glazed insulating glass: 2-1/2" x 6-3/4" (63.5 mm x 171.4 mm) or 8-1/4" (63.5 mm x 209.5 mm), outside glazed pressure plate format.
 - b. 1600UT System™ 2 Curtain Wall:
 - 1) 1" (25.4 mm) double glazed insulating glass: 2-1/2" x 6" (63.5 mm x 152.4 mm) or 7-1/2" (63.5 mm x 190.5 mm), outside glazed structural silicone glazed (SSG) format.
 - 2) 1-3/4" (44.4 mm) triple glazed insulating glass: 2-1/2" x 6-3/4" (63.5 mm x 171.4 mm) or 8-1/4" (63.5 mm x 209.5 mm), outside glazed structural silicone glazed (SSG) format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.

- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of () lbs./sq. ft. or () Pa, inward and () lbs./sq. ft. or () Pa, outward. The design pressures are based on the () Building Code; () Edition.
- D. Structural-Test Performance: Test according to ASTM E 330 and TAS 202 as follows:
1. When tested at positive and negative wind load design pressures, assemblies do not evidence deflection exceeding L/175 of clear span.
 2. A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction.
 - a. When tested at 150% of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2% percent of clear span.
 - b. Minimum test duration according to ASTM E 330 is 10 seconds.
- E. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Normal to Wall Plane: Limited to edge of glass in a direction perpendicular to glass plane not exceeding L/175 of the glass edge length for each individual glazing lite, or an amount that restricts edge deflection of individual glazing lites to 3/4 inch (19 mm), whichever is less. Limit deflection of clear span of framing members to L/175 for spans less than or equal to 13'-6" (4.11 meters) and L/240 + 1/4" for spans greater than 13'-6" (4.11 meters).
 2. Deflection Parallel to Glazing Plane: Limited to [L/360 of clear span or 1/8 inch (3.2 mm), whichever is smaller] [amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8 inch (3.2 mm)].
 - a. Operable Units: Provide a minimum 1/16-inch (1.6 mm) clearance between framing members and operable units.
 3. Cantilever Deflection: Where framing members overhang an anchor point, limit deflection to two times the length of cantilevered member, divided by 175.
- F. Seismic: When tested to AAMA 501.4, system must meet design displacement (elastic) of 0.010 x the story height and ultimate displacement (inelastic) of 1.5 x the design displacement.
- G. Water Penetration under Static Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to ASTM E 331 and TAS 202 at 15 psf (720 Pa).
- H. Water Penetration under Dynamic Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to AAMA 501.1 at dynamic pressure equal to 15 psf (720 Pa).
1. Maximum Water Leakage: [According to AAMA 501.1] [No uncontrolled water penetrating assemblies or water appearing on assemblies' normally exposed interior surfaces from sources other than condensation]. Water leakage does not include water controlled by flashing and gutters that is drained to exterior.
- I. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.
- J. Energy Performance: Glazed aluminum curtain walls shall be tested in accordance with NFRC and AAMA Standards.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" OR 1-3/4" CLEAR HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E, ARGON FILLED, WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

1. Thermal Transmittance (U-factor):
 - a. 1600UT System™1 Curtain Wall:
 - 1) Glass and framing areas shall have U-factor of no greater than 0.33 with 1" (25.4 mm) High Performance (HP) Glass as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.
 - 2) Glass and framing areas shall have U-factor of no greater than 0.24 with 1-3/4" (44.4 mm) High Performance (HP) Triple Glazed as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.

EDITOR NOTE: FOR IMPROVED U-FACTORS WITH FIBER GLASS PRESSURE PLATE BASED ON AAMA 507/NFRC100 SIMULATIONS PLEASE REFER TO THERMAL CHARTS IN ARCHITECTURAL DETAIL MANUAL, AVAILABLE ON KAWNEER.COM.

- b. 1600UT System™2 Curtain Wall:
 - 1) Project specific U-factor () BTU/Hr/Ft²/°F with 1" (25.4 mm) Glass as determined per AAMA 507 or NFRC 100.
 - 2) Project specific U-factor () BTU/Hr/Ft²/°F with 1-3/4" (44.4 mm) Triple Glazed Glass as determined per AAMA 507 or NFRC 100.

EDITOR NOTE: FOR IMPROVED U-FACTORS WITH FIBER GLASS PRESSURE PLATE BASED ON AAMA 507/NFRC100 SIMULATIONS PLEASE REFER TO THERMAL CHARTS IN ARCHITECTURAL DETAIL MANUAL, AVAILABLE ON KAWNEER.COM.

2. Solar Heat Gain Coefficient: Glass and framing areas shall have a solar heat gain coefficient of no greater than [0.35] [0.40] [0.45] <Insert value> as determined according to NFRC 200.

3. Air Leakage: Maximum air leakage through fixed glazing and framing areas of 0.06 cfm/sq.ft. (0.31 l/s.m²) of fixed wall area as determined according to ASTM E 283 and TAS 202 at a minimum static-air-pressure differential of 6.2 psf (300 Pa).
4. Condensation Resistance: When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 1600UT System™1 Curtain Wall:
 - 1) CRF_{glass} (1" [25.4 mm] Double Glazed HP) = 76, CRF_{frame} = 79
 - 2) CRF_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 81, CRF_{frame} = 82
5. Temperature Index (I): when tested to CSA-A440-00, the Temperature Index shall not be less than:
 - a. 1600UT System™1 Curtain Wall with aluminum pressure plate:
 - 1) I_{glass} (1" [25.4 mm] Double Glazed HP) = 67, I_{frame} = 71
 - 2) I_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 77, I_{frame} = 74
 - b. 1600UT System™1 Curtain Wall with fiber glass pressure plate:
 - 1) I_{glass} (1" [25.4 mm] Double Glazed HP) = 68, I_{frame} = 76
 - 2) I_{glass} (1-3/4" [44.4 mm] Triple Glazed HP) = 78, I_{frame} = 76
- K. Storm Shelter Performance:
 1. Shall be tested to meet ICC500: ICC / NSSA Standard for the design and construction of storm shelters.
 2. Missile Criteria for tornado shelters.
 - a. Design Wind Speed:
 - 1) 200 mph (EF4)
 - 2) 240 mph (EF5)
 - b. Missile Speed:
 - 1) 90 mph (EF4)
 - 2) 100 mph (EF5)
- L. Sound Transmission: Provide glazed aluminum curtain walls with fixed glazing and framing areas having the following sound-transmission characteristics:
 1. 1600UT System™1 Curtain Wall:
 - a. STC-31 or OITC-25 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1" (25.4 mm) double insulating glass (1/4", 1/2" AS, 1/4")
 - b. STC-33 or OITC-27 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1-3/4" (44.4 mm) triple insulating glass (1/4", 1/2" AS, 1/4", 1/2" AS, 1/4").

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. 1600UT System™1 Curtain Wall or 1600UT System™2 Curtain Wall
 3. Frame depth options: 6" (152.4 mm) & 7-1/2" (190.5 mm) with 1" (25.4 mm) Double Glazed Insulating Glass; 6-3/4" (171.4 mm) & 8-1/4" (209.5 mm) with 1-3/4" (44.4 mm) Triple Glazed Insulating Glass
 4. Tested to AAMA 501-05 and TAS 202

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be either aluminum or fiberglass and fastened to the mullion with stainless steel screws. Fiberglass pressure plate shall be tested to ASTM D638, D790, D695, D953, D3846.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal barrier consists of 1" (25.4 mm) separation between the interior and exterior metal members in a typical condition. Thermal barrier assembly shall be tested to the thermal cycling requirements of ASTM E2692 and show no sign of degradation following the test.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4-sided captured or 2-sided SSG.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4 mm) and 1-3/4" (44.4 mm) insulating glass option. 1/4" (6.3 mm) or 1" (25.4 mm) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600UT System™1 Curtain Wall: Outside glazed pressure plate format with 1" (25.4 mm) double glazed and 1-3/4" (44.4 mm) triple glazed insulating glass.
 - 2. 1600UT System™2 Curtain Wall: Outside glazed structural silicone glazed (SSG) format with 1" (25.4 mm) double glazed and 1-3/4" (44.4 mm) triple glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).
- C. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.

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- c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
- a. Curtain wall framing system.
 - b. Storefront Framing System.
4. Submittals.
- a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- D. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
- 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
 - 8. Double seal design with primary air and vapor barrier at interior side of glazed aluminum curtain wall and secondary seal weeped and vented to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
- 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permardize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
 - 1. Comply with manufacturer's written instructions.
 - 2. Do not install damaged components.
 - 3. Fit joints to produce hairline joints free of burrs and distortion.
 - 4. Rigidly secure non-movement joints.
 - 5. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 - 6. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 - 7. Seal joints watertight unless otherwise indicated.
- B. Metal Protection:
 - 1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 - 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- D. Install components plumb and true in alignment with established lines and grades.
- E. Install operable units level and plumb, securely anchored, and without distortion. Adjust weather-stripping contact and hardware movement to produce proper operation.
- F. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- G. Install glazing as specified in Division 08 Section "Glazing."

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Leakage Tests: Conduct tests in accordance with ASTM E 783. Allowable air leakage shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 1602 Wall System – 2" x 4-15/16" (50.8 x 125.4) or 6-1/16" (153.9), outside glazed pressure plate format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084433 "Sloped Glazing Assemblies"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 088000 "Glazing"
 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).

- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 10 psf (479 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 10 psf (479 Pa) as defined in AAMA 501.
- G. Structural performance shall be based on Aluminum Association "Specification for Aluminum Structures" or CSA Standard CAN3-S157 "Strength Design in Aluminum". There shall be no deflection in excess of L/175 of the span of any framing member at design load.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR HIGH PERFORMANCE INSULATING GLASS, (1/4" (E=0.035,#2), 1/2" HELIMA WARM EDGE SPACER AND ARGON GAS FILL, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- H. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than 0.40 (low-e).
- I. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 68_{frame} and 67_{glass} (low-e),
or
Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than Captured - 57_{frame} and 60_{glass} (clear).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1602 Wall System.
 - 3. Frame depth options: 2" x 4-15/16" (50.8 x 125.4) or 6-1/16" (153.9), outside glazed pressure plate format.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 3/16" separation.

- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
1. 1602 Wall System: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.

- c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- C. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.

1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 1620/1620 SSG Curtain Wall System – 2" x 6" (50.8 x 152.4) or 2" x 7-1/2" (50.8 x 190.5), outside glazed pressure plate or structural silicone glazed (SSG) format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.

- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (cyclic): The test specimen shall be tested in accordance with ASTM E 547. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Water Resistance, (severe, wind driven rain): The test specimen shall be tested in accordance with AAMA 520 and ASTM E2268. There shall be no visible water at performance level 10, pressure limits 14 psf (670 Pa) – 42 psf (2010 Pa).
- H. Uniform Load: A static air design load of 42 psf (2010 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR HIGH PERFORMANCE INSULATING GLASS, (1/4" (E=0.035,#2), 1/2" WARM EDGE SPACER AND ARGON GAS FILL, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

Captured

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.37 (HP glass) or Project Specific (____) BTU/hr/ft² /°F. per AAMA 507 or (____) BTU/hr/ft² /°F. per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 75_{frame} and 71_{glass} (HP glass).
or
Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 70_{frame} and 63_{glass} (HP glass).
- K. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than: STC 34 or OITC 29 based upon 1" (25.4) laminated glass (1/4", 1/2" AS, 1/4" laminated).

SSG

- L. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.38 (HP glass) or Project Specific (____) BTU/hr/ft² /°F. per AAMA 507 or (____) BTU/hr/ft² /°F. per NFRC 100.
- M. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 76_{frame} and 70_{glass} (HP glass).
or
Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 67_{frame} and 59_{glass} (HP glass).
- N. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than: STC 34 or OITC 28 based upon 1" (25.4) laminated glass (1/4", 1/2" AS, 1/4" laminated).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.

- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1620/1620 SSG Curtain Wall System.
 - 3. Frame depth options: 2" x 6" (50.8 x 152.4) or 2" x 7-1/2" (50.8 x 190.5), outside glazed pressure plate or structural silicone glazed (SSG) format.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides for a minimum separation from interior to exterior metal of 1/4" (6mm).
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.4) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
 5. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fitted joints.
 3. Physical and thermal isolation of glazing from framing members.
 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 5. Provisions for field replacement of glazing from exterior.
 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION**3.1 Examination**

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

SECTION 084413 - GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall units.
 1. Types of Kawneer Curtain Wall and Glazed Assemblies include:
 - a. 1630 SS IR Curtain Wall System: (Hurricane Impact and Blast Mitigation) - 3" x 7-13/16" (76.2 x 198.4) or 8-13/16" (76.2 x 223.8), outside glazed pressure plate format, with 1-5/16" (33.3) laminated insulating glass.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY CONTROL.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Structural-Test Performance: Test according to ASTM E 330 and TAS 202 as follows:
 1. When tested at positive and negative wind load design pressures, assemblies do not evidence deflection exceeding L/180 of clear span.
 2. A static air design load of 130 psf (6224.4 Pa) shall be applied in the positive and negative direction.

- a. When tested at 150% of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2% percent of clear span.
 - b. Minimum test duration according to TAS 202 is 30 seconds.
- E. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Normal to Wall Plane: Limited to edge of glass in a direction perpendicular to glass plane not exceeding L/180 of the glass edge length for each individual glazing lite, or an amount that restricts edge deflection of individual glazing lites to 3/4 inch (19 mm), whichever is less. Limit deflection of clear span of framing members to L/180 for spans less than or equal to 13'-6" (4.11 meters) and L/240 + 1/4" for spans greater than 13'-6" (4.11 meters).
 2. Deflection Parallel to Glazing Plane: Limited to [L/360 of clear span or 1/8" (3.2 mm), whichever is smaller] [amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8" (3.2 mm)].
 - a. Operable Units: Provide a minimum 1/16" (1.6 mm) clearance between framing members and operable units.
 3. Cantilever Deflection: Where framing members overhang an anchor point, limit deflection to two times the length of cantilevered member, divided by 175.
- F. Water Penetration under Static Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to ASTM E 331 and TAS 202 at 15psf (720 Pa).
- G. Water Penetration under Dynamic Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to AAMA 501.1 at dynamic pressure equal to 15psf (720 Pa).
1. Maximum Water Leakage: [According to AAMA 501.1] [No uncontrolled water penetrating assemblies or water appearing on assemblies' normally exposed interior surfaces from sources other than condensation]. Water leakage does not include water controlled by flashing and gutters that is drained to exterior.
- H. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)].
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.
- I. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
1. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 2. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
- J. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria. To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
1. Section B-3.1.1 Dynamic analysis
 2. Section B-3.1.2 Testing
 3. Section B-3.1.3 ASTM F2248 Design Approach
- K. Energy Performance: Glazed aluminum curtain walls shall be tested in accordance with NFRC and AAMA Standards.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" OR 1-3/4" CLEAR HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E, ARGON FILLED, WITH WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

1. Thermal Transmittance (U-factor):
 - a. 1630 SS IR Curtain Wall System:
 - 1) Glass and framing areas shall have U-factor of no greater than 0.44 with 1-5/16" (33.3) High Performance (HP) Glass as determined according to AAMA 1503 or Project specific (___) BTU/Hr/Ft²/°F per AAMA 507 or (___) BTU/Hr/Ft²/°F per NFRC 100.
 2. Solar Heat Gain Coefficient: Glass and framing areas shall have a solar heat gain coefficient of no greater than [0.20] [0.25] [0.30] <Insert value> as determined according to NFRC 200.
 3. Air Infiltration: Maximum air leakage through fixed glazing and framing areas of 0.06 cfm/sq.ft. (0.31 l/s.m²) of fixed wall area as determined according to ASTM E 283 and TAS 202 at a minimum static-air-pressure differential of 6.24 psf (300 Pa).
 4. Condensation Resistance: When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. 1630 SS IR:
 - 1) CRF_{glass} (1-5/16" 1G HP) = 70, CRF_{frame} = 74
 5. Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
 - a. 1630 SS IR aluminum pressure plate:
 - 1) I_{glass} (1-5/16" 1G HP) = 63, I_{frame} = 67
- L. Sound Transmission: Provide glazed aluminum curtain walls with fixed glazing and framing areas having the following sound-transmission characteristics:
1. 1630 SS IR:
 - a. (STC = 37) or (OITC = 32) when tested for laboratory sound transmission loss according to AAMA 1801, ASTM E 90 and ASTM E 1425, and based on 1-5/16" (33.3) laminated insulating glass (1/4", 1/2" AS, 1/4").

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery
 - 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR'S NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1630 SS IR Curtain Wall System: 3" (76.2) sightline.
 - 3. Frame depth options:
 - a. Hurricane Impact and Blast Mitigation: 7-13/16" and 8-13/16" with 1-5/16" (33.3) Laminated Insulating Glass.
 - 4. Tested to AAMA 501-05 and ASTM E 1886, E 1996 and TAS 201, 202, 203.

EDITOR'S NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal barrier consists of 9/16" (14.25 mm) separation between the interior and exterior metal members in a typical condition.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1-5/16" (33.3) laminated insulating glass for vision and Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1630 SS IR Curtain Wall: Outside glazed pressure plate format with 1-5/16" (33.3) laminated insulating glass.
 - 2. 1630 SS IR Curtain Wall Blast Mitigation: Outside glazed pressure plate format with 1" laminated insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using screw spline system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
1. Comply with manufacturer's written instructions.
 2. Do not install damaged components.
 3. Fit joints to produce hairline joints free of burrs and distortion.
 4. Rigidly secure non-movement joints.
 5. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 6. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 7. Seal joints watertight unless otherwise indicated.
- B. Metal Protection:
1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- D. Install components plumb and true in alignment with established lines and grades.
- E. Install operable units level and plumb, securely anchored, and without distortion. Adjust weather-stripping contact and hardware movement to produce proper operation.
- F. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- G. Install glazing as specified in Division 08 Section "Glazing."

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 10 psf (479 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 2250 IG Curtain Wall System – 2-1/4" x 4-1/2" (57.2 x 114.3) or 2-1/4" x 6" (57.2 x 108) or 2-1/4" x 7-1/2" (57.2 x 190.5), for 1" (25.4) infill, inside glazed captured or outside glazed structural silicone (SSG) format.
 - b. 2250 IG Curtain Wall System – 2-1/4" x 5-1/4" (57.2 x 133.4) or 2-1/4" x 6-3/4" (57.2 x 171.5), for 1/4" (6.4) infill, inside glazed captured or outside glazed structural silicone (SSG) format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 0.015 x the design displacement.
- I. Incidental Water Management Option: Head member shall be capable of directing condensation within the spandrel cavity to the exterior.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" (25.4) CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- J. Thermal Transmittance (U-factor): - When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than:
 1. Captured - 0.69 (clear) or Project Specific (____) BTU/hr/ft² /°F. per AAMA 507 or (____) BTU/hr/ft² /°F. per NFRC 100.
 2. SSG - 0.64 (clear) or Project Specific (____) BTU/hr/ft² /°F. per AAMA 507 or (____) BTU/hr/ft² /°F. per NFRC 100.
- K. Condensation Resistance (CRF): - When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 1. Captured - 61_{frame} and 57_{glass} (clear).
 2. SSG - 71_{frame} and 61_{glass} (clear).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 2250 IG Curtain Wall System - inside glazed captured or outside glazed structural silicone (SSG) format.
 - 3. Frame depth options:
 - a. 2-1/4" x 4-1/2" (57.2 x 114.3) or 2-1/4" x 6" (57.2 x 108) or 2-1/4" x 7-1/2" (57.2 x 190.5), for 1" (25.4) infill.
 - b. 2-1/4" x 5-1/4" (57.2 x 133.4) or 2-1/4" x 6-3/4" (57.2 x 171.5), for 1/4" (6.4) infill.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- F. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- G. Thermal Barrier: Vertical and horizontal covers shall utilize rigid PVC thermal isolator clips.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1/4" (6.4) laminated or 1" (25.4) insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Inside glazed captured or outside glazed SSG format with 1" double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 - 4. Submittals.

- a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- C. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fitted joints.
 3. Physical and thermal isolation of glazing from framing members.
 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 6. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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END OF SECTION 084413

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Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 2250 L•R (low-rise) Wall System – 2-1/4" x 5" (57.2 x 127) or 2-1/4" x 7-1/4" (57.2 x 190.5) nominal dimension for 1" (25.4) infill; outside glaze, thermal, pressure plate system.
 - b. 2250 L•R (low-rise) Wall System – 2-1/4" x 4-1/4" (57.2 x 108) or 2-1/4" x 6-1/2" (57.2 x 165.1) nominal dimension for 1/4" (6.4) infill; outside glaze, thermal, pressure plate system.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
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- 7. 084433 "Sloped Glazing Assemblies"
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- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (Static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 10 psf (479 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 10 psf (479 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 30 psf (1437 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA1503 OR CSA A440 ARE BASED UPON 1" (25.4) CLEAR INSULATING GLASS. (1/4", 1/2" AS 1/4"). REFER TO THERMAL CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- H. Thermal Transmittance (U-factor): The (U-factor) shall not be more than:
 1. Captured – 0.60 (clear) per AAMA 1503 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
 2. SSG – 0.55 (clear) or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- I. Condensation Resistance (CRF): When tested to AAMA 1503, the CRF shall not be less than:
 1. Captured – 74_{frame} and 60_{glass} (clear).
 2. SSG – 75_{frame} and 60_{glass} (clear).
 or
 Condensation Index (I): When tested in accordance with CSA-A440-00, the Condensation Index shall not be less than:
 1. Captured – 67_{frame} and 54_{glass} (clear).
 2. SSG – 70_{frame} and 56_{glass} (clear).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 2250 L•R (low-rise) Wall System.
 - 3. Frame depth options:
 - a. 2-1/4" x 5" (57.2 x 127) or 2-1/4" x 7-1/4" (57.2 x 190.5) nominal dimension for 1" (25.4) infill.
 - b. 2-1/4" x 4-1/4" (57.2 x 108) or 2-1/4" x 6-1/2" (57.2 x 165.1) nominal dimension for 1/4" (6.4) infill.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: A minimum 1/4" (6.4) separation between the interior and exterior aluminum created by intermittent polymer clips.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4 insulating glass option. 1/4" (6.4) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Outside glazed pressure plate format with 1" double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 - 4. Submittals.

- a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- C. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permادcoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 2500 PG Wall™ Curtain Wall System – 2-1/2" x 7-1/2" (63.5 x 190.5) nominal dimension, Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - b. 2500 PG Wall™ Curtain Wall System (Impact Glazing) Zone 3, Level D – 2-1/2" x 7-1/2" (63.5 x 190.5) nominal dimension, Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide curtain wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (Static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any curtain wall member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the curtain wall members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA1503 OR CSA A440 ARE BASED UPON 1" (25.4) CLEAR INSULATING GLASS (1/4", 1/2" AS 1/4"). REFER TO THERMAL CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): The (U-factor) shall not be more than: 0.65 (clear) per AAMA 1503 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA 1503, the CRF shall not be less than: Captured – 69_{frame} and 58_{glass} (clear).
or
- K. Condensation Index (I): When tested in accordance with CSA-A440-00, the Condensation Index shall not be less than: Captured – 58_{frame} and 43.6_{glass} (clear).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" (25.4) CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

- L. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than 35 (STC) and 28 (OITC).
- M. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 1. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 2500 PG Wall™ Curtain Wall System - Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - 3. 2500 PG Wall™ Curtain Wall System (Impact Glazing) Zone 3, Level D - Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - 4. Frame depth options: 2-1/2" x 7-1/2" (63.5 x 190.5)
 - 5. Tested to AAMA 501

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 7500 Wall™ Curtain Wall System – 2-1/2" x 6-5/16" (63.5 x 160.3) or 2-1/2" x 7-5/16" (63.5 x 185.7), outside glazed pressure plate format.
 - 1) 7525 Wall™ with 1" (25.4) double glazing.
 - 2) 7550 Wall™ with 1-3/4" (44.4) triple glazing.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s· m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331 and ASTM E 547. There shall be no leakage at a static air pressure differential of 15 psf (720 Pa) as defined in AAMA 501.
- F. Structural performance shall be based on Aluminum Association "Specification for Aluminum Structures" or CSA Standard CAN3-S157 "Strength Design in Aluminum". There shall be no deflection in excess of L/175 of the span of any framing member at design load.

EDITOR NOTE: FOR 7525 WALL THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" (25.4 MM) DOUBLE GLAZED INSULATING GLASS UNIT WITH LOW EMISSIVITY COATING ON SURFACE 2, ARGON GAS FILLED INTERSPACE AND A HELIMA WARM EDGE GLAZING SPACER.

- G. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.36 BTU/hr· ft²· °F (2.02 W/m²· °C) or Project Specific () BTU/hr/ft² /°F, per AAMA 507 or () BTU/hr/ft² /°F, per NFRC 100.
- H. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 83_{frame} and 72_{glass}, or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 76_{frame} and 65_{glass}.

EDITOR NOTE: FOR 7550 WALL THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 2" (50 MM) TRIPLE GLAZED INSULATING GLASS UNIT WITH LOW EMISSIVITY COATING ON SURFACE 2 AND 5, TWO ARGON GAS FILLED INTERSPACES AND HELIMA WARM EDGE GLAZING SPACERS.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.17 BTU/hr· ft²· °F (0.98 W/m²· °C).
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 85_{frame} and 80_{glass}, or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than 77_{frame} and 76_{glass}.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 7500 Wall™ Curtain Wall System.
 - a. 7525 Wall™ for 1" (25.4) double glazing.
 - b. 7550 Wall™ for 1-3/4" (44.4) triple glazing.
 - 3. Frame depth options: 2-1/2" x 6-5/16" (63.5 x 160.3) or 2-1/2" x 7-5/16" (63.5 x 185.7).
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Kawneer IsoWeb™ Thermal Break: All framing members shall consist of interior and exterior extruded aluminum sections that shall be integrated with two parallel, glass reinforced nylon strips forming a continuous composite assembly.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) or 1-3/4" (44.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Outside glazed pressure plate format with 1" (25.4) double or 1-3/4" (44.4) triple glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 - 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 - 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 - 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.

- 4. Submittals.
 - a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- C. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadoze™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. Clearwall™ Curtain Wall System - SS (Screw Spline)
 - 1) Clearwall™ (SS): 2-1/2" x 6-5/8" (63.5 x 168.3) or 2-1/2" x 5-1/8" (63.5 x 130.2), outside glazed with recessed glass edge spacer by qualified Insulated Glass Unit (IGU) manufacturer.
 - 2) Clearwall™ (SSI): 2-1/2" x 7-1/2" (63.5 x 190.5) or 2-1/2" x 6" (63.5 x 152.4), outside glazed with metal interfaced insulating glass (interface shop applied with structural silicone).
 - 3) Clearwall™ (SSIT): 2-1/2" x 7-3/8" (63.5 x 187.0) or 2-1/2" x 5-7/8" (63.5 x 149.0), outside glazed with metal interfaced insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).
 - b. Clearwall™ Curtain Wall System - SB (Shear Block)
 - 1) Clearwall™ (SB): 2-1/2" x 10-1/8" (63.5 x 257.2), outside glazed with recessed glass edge spacer by qualified Insulated Glass Unit (IGU) manufacturer.
 - 2) Clearwall™ (SBI): 2-1/2" x 11" (63.5 x 279.4), outside glazed with metal interfaced insulating glass (interface shop applied with structural silicone).
 - 3) Clearwall™ (SBIT): 2-1/2" x 10-27/32" (63.5 x 275.4), outside glazed with metal interfaced insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.

- b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____) Pa, inward and (____) lbs./sq. ft. or (____) Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Structural-Test Performance: Test according to ASTM E 330 and TAS 202 as follows:
1. When tested at positive and negative wind load design pressures, assemblies do not evidence deflection exceeding L/175 of clear span.
 2. A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction.
 - a. When tested at 150% of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2% percent of clear span.
 - b. Minimum test duration according to ASTM E 330 is 10 seconds.
- E. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Normal to Wall Plane: Limited to edge of glass in a direction perpendicular to glass plane not exceeding L/175 of the glass edge length for each individual glazing lite, or an amount that restricts edge deflection of individual glazing lites to 3/4 inch (19 mm), whichever is less.
 2. Deflection Parallel to Glazing Plane: Limited to [L/360 of clear span or 1/8 inch (3.2 mm), whichever is smaller] [amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8 inch (3.2 mm)].
 - a. Operable Units: Provide a minimum 1/16-inch (1.6-mm) clearance between framing members and operable units.
 3. Cantilever Deflection: Where framing members overhang an anchor point, limit deflection to two times the length of cantilevered member, divided by 175.
- F. Seismic Story Drift: Accommodate design displacement of adjacent stories indicated.
1. Design Displacement: Shall not exceed 1% of story height.
 2. Test Performance: Meeting criteria for passing based on building occupancy type when tested according to AAMA 501.4 at design displacement and 1.5 times the design displacement.
- G. Water Penetration under Static Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to ASTM E 331 and TAS 202 at 15psf (720 Pa).
- H. Water Penetration under Dynamic Pressure: No evidence of water penetration through fixed glazing and framing areas when tested according to AAMA 501.1 at dynamic pressure equal to 15psf (720 Pa).
1. Maximum Water Leakage: [According to AAMA 501.1] [No uncontrolled water penetrating assemblies or water appearing on assemblies' normally exposed interior surfaces from sources other than condensation]. Water leakage does not include water controlled by flashing and gutters that is drained to exterior.
- I. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 120 deg F (49 deg C), ambient; 180 deg F (82 deg C), material surfaces.
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)].
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5.
- J. Energy Performance: Glazed aluminum curtain walls shall be tested in accordance with NFRC and AAMA Standards.

EDITOR NOTE: HP Low-e BASED ON 1-1/8" (28.6) IG UNIT, e=0.04 #2, AIR FILLED, ALUMINUM SPACER.

- K. Thermal Transmittance (U-factor): Fixed glazing and framing areas shall have U-factor of no greater than 0.39 (HP Low-e) for Clearwall™ SS as determined according to AAMA 1503 or Project specific () BTU/Hr/Ft²/°F per AAMA 507 or () BTU/Hr/Ft²/°F per NFRC 100.
- L. Solar Heat Gain Coefficient: Fixed glazing and framing areas shall have a solar heat gain coefficient of no greater than [_____] <Insert value> as determined according to NFRC 200.
- M. Air Infiltration: Maximum air leakage through fixed glazing and framing areas of 0.06 cfm/sq.ft. (0.31 l/s.m²) of fixed wall area as determined according to ASTM E 283 and TAS 202 at a minimum static-air-pressure differential of 6.24 psf (300 Pa).
- N. Condensation Resistance: When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
1. Clearwall™ (SS): CRF_{glass} (HP Low-e) = 61, CRF_{frame} = 78
- O. Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
1. Clearwall™ (SS): I_{glass} (HP Low-e) = 56, I_{frame} = 74
- P. Sound Transmission: Provide glazed aluminum curtain walls with fixed glazing and framing areas having the following sound-transmission characteristics:
1. Clearwall™ (SS): STC-33 or OITC-28 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1-1/8" (28.6) insulating glass (1/4", 5/8" AS, 1/4").

2. Clearwall™ (SSI): STC-37 or OITC-30 when tested for laboratory sound transmission loss according to ASTM E 90 and ASTM E 1425, and based on 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4" with Laminate).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Clearwall™ Curtain Wall System
 3. Frame depth options:
 - a. Clearwall™ Curtain Wall System - SS (Screw Spline).

- 1) Clearwall™ (SS): 2-1/2" x 6-5/8" (63.5 x 168.3) or 2-1/2" x 5-1/8" (63.5 x 130.2), outside glazed with recessed glass edge spacer by qualified Insulated Glass Unit (IGU) manufacturer.
- 2) Clearwall™ (SSI): 2-1/2" x 7-1/2" (63.5 x 190.5) or 2-1/2" x 6" (63.5 x 152.4), outside glazed with metal interfaced insulating glass (interface shop applied with structural silicone).
- 3) Clearwall™ (SSIT): 2-1/2" x 7-3/8" (63.5 x 187.0) or 2-1/2" x 5-7/8" (63.5 x 149.0), outside glazed with metal interfaced insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).
- b. Clearwall™ Curtain Wall System - SB (Shear Block).
 - 1) Clearwall™ (SB): 2-1/2" x 10-1/8" (63.5 x 257.2), outside glazed with recessed glass edge spacer by qualified Insulated Glass Unit (IGU) manufacturer.
 - 2) Clearwall™ (SBI): 2-1/2" x 11" (63.5 x 279.4), outside glazed with metal interfaced insulating glass (interface shop applied with structural silicone).
 - 3) Clearwall™ (SBIT): 2-1/2" x 10-27/32" (63.5 x 275.4), outside glazed with metal interfaced insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).
4. Tested to AAMA 501-05 and TAS 202.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- G. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 1. Glazing System: Retained mechanically with toggles on four sides.
 2. Glazing Plane: Front.
- B. Glass:

1. Clearwall™ (SS)/(SB): Outside glazed with 1-1/8" (28.6) insulating glass with 5/8" (15.9) recessed glass edge spacer supplied by qualified glass supplier.
 2. Clearwall™ (SSI)/(SBI): Outside glazed with metal interfaced 1" (25.4) insulating glass (interface shop applied with structural silicone).
 3. Clearwall™ (SSIT)/(SBIT): Outside glazed with metal interfaced 1" (25.4) insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape).
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
1. Toggle Assembly: Toggle assembly as tested by manufacturer.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
1. System: Outside toggle glazed format with 1" (25.4) or 1-1/8" (28.6) double glazed insulating glass.
 - a. Clearwall™ (SS)/(SB): Outside glazed with 1-1/8" (28.6) insulating glass with 5/8" (15.9) recessed glass edge spacer supplied by qualified glass supplier.
 - b. Clearwall™ (SSI)/(SBI): Outside glazed with metal interfaced 1" (25.4) insulating glass (interface shop applied with structural silicone).
 - c. Clearwall™ (SSIT)/(SBIT): Outside glazed with metal interfaced 1" (25.4) insulating glass (interface shop applied with 3M™ VHB™ structural glazing tape). 3M™ to conduct application review prior to start of each project.
 - B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
 - C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
 - D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fitted joints.
 3. Physical and thermal isolation of glazing from framing members.
 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 5. Provisions for field replacement of glazing from exterior.
 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
 8. Double seal design with primary air and vapor barrier at interior side of glazed aluminum curtain wall and secondary seal weeped and vented to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permazine™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 2500 UT Unitwall™ System – 2-1/2" x 7-1/2" (63.5 x 190.5) Captured system or 2-1/2" x 6-1/2" (63.5 x 165.1) SSG system nominal dimensions, Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide curtain wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (Static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 45 psf (2155 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any curtain wall member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the curtain wall members in excess of 0.2% of their clear spans shall occur.
- H. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 0 deg F (-18 deg C); 180 deg F (82 deg C).
 2. Test Interior Ambient-Air Temperature: [75 deg F (24 deg C)] .
 3. Test Performance: No buckling; stress on glass; sealant failure; excess stress on framing, anchors, and fasteners; or reduction of performance when tested according to AAMA 501.5 for a minimum 3 cycles.
- I. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.
- J. Interstory Drift: When tested to AAMA 501.7, system must meet an interstory drift of ±3/4".

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA1503 OR CSA A440 ARE BASED UPON 1" (25.4) CLEAR INSULATING GLASS (1/4", 1/2" AS 1/4"). REFER TO THERMAL CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- K. Thermal Transmittance (U-factor):
 Captured; The (U-factor) shall not be more than: 0.36 (low E) per AAMA 1503 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
 4-side SSG; The (U-factor) shall not be more than: 0.37 (low E) per AAMA 1503 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- L. Condensation Resistance (CRF):
 Captured; When tested to AAMA 1503, the CRF shall not be less than: 80_{frame} and 72_{glass} (low E).
 4-side SSG; When tested to AAMA 1503, the CRF shall not be less than: 80_{frame} and 71_{glass} (low E).
- or
- M. Condensation Index (I):
 Captured; When tested in accordance with CSA-A440.2, the Condensation Index shall not be less than: 69_{frame} and 65_{glass} (low E).
 4-side SSG; When tested in accordance with CSA-A440.2, the Condensation Index shall not be less than: 75_{frame} and 65_{glass} (low E).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" (25.4) CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/4", 1/2" ARGON, 1/4").

- N. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): Captured & 4-side SSG; When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than 36 (STC) and 30 (OITC).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8) lengths of full-size components and showing details of the following:
1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL," "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 2500 UT Unitwall™ System - Pre-fabricated, Pre-assembled and Pre-glazed™, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - 3. Frame depth options: 2-1/2" x 7-1/2" (63.5 x 190.5) Captured system, 2-1/2" x 6-1/2" (63.5 x 165.1) SSG system.
 - 4. Tested to AAMA 501

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Thermal Breaks: Captured system 4-side continuous polyamide thermal break.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Glazing System: Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass. 1" (25.4) for spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as specified and tested by manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
1. System: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets, Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- C. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- D. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

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3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
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 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

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- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.

- a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
- b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).

B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 1600 SS Curtain Wall System - 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed pressure plate or structural silicone glazed (SSG) format.
 - b. 1600 SS Curtain Wall System Blast Mitigation - 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed pressure plate or tape glazed format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
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- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

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- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): The thermal transmittance (U-factor) shall not be more than:
 1. Captured - 0.65 (clear) when tested to AAMA 1503
 2. SSG - 0.58 (clear) when tested to AAMA 1503,
 or
 Project Specific () BTU/hr/ft² /°F per AAMA 507 or () BTU/hr/ft² /°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 1. Captured - 68_{frame} and 60_{glass} (clear),
 2. SSG - 72_{frame} and 62_{glass} (clear),
 or
 Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
 1. Captured - 61_{frame} and 51_{glass} (clear).
 2. SSG - 64_{frame} and 54_{glass} (clear).
- K. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than:
 Captured - STC 31 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4"),
 SSG - STC 32 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4").
- L. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria. To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 1. Section B-3.1.1 Dynamic analysis
 2. Section B-3.1.2 Testing
 3. Section B-3.1.3 ASTM F2248 Design Approach

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1600 SS Curtain Wall.
 - 3. Frame depth options: 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed captured or structural silicone glazed (SSG) format.
 - 4. 1600 SS Curtain Wall Blast Mitigation
 - 5. Frame depth options: 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed captured or tape glazed format.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600 SS Curtain Wall: Outside glazed format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Outriggers shall be painted (Select from Kawneer's standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer's standard paints and colors, custom colors are available upon request, or Kawneer's anodized finishes.).

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.

- a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.
 - 1. Types of Kawneer Aluminum Curtain Wall include:
 - a. 2500 PG Wall™ Curtain Wall System – 2-1/2" x 7-1/2" (63.5 x 190.5) nominal dimension, Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - b. 2500 PG Wall™ Curtain Wall System (Impact Glazing) Zone 3, Level D – 2-1/2" x 7-1/2" (63.5 x 190.5) nominal dimension, Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide curtain wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance, (Static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 15 psf (718 Pa) as defined in AAMA 501.
- G. Uniform Load: A static air design load of 40 psf (1915 pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any curtain wall member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the curtain wall members in excess of 0.2% of their clear spans shall occur.
- H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA1503 OR CSA A440 ARE BASED UPON 1" (25.4) CLEAR INSULATING GLASS (1/4", 1/2" AS 1/4"). REFER TO THERMAL CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): The (U-factor) shall not be more than: 0.65 (clear) per AAMA 1503 or Project Specific (____) BTU/hr/ft²/°F per AAMA 507 or (____) BTU/hr/ft²/°F per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA 1503, the CRF shall not be less than: Captured – 69_{frame} and 58_{glass} (clear).
or
- K. Condensation Index (I): When tested in accordance with CSA-A440-00, the Condensation Index shall not be less than: Captured – 58_{frame} and 43.6_{glass} (clear).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" (25.4) CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

- L. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than 35 (STC) and 28 (OITC).
- M. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 1. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12" (304.8) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 2500 PG Wall™ Curtain Wall System - Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - 3. 2500 PG Wall™ Curtain Wall System (Impact Glazing) Zone 3, Level D - Pre-fabricated, Pre-assembled and Pre-glazed, Unitized Construction, Four-Side Captured Glazing, Optional: Two or Four-Side Structural Silicone Glazed.
 - 4. Frame depth options: 2-1/2" x 7-1/2" (63.5 x 190.5)
 - 5. Tested to AAMA 501

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Curtain Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material and components to avoid damage. Protect curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Window Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window wall framing.
 - 1. Types of Kawneer Aluminum Window Wall include:
 - a. MetroView™ FG 501T Window Wall – 2-1/4" x 5" (57.2 x 127), inside glazed or outside glazed system.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 107113 "Exterior Sun Control Devices"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum window walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum window walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum window walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Window Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.

- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (cyclic): The test specimen shall be tested in accordance with ASTM E 547. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Water Resistance, (severe, wind driven rain): The test specimen shall be tested in accordance with AAMA 520 and ASTM E2268. The test specimen shall pass performance level 5, pressure limits 9 psf (431 Pa) – 27 psf (1293 Pa).
- H. Uniform Load: A static air design load of 42 psf (2010 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-factor) shall not be more than;
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. U-Factor not more than 0.38 BTU/hr/ft² /°F. per AAMA 1503 or () BTU/hr/ft² /°F. per AAMA 507 or NFRC 100 when using project specified glass.
- J. Condensation Resistance Test (CRF): Provide aluminum window wall tested for thermal performance according to AAMA 1503, the condensation resistance factor (CRF) shall not be less than;
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. CRF not less than 69_{frame} and 68_{glass}.
- K. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;
 - 1. 1" insulating glass made with exterior 1/4" glass, 1/2" spacer, and interior 1/4" laminated glass.
 - a. STC not less than 36; OITC not less than 31.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum window walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum window walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed window wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery
 - 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum window walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum window wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of window wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum window walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. MetroView™ FG 501T Window Wall
 - 3. Frame depth options: 2-1/4" x 5" (57.2 x 127), inside glazed or outside glazed system
 - 4. Tested to AAMA 501

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum window walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum window wall manufacturer for strength, corrosion resistance, and application of required finish and each framing member shall have a wall thickness sufficient to meet the specified structural requirements and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window wall members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated window wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

- G. Thermal Barrier: Kawneer IsoLock™ Thermal Break with a 3/8" (9.5 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum window wall sections.
 - 1. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed window wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Window Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4-sided captured
 - 2. Glazing Plane: Front
- B. Glass: 1" (25.4) insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum window wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle window wall material and components to avoid damage. Protect window wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Inside glazed or outside glazed system with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by sealant manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 6. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum window wall to exterior.
- C. Window Wall Framing: Fabricate components for assembly using screw spline system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install window wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be inside glazed or outside glazed and held in place with extruded aluminum glass stops.
 - 3. Water Drainage: Each light of glass shall be internally drained using water deflectors and sealant to divert water to the sill horizontal weep locations. Weep holes shall be located in the sill to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select window wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum window wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.

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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Window Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window wall framing.
 - 1. Types of Kawneer Aluminum Window Wall include.
 - a. MetroView™ FG 601T PG Window Wall – 2-1/4" x 6" (57.2 x 152.4), Pre-glazed system.
 - b. 1" (25.4) infill, wet glazed or 1-3/16" (30.1) infill, tape glazed.
 - c. 4-Side Captured and Vertical SSG option.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections.

- 1. 072700 "Air Barriers".
- 2. 079200 "Joint Sealants".
- 3. 083213 "Sliding Aluminum-Framed Glass Doors".
- 4. 084113 "Aluminum-Framed Entrances and Storefronts".
- 5. 084313 "Aluminum-Framed Storefronts".
- 6. 084329 "Sliding Storefronts".
- 7. 084433 "Sloped Glazing Assemblies".
- 8. 085113 "Aluminum Windows".
- 9. 086300 "Metal-Framed Skylights".
- 10. 088000 "Glazing".
- 11. 107113 "Exterior Sun Control Devices".
- 12. 122600 "Interior Daylighting Devices".

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum window walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum window walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following.
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum window walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Window Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.01 cfm/ft² (0.1 l/s · m²) at a static air pressure differential of 6.2 psf (300 Pa).
- E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- F. Water Resistance, (cyclic): The test specimen shall be tested in accordance with ASTM E 547. There shall be no leakage at a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.
- G. Water Resistance, (severe, wind driven rain): The test specimen shall be tested in accordance with AAMA 520 and ASTM E2268. The test specimen shall pass performance level 5, pressure limits 9 psf (431 Pa) – 27 psf (1293 Pa).
- H. Uniform Load: A static air design load of 45 psf (2150 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-factor) shall not be more than.
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. U-Factor not more than 0.32 BTU/hr/ft² /°F. per AAMA 1503 or () BTU/hr/ft² /°F. per AAMA 507 or NFRC 100 when using project specified glass.
- J. Condensation Resistance Test (CRF): Provide aluminum window wall tested for thermal performance according to AAMA 1503, the condensation resistance factor (CRF) shall not be less than.
 - 1. 1" Low-e insulating glass with warm edge spacer.
 - a. CRF not less than 76_{frame} and 74_{glass}.
- K. Condensation Resistance (I): When tested to CSA A440, the condensation resistance factor shall not be less than.
 - a. Insulated Glass – 67_{frame} and 67_{glass} (low-e).
- L. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than.
 - 1. 1" insulating glass made with exterior 1/4" tempered glass, 1/2" spacer, and interior 1/4" laminated glass.
 - a. STC not less than 34; OITC not less than 27.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum window walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum window walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed window wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following.
 - 1. Joinery.
 - 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum window walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum window wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.

1. Build mockups for type(s) of window wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum window walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL"/"OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product.
 1. Kawneer Company Inc..
 2. MetroView™ FG 601T PG Window Wall.
 3. Frame depth: 2-1/4" x 6" (57.2 x 152.4), Pre-glazed system.
 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following.
 1. Manufacturer: (_____).
 2. Series: (_____).
 3. Profile dimension: (_____).
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum window walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum window wall manufacturer for strength, corrosion resistance, and application of required finish and each framing member shall have a wall thickness sufficient to meet the specified structural requirements and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window wall members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

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Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated window wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- G. Thermal Barrier: Kawneer IsoLock™ Thermal Break with a 3/8" (9.5 mm) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum window wall sections.
 - 1. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed window wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Window Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4-sided Captured and Vertical SSG option.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) wet glazed or 1-3/16" (30.1) tape glazed, insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum window wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle window wall material and components to avoid damage. Protect window wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Inside glazed system with 1" (25.4) wet glazed or 1-3/16" tape glazed, double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by sealant manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics.
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 6. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum window wall to exterior.

- C. Window Wall Framing: Fabricate components for assembly using screw spline system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing.
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install window wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be inside glazed and held in place with extruded aluminum glass stops.
 - 3. Water Drainage: Each light of glass shall be internally drained using water deflectors and sealant to divert water to the sill horizontal weep locations. Weep holes shall be located in the sill to divert water to the exterior of the building.
- B. Related Products Installation Requirements.
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual.

3.3 Field Quality Control

- A. Field Tests: Architect shall select window wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum window wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Window Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window wall framing.
 - 1. Types of Kawneer Aluminum Window Wall include:
 - a. FG 623™ Window Wall – 2-1/4" x 6" (57.2 x 152.4) nominal dimension; Thermal; Front Plane; Weatherseal Glazed; Screw Spline Fabrication for 1/4" (6.4) and 1" (25.4) glazing.
 - b. FG 623™ IR Window Wall – 2-1/4" x 6" (57.2 x 152.4) nominal dimension; Thermal; Front Plane; Weatherseal Glazed; Screw Spline Fabrication for 9/16" (14.3) and 5/8" (15.9) glazing.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
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- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum window walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum window walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum window walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide window wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa).
- E. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 10 psf (479 Pa) as defined in AAMA 501.
- F. Uniform Load: A static air design load of 40 psf (1916 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS ARE BASED UPON 1" (25.4) CLEAR INSULATING GLASS. (1/4", 1/2" AS, 1/4") OR REFER TO THERMAL TRANSMITTANCE (U-VALUE) CHARTS FOR PROJECT SPECIFIC U-VALUES.

- G. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.57 (clear) or Project Specific (____) BTU/hr/ft² /°F. per AAMA 507.
- H. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than: 70_{frame} and 59_{glass} (clear), or Condensation Index (I): when tested to CAN/CSA-A440, the condensation index shall not be less than 60_{frame} and 52_{glass} (clear).
- I. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - 1. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - 2. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum window walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum window walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed window wall systems, made from 12" (300 mm) lengths of full-size components and showing details of the following:
 - 1. Joinery
 - 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum window walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum window wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of window wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum window walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.

1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. FG 623™ Window Wall
 - a. Frame depth options: 2-1/4" x 6" (57.2 x 152.4) nominal dimension; Thermal; Front Plane; Weatherseal Glazed; Screw Spline Fabrication for 1/4" (6.4) and 1" (25.4) glazing.
 3. FG 623™ IR Window Wall
 - a. Frame depth options: 2-1/4" x 6" (57.2 x 152.4) nominal dimension; Thermal; Front Plane; Weatherseal Glazed; Screw Spline Fabrication for 9/16" (14.3) and 5/8" (15.9) glazing.
 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window wall installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum window walls for a period of not less than ten (10) years. (Company Name).
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum window wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated window wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- G. Thermal Barrier:

1. Kawneer IsoLock™ Thermal Break with a nominal 1/4" (6.4) separation consisting of a two-part chemically curing, high-density polyurethane, which is mechanically and adhesively joined to aluminum window wall sections.
 2. Thermal Break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.
- H. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed window wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Window Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 1. Glazing System: 4 sided captured.
 2. Glazing Plane: Front.
- B. Glass: 1/4" (6.4) and 1" (25.4) insulating glass option.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum window wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle window wall material and components to avoid damage. Protect window wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 1. System: Inside glazed, weatherseal glazed format with 1/4" (6.4) monolithic or 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. InLighten™ Light Shelf: aluminum light shelf system consisting of anchor channels, support beams, fascia trims and Aluminum Composite Material (ACM) panels that is anchored directly to the Curtain Wall intermediate horizontal members.
 1. Light Shelf: Interior mounted shelf to reflect daylight deeper into interior space.
 2. Light Shelf System to consist of:
 - a. Aluminum Composite Material (ACM) panel, 4mm thick.
 - b. Translucent polycarbonate panel, 4mm/16mm thick.
 - c. ACM finish on upper and lower surface shall be selected from Kawneer standard finishes.
 - d. Extruded Aluminum outriggers and fascia.
 - e. Extruded aluminum anchor designed to secure to compatible verticals of framing system. Anchor shall be designed to engage shelf so as to allow the shelf to rotate down and hang on its own safely for cleaning.
 - f. Extruded aluminum shear blocks designed to hinge on the anchors to allow rotating individual shelves for cleaning.
 - g. Panel /Shelf projection shall not exceed 30" (762 mm).
 - h. Mullion spacing of framing system shall not exceed 6' (1.83 m) on center.
 - i. Panel /Shelf deflection shall not exceed L/120 of horizontal span length.
 3. Framing System to Support Light Shelf shall be: (select appropriate framing system)
 - a. Curtain wall framing system.
 - b. Storefront Framing System.
 4. Submittals.

- a. Manufacturer's Installation Instructions.
 - b. Samples for Verification.
 - 1) Factory applied finish as selected by architect.
 - 2) Functioning Light Shelf sample demonstrating operation.
 - c. Shop Drawing including:
 - 1) Plans, elevations, sections, fabrication and installation details.
- C. Validation from manufacture of single-source for light shelf and framing system and compatibility between the system.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 6. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum window wall to exterior.
- C. Window Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install window wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select window wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum window wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Window Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window wall framing.
 - 1. Types of Kawneer Aluminum Window Wall include:
 - a. PG 123™ Framing – 2-1/4" x 6" (57.2 x 152.4) nominal dimension; Pre-fabricated, Pre-assembled and Pre-glazed; Thermal; Front Plane; Structural Silicone and Weatherseal Glazed; Screw Spline Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 088000 "Glazing"
- 11. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum window walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 - 1. Glazed aluminum window walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum window walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Window Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

- D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (0.3 l/s · m²) at a static air pressure differential of 6.24 psf (300 Pa). Air infiltration shall meet the FIXED rating per CAN/CSA A440.
- E. Water Resistance: The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a minimum static air pressure differential of 15 psf (718 Pa) as defined in AAMA 501. Water Infiltration shall meet the (Select up to B7) rating per CAN/CSA A440.
- F. Uniform Load: A static air design load of 42 psf (2011 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur. Uniform load shall meet the C3 rating per CAN/CSA A440.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS ARE BASED UPON 1" (25.4) CLEAR INSULATING GLASS. (1/4", 1/2" AS, 1/4") OR REFER TO THERMAL TRANSMITTANCE (U-VALUE) CHARTS FOR PROJECT SPECIFIC U-VALUES.

- G. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.57 (clear) or Project Specific (_____) BTU/hr/ft² /°F. per AAMA 507.
- H. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than: 69_{frame} and 60_{glass} (clear), or Condensation Index (I): when tested to CAN/CSA-A440, the condensation index shall not be less than 59_{frame} and 49_{glass} (clear).

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" (25.4) CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

- I. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than: Glass to Exterior – 37 (STC) and 29 (OITC)
- J. Live Load Deflection Cycle: Framing system shall meet specified air and water infiltration requirements after cycle testing for +/- 1/2" vertical head movement from nominal position.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum window walls. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum window walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed window wall systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery.
 2. Glazing.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum window walls that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum window wall system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of window wall elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for glazed aluminum window walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. PG 123™ Framing.
 - 3. Frame depth options: 2-1/4" x 6" (57.2 x 152.4) nominal dimension – Pre-fabricated, Pre-assembled and Pre-glazed; Thermal; Front Plane; Structural Silicone and Weatherseal Glazed; Screw Spline Fabrication.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum window walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum window wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

- G. Sealant: For sealants required within fabricated window wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier:
 - 1. Kawneer IsoWeb™ Thermal Break; All perimeter window wall members shall consist of interior and exterior extruded aluminum sections that shall be integrated with two parallel, glass reinforced nylon strips, forming a continuous composite assembly.
 - 2. Thermal separator at Intermediate Horizontal members shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" separation.
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed window wall members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Window Wall Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4" (6.4) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle window wall material and components to avoid damage. Protect window wall material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. System: Inside glazed, structural silicone and weatherseal glazed format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum window wall to exterior.
- C. Window Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.

- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadoze™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install window wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select window wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum window wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Side load single hung (AW-PG50-H)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Windows"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99".
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than: 75 (frame) and 76 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than: 61 (frame), 75 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.23 to 0.38 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.23 to 0.38 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s·m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa) with a **10 lb. sill** or 15 lbf/sq. ft. (720 Pa) with a **15 lb. sill**.
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 32 (STC) and 24 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.

2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.41 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- L. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 1. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
(CRF_f) frame not less than 71.
(CRF_g) glass not less than 74.
- M. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 1. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
Temperature Index (I_f) frame not less than 57.
Temperature Index (I_g) glass not less than 77.
- N. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
- O. Air Exfiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Exfiltration Test.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
- P. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **10 lb. Sill**.
 - b. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **10 lb. Sill**.
 - b. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **15 lb. Sill**.
- Q. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-1/4" laminated insulating glass: 35 (STC) and 31 (OITC)

AA™ 5450 (Standard Face) and AA™ 5450 (Beveled Face)

- R. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- S. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- T. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.

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Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 MANUFACTURERS**

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™5450 Ultra Thermal Singe Hung (Standard Face)
 - 3. Series AA™5450 Ultra Thermal Singe Hung (Beveled Face)
 - 4. 4 5/8" (117.48 mm) frame depth
 - 5. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.

2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Single Hung Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: AW-PG50-H

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Windows: Provide the following operating hardware:
 1. Sash Balances: A Class 5 adjustable spiral balance with stainless steel or other corrosion-resistant components. Two per sash.
 2. Handle: Continuous, integral, bottom sash lift handle.
 3. Sash Lock: White bronze sweep lock and keeper on meeting rails. One or two per sash as required by size. Brushed nickel finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.

- B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 2. Finish: Manufacturer's standard.

EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.

- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch (0.28-mm) diameter, coated aluminum wire.
1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
- D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™, AAMA 2604. Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.6 psf (75 Pa) for CW or 6.2 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Side load double hung (AW-PG50-H)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than 71 (frame) and 76 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than 40 (frame), 74 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.3 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa) with a **10 lb. sill** or 15 lbf/sq. ft. (720 Pa) with a **15 lb. sill**.
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 32 (STC) and 25 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.

AA™ 5450 (Standard Face) and AA™ 5450 (Beveled Face)

- L. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- M. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- N. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify actual dimensions of aluminum framed window openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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PART 2 - PRODUCTS**2.1 MANUFACTURERS**

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series AA™5450 Ultra Thermal Double Hung (Standard Face)
 3. Series AA™5450 Ultra Thermal Double Hung (Beveled Face)
 4. 4 5/8" (117.48 mm) frame depth
 5. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer:
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Double Hung Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
1. Performance Class and Grade: AW-PG50-H

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads and an interior gasket in accordance with AAMA 702 or ASTM C864.

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2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Windows: Provide the following operating hardware:
 - 1. Sash Balances: A Class 5 adjustable spiral balance with stainless steel or other corrosion-resistant components. Two per sash.
 - 2. Handle: Continuous, integral, bottom and top sash lift handle.
 - 3. Sash Lock: White bronze sweep lock and keeper on meeting rails. One or two per sash as required by size. Brushed nickel finish.
 - 4. Aluminum autolock at top sash lift handle.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

- 5. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
- 6. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
- 7. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 - 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.
 - B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
 - 1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 - 2. Finish: Manufacturer's standard.
- EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.**
- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch (0.28-mm) diameter, coated aluminum wire.
 - 1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
 - D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
 - 1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 - 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permardize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604. Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within windows to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Fixed window (AW-PG70-FW)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than: 78 (frame) and 79 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than: 68 (frame) and 75 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.22 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.19 to 0.37 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32).
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.1 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa).
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 29 (STC) and 23 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.22 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.20 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.34).

AA™5450 (Standard Face) and AA™5450 (Beveled Face)

- L. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™5450 Ultra Thermal Fixed (Standard Face)
 - 3. Series AA™5450 Ultra Thermal Fixed (Beveled Face)
 - 4. 4 5/8" (117.48 mm) frame depth
 - 5. AW-PG70-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Fixed Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: AW-PG70-FW

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: None required

2.6 INSECT SCREENS

- A. General: None required

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.

1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.

- a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal
 - b. Horizontal Sliding (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Windows"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 99" x 79"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

- 1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.

- a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series AA™5450 Ultra Thermal Horizontal Sliding Window
 3. 4 5/8" (117.48 mm) frame depth

4. (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Horizontal Sliding Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
1. Performance Class and Grade: (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- C. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than Single Slide: 76 (frame) and 77 (glass) or Double Slide: 69 (frame) and 77 (glass).
- D. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than Single Slide: 57 (frame) and 73 (glass) or Double Slide: 36 (frame) and 74 (glass).
- E. Thermal Transmittance: Provide aluminum windows tested for thermal performance according to AAMA 1503.
1. Provide aluminum windows tested for thermal performance according to AAMA 1503, with a thermal transmittance (U-factor) no more than Single Slide: 0.25 BTU/hr/sf/F or Double Slide: 0.28 BTU/hr/sf/F.
 2. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-factor) range of; Single Slide: 0.23 to 0.38 BTU/hr/sf/F or Double Slide: 0.25 to 0.39 BTU/hr/sf/F (Based on center of glass U-factor range 0.10 to 0.32 for triple glazing).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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- F. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- G. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 - 1. Maximum Rate: 0.3 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- H. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 - 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa).
- I. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- J. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.
- L. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass:
XO UNIT = 32 (STC) and 26 (OITC)
XX UNIT = 33 (STC) and 26 (OITC)

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Windows: Provide the following operating hardware:
 - 1. Handle: Continuous, integral pulls.
 - 2. Sash Locks.
 - 3. Composite adjustable tandem roller.
 - 4. Stainless Steel roller track.
 - 5. Standard auto lock.
 - 6. Limit device.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

- 7. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
- 8. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 - 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.
 - B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
 - 1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 - 2. Finish: Manufacturer's standard.
- EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.**
- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch- (0.28-mm-) diameter, coated aluminum wire.
 - 1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
 - D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
 - 1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 - 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12.7 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604. Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.

3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8430TL Single Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG70-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG70-H

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .51 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 55) (Glass = 62).

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.
13. Sound: Testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (34 STC) and (29 OITC).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8400TL Thermal Windows
 3. Model 8430TL Single Hung Window
 4. 4" (101.6 mm) frame depth
 5. AW-PG70-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 1/4" (6.35 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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2.3 Window System

- A. Series 8400TL Thermal Windows - Single Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8450TL Double Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. H-HC70 / H-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: H-HC70
 - b. Performance Class and Grade: H-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 51) (Glass = 63) .
8. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .52 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Sound: testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (33 STC) and (29 OITC).
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8400TL Thermal Windows
 3. Model 8450TL Double Hung Window
 4. 4" (101.6 mm) frame depth
 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Double Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom and top sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
6. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8410TL Fixed Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 60" x 99" (1524 x 2515 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 60" x 99" (1524 x 2515 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .48 BTU/hr/sf/°F or (____) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503 with 1" (25,4 mm) insulating clear glass, the condensation resistance factor shall not be less than (CRF_f 67) frame and (CRF_g 66) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Sound Performance: When tested in accordance with ASTM E 90 and E 413, the sound transmission loss (STL) shall not be less than 39.
10. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8410TL Fixed Window
 - 4. 4" (101.6 mm) frame depth
 - 5. AW-PG100FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Fixed Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- C. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and mechanically clipped and/or staked, factory sealed frame and vent corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8470TL Horizontal Sliding Window
 - c. 4" (101.6 mm) frame depth
 - d. HS-HC70 / HS-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: HS-HC70
 - b. Performance Class and Grade: HS-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 96" x 80" (2438 x 2032 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 PA).

3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 96" x 80" (2438 x 2032 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Temperature Index Test: (CRF) when tested in accordance with CAN/CSA A440, the Temperature Index shall not be less than (CRF_f 38.2) frame and (CRF_g 61.2) glass
8. Thermal Transmittance Test: (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .55 BTU/hr/sf/°F or () BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test: (CRF) when tested in accordance with AAMA 1503, the condensation resistance factor shall not be less than (CRF_f 50) frame and (CRF_g 61) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound: Testing per ASTM 1801 with 1" insulating glass made with (1/4" annealed exterior with, 1/2" airspace, 1/4" annealed interior): minimum (34 STC) and (29 OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems..

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8470TL Horizontal Sliding Window
 - 4. 4" (101.6 mm) frame depth
 - 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Window - Horizontal Sliding Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Continuous Integral Pulls
2. Stainless Steel Ball Bearing Rollers
3. Stainless Steel Roller Track
4. Plunger Lock

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints.

- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.5.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar material to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.

- b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-5000 Windows
 - b. Double Hung Tilt Window
 - c. 3-1/4" (83 mm) frame depth
 - d. CW-PG35-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: CW-PG35 - 56" x 91" (1422 mm x 2311 mm) -H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Leakage: The test specimen shall be tested in accordance with ASTM E283. Air leakage rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 1.6 psf (75 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM. There shall be no leakage as defined in the test method at a static air pressure differential of 5.25 psf (251 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 35 psf (1676 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .3% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 52.5 psf (2514 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series NX-5000 Windows - Double Hung Tilt
 3. 3-1/4" (83 mm) frame depth
 4. CW-PG35-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-5000 Windows - Double Hung Tilt

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Black [Optional White] zinc die cast Sweep Lock
 - b. (Optional) Aluminum Automatic Sill Locks
 - c. (Optional) Black (White) nylon Night Latches
 - d. Aluminum Automatic Head Lock
 - e. Zinc Pivot Sash Bars
 - f. Black [Optional White] nylon Finger Button [Custodial] tilt releases

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) [Optional Full Screen] Held in exterior tracks with stainless steel leaf springs; 5/16" x 1-1/2" x .045" extruded [Optional Roll Formed] tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Leakage Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.6 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-5400 Windows
 - b. Single Hung Tilt Window
 - c. 3-1/4" (83 mm) frame depth
 - d. CW-PG45-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: CW-PG45 - 56" x 91" (1422 mm x 2311 mm) -H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Leakage: The test specimen shall be tested in accordance with ASTM E283. Air leakage rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 6.2 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331. There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 45 psf (2155 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 67.5 psf (3232 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series NX-5400 Windows - Single Hung Tilt
 3. 3-1/4" (83 mm) frame depth
 4. CW-PG45-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-5400 Windows - Single Hung Tilt

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Black [White] zinc die cast Sweep Lock
 - b. (Optional) Aluminum Automatic Sill Locks
 - c. (Optional) Black [White] nylon Night Latches
 - d. Zinc Pivot Bars
 - e. Black [White] nylon Finger Button [Custodial] Tilt Releases

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.

- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in exterior tracks with stainless steel leaf springs; 5/16" x 1-1/2" x .045" extruded [Optional Roll Formed] tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Leakage Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.6 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9000 Windows
 - b. Double Hung Tilt Window
 - c. 4" (102 mm) frame depth
 - d. AW-PG45-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG45-H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 1.6 psf (77 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (480 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 45 psf (2155).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 67.5 psf (3232).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-9000 Windows - Double Hung Tilt
 3. 4" (102 mm) frame depth
 4. AW-PG45-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)

4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.062" (1.57 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9000 Windows - Double Hung Tilt

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be in accordance with manufacturer's standards. Sash glazing: black reusable flexible PVC channel gasket with weep holes.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Pole-Operated Cam Meeting Rail Lock and Keeper
 - b. (Optional) Pole-Operated White Bronze Automatic Head Lock
 - c. (Optional) Aluminum Automatic Head Lock
 - d. (Optional) Aluminum Automatic Sill Locks
 - e. (Optional) White Bronze Sill Lock
 - f. (Optional) Limit Lock to limit sash travel to (____ Enter travel distance in inches, e.g. 6")
 - g. Zinc Sash Pivot Bars
 - h. Nylon Black Tilt Latches with 3/16" Hex Key
 - i. (Optional) Pole Ring

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in exterior integral tracks with top pivots and sill automatic latches; 7/16" x 1" x .045 extruded tubular aluminum frame with window finish; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh secured to frame with PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

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B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
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5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
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 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
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- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9100 Windows
 - b. Single Hung Side Load Window
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG50-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG50-H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).
5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 50 psf (2400 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 75 psf (3600 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTORS AND CFR.

8. Thermal Test: Per AAMA 1503, at the prescribed 48" x 72" (1219 x 1829) test size glazed with 1" insulating glass made with 1/4" , argon gas, and 1/4" glass with low E coating:
 - a. Condensation Resistance Factor: Minimum (56 frame) and (62 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.51 BTU/HR/SQ.FT/°F.
9. U-Factor Simulation: Per NFRC 100, at the prescribed 48" x 72" (1219 x 1829) Non-Residential Size, glazed with 1" insulating glass made with exterior 1/4" , argon gas, and interior 1/4" glass with low E coating:
 - a. Thermal Transmittance to be maximum 0.51 BTU/HR/SQ.FT/°F.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
 13. Sound Test: Testing per ASTM E90 with 1" insulating glass made with exterior 1/4" laminated glass - 1/8" glass x .060 PVB interlayer x 1/8" glass - and interior 3/16" clear glass: Minimum (36 STC) and (31 OITC).
 14. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.

- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series TR-9100 Windows - Single Hung Side Load
 - 3. 3-1/4" (82.5 mm) frame depth
 - 4. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.062" (1.57 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9100 Windows - Single Hung Side Load

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Typical Hardware:
 - a. Aluminum Automatic Sill Locks
 - b. (Optional) White Bronze Automatic Sill Locks
 - c. (Optional) White Bronze Pole Ring on meeting rail
 - d. (Optional) Keyed plunger Limit Lock (Specify clear opening or travel distance in inches, e.g. 6")

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 - 1. True muntins.
 - 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in exterior applied PVC rigid tracks with two stainless steel leaf springs; 7/16" x 1-1/4" x .045 extruded tubular aluminum frame with window finish; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh secured to frame with PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.

- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:

1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9400 Windows
 - b. Double Hung Side Load Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG55-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG55-H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 55 psf (2633 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 82.5 psf (3960 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-9400 Windows - Double Hung Side Load
 3. 4" (101.6 mm) frame depth
 4. AW-PG55-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)

4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.080" (2.03 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9400 Windows - Double Hung Side Load

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Side Load Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Aluminum Automatic Head Lock.
 - b. Aluminum Automatic Sill Locks.
 - c. (Optional) White Bronze Pole Operated Automatic Head Lock.
 - d. (Optional) White Bronze Aluminum Automatic Sill Locks.
 - e. (Optional) White Bronze Cam Meeting Rail Lock and Keeper. [Not available with bevel or dual glazed sash]

2.6 Accesories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in exterior integral tracks with top pivots and sill automatic latches; 7/16" x 1" x .045 extruded tubular aluminum frame with window finish; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh secured to frame with PVC spline.
- I. Protection Screens: (Full Screen) Held by a top full-width aluminum hinge and two bottom automatic slide latches released from interior; extruded .078" tubular aluminum frame with same finish as window: 1-1/16" x 1-11/16" rails, 1-1/16" x 1-3/8" stiles, 1-1/16" x 2-1/4" mid-height brace bar; corners fastened with tamper-resistant screws; [Enter color and material for woven wire mesh or perforated sheet metal] secured with interior pressure plates fastened with screws concealed with aluminum cover plates.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9100 Windows
 - b. Single Hung Side Load Window
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG40-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG40-H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 40 psf (1915 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 60 psf (2873 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Compant Inc.
 2. Series TR-9700 Windows - Single Hung Side Load
 3. 3-1/4" (82.5 mm) frame depth
 4. AW-PG40-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)

4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.062" (1.57 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9700 Windows - Single Hung Side Load

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Side Load Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Aluminum Automatic Sill Locks
 - b. (Optional) White Bronze Pole Ring on meeting rail

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in exterior applied PVC rigid tracks with two stainless steel leaf springs; 7/16" x 1-1/4" x .045 extruded tubular aluminum frame with window finish; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh secured to frame with PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9800 Windows
 - b. Double Hung Tilt Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG50-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DefinitionS

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG50-H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 50 psf (2400 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 75 psf (3600 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-9800 Windows - Double Hung Tilt
 3. 4" (101.6 mm) frame depth
 4. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)

4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.062" (1.57 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9800 Windows - Double Hung Tilt

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Tilt Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Pole-operated Cam Meeting Rail Lock and Keeper.
 - b. (Optional) Aluminum Automatic Sill Locks.
 - c. (Optional) White Bronze Aluminum Automatic Sill Locks.
 - d. (Optional) Limit Lock to limit sash travel. [Enter travel distance in inches, e.g. 6"]
 - e. Zinc Sash Pivot Bars.
 - f. Black Nylon Tilt Latches, operated with a 3/16" hex key and spring-loaded for automatic jamb engagement when the sash is in the vertical position.
 - g. (Optional) Pole Ring

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.

- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in exterior integral tracks with top pivots and sill automatic latches; 7/16" x 1" x .045 extruded tubular aluminum frame with window finish; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh secured to frame with PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9900 Windows
 - b. Double Hung Side Load Window
 - c. 4-1/2" (114.3 mm) frame depth
 - d. AW-PG50-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG50-H.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 50 psf (2394 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 75 psf (3591 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTOR AND CFR.

8. Thermal Test: Per AAMA 1503, at the prescribed 48" x 72" (1219 x 1829) test size glazed with 1" insulating glass made with 5/16" clear laminated glass exterior, argon gas, and 5/16" clear laminated glass with a hard coat low E coating interior:
 - a. Condensation Resistance Factor: Minimum (46 frame) and (59 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.60 BTU/HR/SQ.FT/°F.
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer company Inc.
 - 2. Series TR-9900 Windows - Double Hung Side Load
 - 3. 4-1/2" (114.3 mm) frame depth
 - 4. AW-PG50-H.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.080" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9900 Windows - Double Hung Side Load

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Side Load Window Typical Hardware:

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Pole Operated Automatic Head Lock.
 - b. White Bronze Automatic Sill Lock and Keeper.
 - c. (Optional) Anti-lockout Keeper.
 - d. (Optional) White Bronze Cam Meeting Rail Lock and Keeper.
 - e. (Optional) White Bronze Meeting Rail Pole Socket.

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) [Optional Full Screen] Held in exterior integral tracks with top pivots and sill automatic latches; 7/16" x 1" x .045 extruded tubular aluminum frame with window finish; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh secured to frame with PVC spline.
- I. Protection Screens: (Full Screen) Held by a top full-width aluminum hinge and two bottom automatic slide latches released from interior; extruded .078" tubular aluminum frame with same finish as window: 1-1/16" x 1-11/16" rails, 1-1/16" x 1-3/8" stiles, 1-1/16" x 2-1/4" mid-height brace bar; corners fastened with tamper-resistant screws; [Enter color and material for woven wire mesh or perforated sheet metal] secured with interior pressure plates fastened with screws concealed with aluminum cover plates.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.

- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.

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2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Side load single hung (AW-PG50-H)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Windows"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99".
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than: 75 (frame) and 76 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than: 61 (frame), 75 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.23 to 0.38 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.23 to 0.38 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s·m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa) with a **10 lb. sill** or 15 lbf/sq. ft. (720 Pa) with a **15 lb. sill**.
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 32 (STC) and 24 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.

2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.41 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- L. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 1. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
(CRF_f) frame not less than 71.
(CRF_g) glass not less than 74.
- M. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 1. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
Temperature Index (I_f) frame not less than 57.
Temperature Index (I_g) glass not less than 77.
- N. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
- O. Air Exfiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Exfiltration Test.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
- P. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **10 lb. Sill**.
 - b. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **10 lb. Sill**.
 - b. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **15 lb. Sill**.
- Q. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-1/4" laminated insulating glass: 35 (STC) and 31 (OITC)

AA™ 5450 (Standard Face) and AA™ 5450 (Beveled Face)

- R. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- S. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- T. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 MANUFACTURERS**

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™5450 Ultra Thermal Singe Hung (Standard Face)
 - 3. Series AA™5450 Ultra Thermal Singe Hung (Beveled Face)
 - 4. 4 5/8" (117.48 mm) frame depth
 - 5. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.

2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Single Hung Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: AW-PG50-H

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Windows: Provide the following operating hardware:
 1. Sash Balances: A Class 5 adjustable spiral balance with stainless steel or other corrosion-resistant components. Two per sash.
 2. Handle: Continuous, integral, bottom sash lift handle.
 3. Sash Lock: White bronze sweep lock and keeper on meeting rails. One or two per sash as required by size. Brushed nickel finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.

- B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 2. Finish: Manufacturer's standard.

EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.

- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch (0.28-mm) diameter, coated aluminum wire.
1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
- D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™, AAMA 2604. Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.6 psf (75 Pa) for CW or 6.2 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Side load double hung (AW-PG50-H)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than 71 (frame) and 76 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than 40 (frame), 74 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.3 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa) with a **10 lb. sill** or 15 lbf/sq. ft. (720 Pa) with a **15 lb. sill**.
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 32 (STC) and 25 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.

AA™ 5450 (Standard Face) and AA™ 5450 (Beveled Face)

- L. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- M. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- N. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify actual dimensions of aluminum framed window openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

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PART 2 - PRODUCTS**2.1 MANUFACTURERS**

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series AA™5450 Ultra Thermal Double Hung (Standard Face)
 3. Series AA™5450 Ultra Thermal Double Hung (Beveled Face)
 4. 4 5/8" (117.48 mm) frame depth
 5. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer:
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Double Hung Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
1. Performance Class and Grade: AW-PG50-H

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads and an interior gasket in accordance with AAMA 702 or ASTM C864.

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2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Windows: Provide the following operating hardware:
 - 1. Sash Balances: A Class 5 adjustable spiral balance with stainless steel or other corrosion-resistant components. Two per sash.
 - 2. Handle: Continuous, integral, bottom and top sash lift handle.
 - 3. Sash Lock: White bronze sweep lock and keeper on meeting rails. One or two per sash as required by size. Brushed nickel finish.
 - 4. Aluminum autolock at top sash lift handle.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

- 5. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
- 6. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
- 7. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 - 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.
 - B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
 - 1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 - 2. Finish: Manufacturer's standard.
- EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.**
- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch (0.28-mm) diameter, coated aluminum wire.
 - 1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
 - D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
 - 1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 - 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permardize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604. Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within windows to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Fixed window (AW-PG70-FW)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than: 78 (frame) and 79 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than: 68 (frame) and 75 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.22 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.19 to 0.37 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32).
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.1 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa).
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 29 (STC) and 23 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.22 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.20 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.34).

AA™5450 (Standard Face) and AA™5450 (Beveled Face)

- L. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™5450 Ultra Thermal Fixed (Standard Face)
 - 3. Series AA™5450 Ultra Thermal Fixed (Beveled Face)
 - 4. 4 5/8" (117.48 mm) frame depth
 - 5. AW-PG70-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Fixed Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: AW-PG70-FW

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: None required

2.6 INSECT SCREENS

- A. General: None required

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.

1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.

- a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal
 - b. Horizontal Sliding (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Windows"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 99" x 79"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

- 1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.

- a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series AA™5450 Ultra Thermal Horizontal Sliding Window
 3. 4 5/8" (117.48 mm) frame depth

4. (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Horizontal Sliding Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- C. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than Single Slide: 76 (frame) and 77 (glass) or Double Slide: 69 (frame) and 77 (glass).
- D. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than Single Slide: 57 (frame) and 73 (glass) or Double Slide: 36 (frame) and 74 (glass).
- E. Thermal Transmittance: Provide aluminum windows tested for thermal performance according to AAMA 1503.
 1. Provide aluminum windows tested for thermal performance according to AAMA 1503, with a thermal transmittance (U-factor) no more than Single Slide: 0.25 BTU/hr/sf/F or Double Slide: 0.28 BTU/hr/sf/F.
 2. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-factor) range of; Single Slide: 0.23 to 0.38 BTU/hr/sf/F or Double Slide: 0.25 to 0.39 BTU/hr/sf/F (Based on center of glass U-factor range 0.10 to 0.32 for triple glazing).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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- F. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- G. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 - 1. Maximum Rate: 0.3 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- H. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 - 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa).
- I. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- J. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.
- L. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass:
XO UNIT = 32 (STC) and 26 (OITC)
XX UNIT = 33 (STC) and 26 (OITC)

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Windows: Provide the following operating hardware:
 - 1. Handle: Continuous, integral pulls.
 - 2. Sash Locks.
 - 3. Composite adjustable tandem roller.
 - 4. Stainless Steel roller track.
 - 5. Standard auto lock.
 - 6. Limit device.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

- 7. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
- 8. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 - 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.
 - B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
 - 1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 - 2. Finish: Manufacturer's standard.
- EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.**
- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch- (0.28-mm-) diameter, coated aluminum wire.
 - 1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
 - D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
 - 1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 - 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12.7 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604. Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.

3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8430TL Single Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG70-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG70-H

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .51 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 55) (Glass = 62).

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
 To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.
13. Sound: Testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (34 STC) and (29 OITC).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8400TL Thermal Windows
 3. Model 8430TL Single Hung Window
 4. 4" (101.6 mm) frame depth
 5. AW-PG70-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 1/4" (6.35 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window System

- A. Series 8400TL Thermal Windows - Single Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8450TL Double Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. H-HC70 / H-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: H-HC70
 - b. Performance Class and Grade: H-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 51) (Glass = 63) .
8. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .52 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Sound: testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (33 STC) and (29 OITC).
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8400TL Thermal Windows
 3. Model 8450TL Double Hung Window
 4. 4" (101.6 mm) frame depth
 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Double Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom and top sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
6. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8410TL Fixed Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 60" x 99" (1524 x 2515 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 60" x 99" (1524 x 2515 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .48 BTU/hr/sf/°F or (____) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503 with 1" (25,4 mm) insulating clear glass, the condensation resistance factor shall not be less than (CRF_f 67) frame and (CRF_g 66) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Sound Performance: When tested in accordance with ASTM E 90 and E 413, the sound transmission loss (STL) shall not be less than 39.
10. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8410TL Fixed Window
 - 4. 4" (101.6 mm) frame depth
 - 5. AW-PG100FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Fixed Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- C. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and mechanically clipped and/or staked, factory sealed frame and vent corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8470TL Horizontal Sliding Window
 - c. 4" (101.6 mm) frame depth
 - d. HS-HC70 / HS-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: HS-HC70
 - b. Performance Class and Grade: HS-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 96" x 80" (2438 x 2032 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 PA).

3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 96" x 80" (2438 x 2032 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Temperature Index Test: (CRF) when tested in accordance with CAN/CSA A440, the Temperature Index shall not be less than (CRF_f 38.2) frame and (CRF_g 61.2) glass
8. Thermal Transmittance Test: (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .55 BTU/hr/sf/°F or () BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test: (CRF) when tested in accordance with AAMA 1503, the condensation resistance factor shall not be less than (CRF_f 50) frame and (CRF_g 61) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound: Testing per ASTM 1801 with 1" insulating glass made with (1/4" annealed exterior with, 1/2" airspace, 1/4" annealed interior): minimum (34 STC) and (29 OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems..

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8470TL Horizontal Sliding Window
 - 4. 4" (101.6 mm) frame depth
 - 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Window - Horizontal Sliding Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Continuous Integral Pulls
2. Stainless Steel Ball Bearing Rollers
3. Stainless Steel Roller Track
4. Plunger Lock

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints.

- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.5.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar material to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.

- b. **Water Infiltration Test:** Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. **Testing Extent:** Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. **Test Reports:** Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
1. Types of aluminum windows include:
 - a. Kawneer Series NX-6000 Windows
 - b. Double Slide Horizontal Sliding Window
 - c. Configurations: XX
 - d. 3-1/4" (83 mm) frame depth
 - e. CW-PG35-HS without reinforcement
 - f. CW-PG55-HS with reinforcement at meeting rail

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: CW-PG35 - 71" x 60" (1803 mm x 1524 mm) -HS without reinforcement.
 - b. Performance Class and Grade: CW-PG55 - 71" x 60" (1803 mm x 1524 mm) -HS with reinforcement in meeting rail.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Leakage: The test specimen shall be tested in accordance with ASTM E283.
 - a. CW-PG35-HS without reinforcement. The air leakage rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 1.6 psf (75 Pa).

- b. CW-PG55-HS with reinforcement in meeting rail. The air leakage rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 6.2 psf (300 pa).
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331.
 - a. CW-PG35-HS without reinforcement. There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
 - b. CW-PG55-HS with reinforcement in meeting rail. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa).
5. Uniform Load Deflection:
 - a. CW-PG35-HS without reinforcement. A minimum static air pressure difference of 35 psf (2633 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
 - b. CW-PG55-HS with reinforcement in meeting rail. A minimum static air pressure difference of 55 psf (2633 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural:
 - a. CW-PG35-HS without reinforcement. A minimum static air pressure difference of 52.5 psf (2514 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
 - b. CW-PG55-HS with reinforcement in meeting rail. A minimum static air pressure difference of 82.5 psf (3950 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.

1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series NX-6000 Windows - Double Slide Horizontal Sliding
 3. 3-1/4" (83 mm) frame depth
 4. CW-PG35-HS without reinforcement
 5. CW-PG55-HS with reinforcement at meeting rail

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-6000 Windows - Double Sliding

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Sliding Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Typical Hardware:
 - a. Black [White] zinc Automatic Handle/Lock.
 - b. Aluminum Automatic Handle/Lock (Finish to match window color).
 - c. White nylon wheel housings with ball bearing brass wheels.
 - d. (Optional) Anti-lift block.

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 - 1. True muntins.
 - 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) [Optional Full Screen] Held in exterior integral tracks with two stainless steel leaf springs; 5/16" x 1-1/2" x .050" extruded [Optional Roll Formed] tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.

- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Leakage Test: Conduct test in accordance with ASTM E783.
 - i. CW-PG35-HS at a minimum uniform static test pressure of 1.6 psf (75 Pa) The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - ii. CW-PG55-HS at a minimum uniform static test pressure of 1.6 psf (75 Pa) The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.

- b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-6400 Windows
 - b. Single Slide Horizontal Sliding Window
 - c. Configuration: OX and XO
 - d. 3-1/4" (83 mm) frame depth
 - e. CW-PG50-HS.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: CW-PG50 - 71" x 60" (1803 mm x 1524 mm) -HS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Leakage: The test specimen shall be tested in accordance with ASTM E283. Air leakage rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 6.2 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331. There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 50 psf (2394 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 75 psf (3591 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series NX-6400 Windows - Single Side Horizontal Sliding
 3. 3-1/4" (83 mm) frame depth
 4. CW-PG50-HS.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-6400 Windows - Single Slide Horizontal Sliding

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Slide Horizontal Sliding Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Black [White] zinc Automatic Handle/Lock.
 - b. White nylon Wheel Housings with ball bearing brass wheels.
 - c. (Optional) Anti-lift block.

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.

- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in frame with two stainless steel leaf springs; 5/16" x 1-1/2" x .050" extruded [Optional Roll Formed] tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Leakage Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.6 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-6800 Windows
 - b. Horizontal Sliding Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG50-HS

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG50-HS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 99" x 79" (2515 x 2007). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 99" x 79" (2515 x 2007). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 50 psf (2394 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 75 psf (3591 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, AIR FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTOR AND CFR.

8. U-Factor Simulation: thermal computer simulation per NFRC 100, at the prescribed 48"x 60" (1219 x 1524) Non-Residential Size, glazed with 1" insulating glass made with 1/8" clear glass with, thermoplastic butyl spacer, air, and 1/8" clear interior glass lite: Thermal Transmittance to be maximum 0.59 BTU/HR/SQ.FT/°F.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series TR-6800 Windows - Horizontal Sliding
 - 3. 3-1/4" (83 mm) frame depth
 - 4. AW-PG50-HS

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.062" (1.57 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-6800 Windows - Horizontal Sliding

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Typical Hardware:
 - a. Stainless Steel Wheel Housings with Adjustable Ball Bearing Stainless Steel Wheel
 - b. Black Zinc Automatic Handle/Lock with Keeper
 - c. (Optional) One stainless steel safety device mounted in the bottom of the pull stile to limit sash travel to (___ Enter travel distance in inches, e.g. 6") when the device is extended into the frame sill keeper secured with one stainless screw.

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 - 1. True muntins.
 - 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Half Screen) Held in exterior integral tracks with two stainless steel leaf springs; 5/16" x 1-1/2" x .050 extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh secured with PVC spline.
- I. Protection Screens: (Full Screen) Held by a top full-width aluminum hinge and two bottom automatic slide latches released from interior; extruded .078" tubular aluminum frame with same finish as window: 1-1/16" x 1-11/16" rails, 1-1/16" x 1-3/8" stiles, 1-1/16" x 2-1/4" mid-width brace bar, corners fastened with tamper-resistant screws; [Enter color and material for woven wire mesh or perforated sheet metal] secured with interior pressure plates fastened with screws concealed with aluminum cover plates.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.

- a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Law and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ UT Windows (Structural Silicone Glazed)
 - b. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - c. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Performance Class and Grade:
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)
2. Air leakage: The test specimen shall be tested in accordance with ASTM E283. Air leakage rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.2 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.6 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa). The test specimen shall meet the B7 rating with no water leakage at 12 psf (575 Pa) when tested in accordance with CAN/CSA-A440-00 Windows;
4. Uniform Load Deflection: A minimum static air pressure difference [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C3, C4 or C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG70-C (with 3-Cam Handles); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-C (with 3-Cam handles); 90 psf (4309 Pa)
5. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.3% of span length.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 60 psf (2873 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 90 psf (4309 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 105 psf (5027 Pa)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-C (with 3-Cam Handles); 105 psf (5027 Pa)
6. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
 - a. Project-Out Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-AP (with 3-Cam handles); 135 psf (6464 Pa)

- b. Outswing Casement Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-C (with 3-Cam handles); 135 psf (6464 Pa)
- 7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
- 8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass:
 - 1) Project-Out: U-Factor not more than .56 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) clear glass, aluminum spacer, and interior 3/16" (4.76 mm) glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- b. 1-3/4" insulating glass:
 - 1) Project-Out and Outswing Casement: U-Factor not more than .23 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- 9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - i. Project-Out: CRF not less than 73 (frame) and 60 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: CRF not less than 80 (frame) and 82 (glass).
 - 2) Project-Out: CRF not less than 81 (frame) and 83 (glass).
- 10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - 1) Project-Out: (I) not less than 68 (frame) and 61 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: (I) not less than 70 (frame) and 73 (glass).
 - 2) Project-Out: (I) not less than 75 (frame) and 81 (glass).
- 11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass made with exterior 3/16" (4.76 mm) clear glass, 3/8" (9.52 mm) aluminum spacer, and interior 7/16" (11.11 mm) laminated clear glass:
 - 1) Project-Out: STC not less than 37; OITC not less than 30.
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 9/16" (14.29 mm) clear laminated glass, 7/8" (22.2 mm) aluminum spacer, and interior 5/16" (7.94 mm) clear laminated glass:
 - 1) Outswing Casement: STC not less than 41; OITC not less than 34.
- 12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
- 13. Blast Mitigation performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
- b. Section B-3.1.2 Testing
- c. Section B-3.1.3 ASTM F2248 Design Approach
- 14. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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- a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
- b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. GLASSvent™ UT Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 - a. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP
 - ii. CW-PG60-AP
 - iii. CW-PG70-AP
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP
 - ii. AW-PG90-AP
 - b. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C
 - ii. CW-PG70-C
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C

ii. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ UT Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.
- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
 - 1. Stainless Steel 4-Bar Hinges
 - 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- 3. Cast white Bronze Cam Handle with Pole Ring
- 4. Cast White Bronze Access Control (Custodial) Locks with Removable Handle

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T5 or 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION**3.1 Examination**

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.2 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 526 Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Operating Window System Performance Requirements:
 - 1. Operating window air tightness shall meet the A3 rating (less than 0.10 cfm/ft² (0.55 m³/h)/m) at 1.57 psf (75 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 - 2. Operating window water tightness shall meet the B5 rating (no water leakage at 10.4 psf (500 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 - 3. Windload resistance for operating windows shall meet the C5 rating when tested with configurations in accordance with CAN/CSA-A440 Windows.
 - 4. Operating windows shall meet performance criteria for ease of operation, sash strength and stiffness in accordance with CAN/CSA-A440 Windows.
 - 5. The thermal transmittance (U-Factor) of the window when tested in accordance with CAN/CSA A440.2 shall be:
 - Inswing Casement U = 0.43 BTU/hr · ft² · F
(2.4 W/m² · °C)
 - Outswing Casement U = 0.42 BTU/hr · ft² · F
(2.4 W/m² · °C)

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(Note to Specifier: Thermal performance depends on glass specified. Above tests were performed using 25mm double glazed insulated glass unit with 0.10 low emmissivity coating on surface 3, argon gas filled interspace and a thermally broken aluminum glazing spacer.)
Test size 4ft x 6ft (1219mm x 1829mm).

6. The condensation index of the frame when tested in accordance with CAN/CSA-A440 Windows shall be:
- | | |
|-------------------|------------|
| Inswing Casement | $I_r = 54$ |
| Outswing Casement | $I_r = 57$ |

1.5 Submittals

- Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- Samples for Verification: For aluminum windows and components required.
- Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- Basis-of-Design Product:
 - Kawneer Company Inc.
 - Series 526 Thermal Windows – Inswing and Outswing Casement
 - 2-1/4" (57.2 mm) frame depth

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- Subject to compliance with requirements, provide a comparable product by the following:
 - Manufacturer: (_____)
 - Series: (_____)
 - Profile dimension: (_____)
 - Performance Grade: (_____)

- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. 526 Thermal Window - Casement

EDITOR NOTE: IF RAIN SCREEN WINDOW IS REQUIRED, ADD THE FOLLOWING:

- B. All glazing pockets shall be vented, pressure equalized and drained to the exterior.
- C. Elastomeric air seal gasket shall be installed around the full perimeter of glass and sealed at corners with silicone sealant. Air seal gasket must provide adhesion with silicone sealant.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Inswing Casement Windows: Provide the following operating hardware:
 - 1. Butt Hinges
 - 2. Cast White Bronze Cam Locks (Standard)
 - 3. Weep Covers
 - 4. 5" Limit Arm (For Min. Frame Width 13.25" to 17.999") or Friction Arm (For Min. Frame Width 18" to 36")

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- 5. Access Control Locks
 - 6. Rainscreen Sash
- C. Outswing Casement Windows: Provide the following operating hardware:
 - 1. Butt Hinges
 - 2. Cast White Bronze Cam Locks (Standard)
 - 3. Weep Covers
 - 4. 5" Limit Arm (For Min. Frame Width 13.25" to 17.124") or Friction Arm (For Min. Frame Width 17.125" to 36")

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

5. Roto-Operator
6. Hook Lock Handle
7. Access Control Locks
8. Rainscreen Sash

2.6 Accessories

- A. Insect Screens: Insect screen frames shall be extruded aluminum finished to match window frame and rigidly joined at the corners. Screen shall be 18 x 16 glassfiber mesh. Splines shall be extruded elastomer removable to permit re-screening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Frame thermal barrier shall be Kawneer IsoPort™ with a minimum of ¼" (6mm) separation consisting of a one piece polyamide strip installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.

2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 526 Thermal Windows
 - b. Project-In or Project-Out Window
 - c. 2-1/4" (57.2 mm) frame depth

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Operating Window System Performance Requirements:
 - 1. Operating window air tightness shall meet the A3 rating (less than 0.10 cfm/ft (0.55 m³/h)/m) at 1.57 psf (75 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 - 2. Operating window water tightness shall meet the B5 rating (no water leakage at 10.4 psf (500 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 - 3. Windload resistance for operating windows shall meet the C5 rating when tested with configurations in accordance with CAN/CSA-A440 Windows.
 - 4. Operating windows shall meet performance criteria for ease of operation, sash strength and stiffness in accordance with CAN/CSA-A440 Windows.
 - 5. The thermal transmittance (U-Factor) of the window when tested in accordance with CAN/CSA A440.2 shall be:
 - Project-In U = 0.43 BTU/hr · ft² · F
(2.4 W/m² · °C)
 - Project-Out U = 0.42 BTU/hr · ft² · F
(2.4 W/m² · °C)

(Note to Specifier: Thermal performance depends on glass specified. Above tests were performed using 25mm double glazed insulated glass unit with 0.10 low emmissivity coating on surface 3, argon gas filled interspace and a thermally broken aluminum glazing spacer.)
Test size 4ft x 6ft (1219mm x 1829mm).

6. The condensation index of the frame when tested in accordance with CAN/CSA-A440 Windows shall be:
- | | |
|-------------|------------|
| Project-In | $I_r = 55$ |
| Project-Out | $I_r = 60$ |

1.5 Submittals

- Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- Samples for Verification: For aluminum windows and components required.
- Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- Basis-of-Design Product:
 - Kawneer Company Inc.
 - Series 526 Thermal Windows - Project-In or Project-Out
 - 2-1/4" (57.2 mm) frame depth

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- Subject to compliance with requirements, provide a comparable product by the following:
 - Manufacturer: (_____)
 - Series: (_____)
 - Profile dimension: (_____)
 - Performance Grade: (_____)

- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. 526 Thermal Windows

EDITOR NOTE: IF RAIN SCREEN WINDOW IS REQUIRED, ADD THE FOLLOWING:

- B. All glazing pockets shall be vented, pressure equalized and drained to the exterior.
- C. Elastomeric air seal gasket shall be installed around the full perimeter of glass and sealed at corners with silicone sealant. Air seal gasket must provide adhesion with silicone sealant.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-In Window: Provide the following operating hardware:
 - 1. 4-Bar Hinges
 - 2. Cast White Bronze Cam Locks (Standard)
 - 3. Weep Covers

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- 4. Access Control Locks
- 5. Pole Ring
- 6. Rainscreen Sash

- C. Project-Out Window: Provide the following operating hardware:
 - 1. 4-Bar Hinges
 - 2. Cast White Bronze Cam Locks (Standard)
 - 3. Weep Covers

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

4. Access Control Locks
5. Pivot Shoe Operator
6. Loose Rivet 4-Bar Hinges
7. Hook Lock Handle
8. Rainscreen Sash

2.6 Accessories

- A. Insect Screens: Insect screen frames shall be extruded aluminum finished to match window frame and rigidly joined at the corners. Screen shall be 18 x 16 glassfiber mesh. Splines shall be extruded elastomer removable to permit re-screening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Frame thermal barrier shall be Kawneer IsoPort™ with a minimum of ¼" (6mm) separation consisting of a one piece polyamide strip installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.

2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 5500 Thermal Windows
 - b. Fixed window
 - c. 4" (102 mm) frame depth
 - d. Architectural Window Grade AW-PG80-F

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 90" (1524 x 2286). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 2. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 90" (1524 x 2286). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (500 Pa). The test specimen shall meet the B5 rating with no water leakage at 500 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 3. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3840 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2874 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
 5. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than .34 BTU/hr/ft²/°F.
7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than (72 frame) and (74 glass), or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than (62 frame) and (66 glass).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 5500 Thermal Windows - Fixed
 3. 4" (102) frame depth
 4. Architectural Window Grade AW-PG80-F

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)

2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 5500 Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

- G. Optional Perimeters and Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
- H. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 5525 Thermal Windows
 - b. Fixed window
 - c. 5" (127 mm) frame depth
 - d. Architectural Window Grade AW-PG75-F

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 90" (1524 x 2286). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 2. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 90" (1524 x 2286). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (500 Pa). The test specimen shall meet the B5 rating with no water leakage at 500 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 3. Uniform Load Deflection: A minimum static air pressure difference of 75 psf (3592 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2874 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
 5. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than .35 BTU/hr/ft²/°F.
7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than (73 frame) and (74 glass), or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than (64 frame) and (66 glass).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 5525 Thermal Windows - Fixed
 3. 5" (127) frame depth
 4. Architectural Window Grade AW-PG75-F

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)

2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 5525 Thermal Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

- G. Optional Perimeters and Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
- H. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Fixed Window
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 6' x 6' (1829 x 1829 mm) for F-HC100 and 5' x 8' (1524 x 2438 mm) for F-AW100. The air infiltration rate shall not exceed 0.06 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 6' x 6' (1829 x 1829 mm) for F-HC100 and 5' x 8' (1524 x 2438 mm) for F-AW100. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI/AAMA 101.
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Fixed
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 7225 (Non-Thermal) Fixed Window

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 1" (25,4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS, SEE THE PANNINGS AND TRIMS SECTION OF THE KAWNEER ARCHITECTURAL WINDOWS MANUAL.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.

3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: When closed and locked, test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 3' x 5' (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² of vent perimeter at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 3' x 5' (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: When closed and locked, a minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: When closed and locked, a minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, hardware parts, support arms, actuating mechanisms or any other damage which would cause the window to be inoperable, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Inswing and Outswing Casement
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW SYSTEM

- A. Series 7225 Non-Thermal Windows - Inswing and Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Roto-Operator
 - e. Multipoint Lock
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Butt Hinges
 - c. Friction Adjusters
 - d. Limit Stop
- 3. Other:
 - a. Pole Ring

b. Pole

C. Optional Egress Hardware Set:

1. Locking:
 - a. Multipoint Lock
2. Hinging:
 - a. Butt Hinges
3. Friction Adjusters

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

D. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:

1. True Muntins
2. Between The Glass Muntins
3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

E. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.

F. Optional Venetian Blinds: 1" aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

G. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:

1. Profiles that are sharp, straight, and free of defects or deformations.
2. Accurately fit joints; make joints flush, hairline and weatherproof.
3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
4. Physical and thermal isolation of glazing from framing members.
5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
6. Provisions for field replacement of glazing.
7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints

C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.

G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).

H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG90-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: When closed and locked, test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 5' x 3' (1524 x 914 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² of vent perimeter at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 5' x 3' (1524 x 914 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: When closed and locked, a minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: When closed and locked, a minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, hardware parts, support arms, actuating mechanisms or any other damage which would cause the window to be inoperable, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Project-In and Project-Out
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG90-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 7225 Non-Thermal Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Projected Windows Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Pivot Shoe Roto-Operator
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- D. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- E. Optional Venetian Blinds: 1" aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8225TL Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
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 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG90-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 36" x 60" (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 36" x 60" (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of $L/175$ of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. Outswing Casement: U-Factor not more than .60 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
 - b. Inswing Casement: U-Factor not more than .62 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. Outswing Casement: (CRF_f) frame not less than 56 with clear glass.
Outswing Casement: (CRF_g) glass not less than 55 with clear glass.
 - b. Inswing Casement: (CRF_f) not less than 56 with clear glass.
Inswing Casement: (CRF_g) not less than 55 with clear glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Inswing and Outswing Casement
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be a Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Inswing and Outswing Casement

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Roto-Operator
 - e. Multipoint Lock
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Butt Hinges
 - c. Friction Adjusters
 - d. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole
- C. Optional Egress Hardware Set:
 - 1. Locking:
 - a. Multipoint Lock
 - 2. Hinging:
 - a. Butt Hinges
 - b. Friction Adjusters
- D. Other:
 - 1. "Escape/Rescue Window" Label

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- E. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 - 1. True Muntins
 - 2. Between The Glass Muntins
 - 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- F. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- G. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- H. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.

- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- 1. Types of aluminum windows include:
 - a. Series 8225TL Thermal Windows
 - b. Fixed Window
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 60" x 99" (1524 x 2515 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 60" x 99" (1524 x 2515 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .58 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503 with clear glass, the condensation resistance factor (CRF) shall not be less than (CRF_f 59) frame and (CRF_g 57) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Sound Performance: When tested in accordance with ASTM E 90, the STC shall not be less than (34) and OITC not less than (28) based on 1" (25.4 mm) IG with 1/2" (12.7 mm) air space.
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Fixed
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8225TL Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG90-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG90-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 36" x 60" (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 36" x 60" (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. Project-Out: U-Factor not more than .60 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
 - b. Project-In: U-Factor not more than .62 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. Project-Out: (CRF_f) frame not less than 56 with clear glass.
Project-Out: (CRF_g) glass not less than 55 with clear glass.
 - b. Project-In: (CRF_f) not less than 56 with clear glass.
Project-In: (CRF_g) not less than 55 with clear glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out with 0.125" wall thickness).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Project-Out with 0.125" wall thickness).
10. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Project-In and Project-Out
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG90-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Project-In and Project-Out

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Windows Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Pivot Shoe Roto-Operator
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 - 1. True Muntins
 - 2. Between The Glass Muntins
 - 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- D. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- E. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.

7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:

1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™6400/6500/6600 Windows
 - b. Inswing and Outswing Casement Windows
 - c. 3-9/16" (90.4 mm) Inswing vent depth or 3-3/8" (85.7 mm) Outswing vent depth
 - d. AW-PG70-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-C

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of $L/175$ of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. Outswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
Inswing Casement: U-Factor not more than .40 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
 - b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 71 (frame) and 69 (glass).
 - b. Inswing Casement: CRF not less than 74 (frame) and 68 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: (I) not less than 62 (frame) and 64 (glass).
 - b. Inswing Casement: (I) not less than 70 (frame) and 68 (glass).
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: STC not less than 35; OITC not less than 28.
- b. Inswing Casement: STC not less than 33; OITC not less than 27.

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED STC AND OITC VALUES

12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum windows through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows - Inswing and Outswing Casement
 - 3. 3-9/16" (90.4 mm) Inswing vent depth or 3-3/8" (85.7 mm) Outswing vent depth
 - 4. AW-PG70-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. **Subject to compliance with requirements, provide a comparable product by the following:**
 - 1. **Manufacturer:** (_____)
 - 2. **Series:** (_____)
 - 3. **Profile dimension:** (_____)
 - 4. **Performance Grade:** (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements.
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid window installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. **Substitution Acceptance:** Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. **Aluminum Extrusions:** Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. **Thermal Barrier:** The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. **Fasteners:** Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. **Anchors, Clips, and Accessories:** Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™6400/6500/6600 Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior TPE gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Single Handle Multi-Point Locks (Standard)
 - b. Cast White Bronze Cam Locks (Outswing Casement)
 - c. Access Control Locks (Outswing Casement)
 - 2. Hinging
 - a. 4-Bar Hinges (Inswing Casement)
 - b. Limit Stop
 - c. Concealed Hinges (Outswing Casement)
 - d. Friction Adjusters
 - 3. Other
 - a. Roto Operator (Outswing Casement)

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 - 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- G. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.

4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and/or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.

- a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™ 6400/6500/6600 Windows
 - b. Fixed Window
 - c. 4" (101.6 mm) AA™ 6400 frame depth, 5" (127 mm) AA™ 6500 frame depth or 6" (152 mm) AA™ 6600 frame depth
 - d. AW-PG70-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Framing System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-FW

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 75 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. U-Factor not more than .31 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than 77 (frame) and 72 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than 73 (frame) and 66 (glass) for AA™6400 and 70 (frame) and 67 (glass) for AA™6500.
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass made with exterior 3/16" clear glass, 3/8" aluminum spacer, and interior 7/16" laminated clear glass:
 - i. STC not less than 38; OITC not less than 32.
- b. 1-3/4" insulating glass made with exterior 1/2" clear laminated glass, 1" aluminum spacer, and interior 1/4" clear laminated glass:
 - i. STC not less than 48; OITC not less than 38.
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows - Fixed
 - 3. 4" (101.6 mm) AA™6400 frame depth, 5" (127 mm) AA™6500 frame depth or 6" (152 mm) AA™6600 frame depth
 - 4. AW-PG70-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window Framing System

- A. Series AA™6400/6500/6600 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior TPE gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (45,72 cm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Framing: Fabricate components for assembly using manufacture's standard installation instructions.
- C. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.
- D. Thermally Improved Construction: Fabricate aluminum window framing with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™ 6400/6500/6600 Windows
 - b. Project-In and Project-Out Windows
 - c. 3-9/16" (90.4 mm) Project-In vent depth or 3-3/8" (85.7 mm) Project-Out vent depth
 - d. AW-PG70-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-AP

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. Project-Out: U-Factor not more than .43 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
Project-In: U-Factor not more than .40 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
 - b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: CRF not less than 71 (frame) and 69 (glass).
 - b. Project-In: CRF not less than 74 (frame) and 68 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: (I) not less than 62 (frame) and 64 (glass).
 - b. Project-In: (I) not less than 70 (frame) and 68 (glass).
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: STC not less than 35; OITC not less than 28.
- b. Project-In: STC not less than 33; OITC not less than 27.

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED STC AND OITC VALUES

12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum windows through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows
 - 3. Project-In and Project-Out
 - 4. 3-9/16" (90.4 mm) Project-In vent depth or 3-3/8" (85.7 mm) Project-Out vent depth
 - 5. AW-PG70-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements.
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid window installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. **Substitution Acceptance:** Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. **Aluminum Extrusions:** Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. **Thermal Barrier:** The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. **Fasteners:** Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™6400/6500/6600 Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Single Handle Multi-Point Locks (Standard) Project-In
 - b. Dual Handle Multi-Point Locks (Standard) Project-Out
 - c. Cast White Bronze Cam Locks (Project-Out)
 - d. Access Control Locks (Project-Out)
 - 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - 3. Other
 - a. Roto Operator (Project-Out)
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 - 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- G. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. C-HC90 / C-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/11.S.2/A440 (NAFS).
 - a. Performance Class and Grade: C-HC90
 - b. Performance Class and Grade: C-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.

4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 720 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: U-Factor not more than .47 BTU/hr/ft²/°F.
- b. Inswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 61 (53.2 I-frame).
- b. Inswing Casement: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Inswing and Outswing Casement
 - 3. 2-5/8" (67 mm) frame depth
 - 4. C-HC90 / C-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.

- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:

1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
 - c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:

1. True muntins.
2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.

- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. C-HC90 / C-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/11.S.2/A440 (NAFS).
 - a. Performance Class and Grade: C-HC90
 - b. Performance Class and Grade: C-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.

4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 720 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Inswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 61 (53.2 I-frame).
- b. Inswing Casement: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Inswing and Outswing Casement
 - 3. 2-5/8" (67 mm) frame depth
 - 4. C-HC90 / C-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.

- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:

1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
 - c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:

1. True muntins.
2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.

- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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END OF SECTION 085113

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 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. AP-HC90 / AP-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

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 8. 084433 "Sloped Glazing Assemblies"
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- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AP-HC90
 - b. Performance Class and Grade: AP-AW90

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EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 6.24 psf (300 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Project-In: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: CRF not less than 61 (53.2 I-frame).
- b. Project-In: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Project-Out only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Project-In and Project-Out
 - 3. 2-5/8" (67 mm) frame depth
 - 4. AP-HC90 / AP-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window System

- A. Series AA™ 900 Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
- c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
3. Other
 - a. Roto Operator (Project-Out)
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.

2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.

- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ Windows (Structural Silicone Glazed)
 - b. Project-Out and Outswing Casement Windows
 - c. 2-11/16" (68.3 mm) system depth (1/4" Infill), 3-7/16" (87.3 mm) system depth (1" Infill)
 - d. AW-PG90-AP/AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 078466 "Fire-Resistant Joint systems"
 3. 079200 "Joint Sealants"
 4. 083213 "Sliding Aluminum-Framed Glass Doors"
 5. 084113 "Aluminum-Framed Entrances and Windows"
 6. 084313 "Aluminum-Framed Windows"
 7. 084329 "Sliding Windows"
 8. 084413 "Glazed Aluminum Curtain Walls"
 9. 084433 "Sloped Glazing Assemblies"
 10. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-AP/AW-PG90-C
2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914) Project-Out or 36" x 60" (914 x 1524) Casement Outswing. Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914) Project-Out or 36" x 60" (914 x 1524) Casement Outswing. There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of $L/175$ of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6464 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
7. Thermal testing per AAMA 1503 within 1600 Wall System™1, at the prescribed 59" x 24" (1500 x 600) test size glazed using a single lite of 1" insulating glass composed of 1/4" clear low-E .035 #2, 1/2" air space with warm edge spacer, 1/4" clear with the following results:
 - a. Condensation Resistance Factor: Minimum (51 frame) and (63 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.72 BTU/hr/ft²/°F U-value

or

Thermal Transmittance Test: (U-Factor): The conductive thermal transmittance (U-Factor) shall not be more than (____) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

8. Sound: Testing per ASTM E 90 glazed with 1" insulating glass made with exterior 1/4" laminated glass x 1/2" air space x interior 1/4" laminated glass: Minimum (31 STC) and (26 OITC).
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Blast Mitigation performance: Tested per ASTM F 1642, GSA-TS01, and UFC 04-010-01 at a peak pressure of 6 psi and a 41 psi-msec impulse. The system shall achieve a minimum "Low Hazard" rating per ASTM F1642-04, a "Performance Condition 3b" per GSA and a "Low Level of Protection" per UFC 4-010-01 (Project-Out only).

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
- b. Section B-3.1.2 Testing
- c. Section B-3.1.3 ASTM F2248 Design Approach

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. GLASSvent™ Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 3. 2-11/16" (68.3 mm) system depth (1/4" Infill), 3-7/16" (87.3 mm) system depth (1" Infill)
 4. AW-PG90-AP/AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.
- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
 1. 4-Bar Hinges
 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

3. Stainless Steel 4-Bar Hinges
4. Cast white Bronze Cam Handle with Pole Ring
5. Cast White Bronze Access Control (Custodial) Locks with Removable Handle
6. Cast White Bronze Concealed Lock and Key

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION**3.1 Examination**

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: HC40 IS THE CLASS AND GRADE GLAZED WITH 1" GLASS AND TWO (2) CAM LOCKS. HC70 IS THE CLASS AND GRADE GLAZED WITH 1" GLASS AND THREE (3) CAM LOCKS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ Windows (Structural Silicone Glazed)
 - b. Project-Out and Outswing Casement Windows
 - c. 2-3/16" (55.5 mm) system depth (1/4" Infill), 2-13/16" (71.4 mm) system depth (1" Infill)
 - d. (P-HC40 – P-HC70) Project-Out Window, (C-HC40 – C-HC70) Outswing Casement Window

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 078466 "Fire-Resistant Joint systems"
 - 3. 079200 "Joint Sealants"
 - 4. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 5. 084113 "Aluminum-Framed Entrances and Windows"
 - 6. 084313 "Aluminum-Framed Windows"
 - 7. 084329 "Sliding Windows"
 - 8. 084413 "Glazed Aluminum Curtain Walls"
 - 9. 084433 "Sloped Glazing Assemblies"
 - 10. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: (P-HC40 – P-HC70) Project-Out Window
 - b. Performance Class and Grade: (C-HC40 – C-HC70) Outswing Casement Window
- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915) Project-Out or 36" x 60" (915 x 1524) Casement Outswing. Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915) Project-Out or 36" x 60" (915 x 1524) Casement Outswing. There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of (40 psf (1915 Pa)(2 Locks)) or (70 psf (3352 Pa)(3 Locks)) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural: A minimum static air pressure difference of (60 psf (2873 Pa)(2 Locks)) or (105 psf (5027)(3 Locks)) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS. (1/8" – 3/4" AS – 1/8")

7. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out Windows: 0.68 BTU/hr/ft²/°F. (NFRC – 0.62) or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
 - b. Outswing Casement Windows: 0.67 BTU/hr/ft²/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than; Frame 51, Glass 54.
or
a. Condensation Index (I): when tested to CSA-A440-00, the condensation index shall not be less than; Frame 47, Glass 48.
 9. Thermal Transmittance Test: (U-Factor): The conductive thermal transmittance (U-Factor) shall not be more than (____) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
 10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than: 47.7.
 11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
 12. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) above grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.

1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. GLASSvent™ Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 3. 2-3/16" (55.5 mm) system depth (1/4" Infill), 2-13/16" (71.4 mm) system depth (1" Infill)
 4. (P-HC40 – P-HC70) Project-Out Window, (C-HC40 – C-HC70) Outswing Casement Window

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.

- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

2.5 Hardware

EDITOR NOTE: BELOW HARDWARE ITEMS ARE PRODUCT SPECIFIC. EACH PRODUCT TYPE HAS HARDWARE STANDARDS AND OPTIONS; OPTIONS ARE COST/BUDGET RELATED. CONSULT WITH KAWNEER REPRESENTATIVE FOR PARTICULAR HARDWARE REQUIREMENTS FOR SPECIFIC WINDOW TYPE SELECTED.

EDITOR NOTE: REVISE BELOW FOR SPECIFIC HARDWARE FOR EACH SPECIFIC WINDOW TYPE. SEE HARDWARE SELECTION GUIDE FOR HARDWARE OPTIONS OR CONTACT YOUR KAWNEER REPRESENTATIVE.

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
1. Stainless Steel 4-Bar Hinges
 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- C. Project-Out Windows
1. Cast White Bronze Cam Handle with Pole Ring
 2. Cast White Bronze Access Control (Custodial) Locks with Removable Handle
 3. Cast White Bronze Concealed Lock and Key
 4. Cast White Bronze Pull Ring
 5. Pivot-shoe Roto Operator
- D. Outswing Casement Windows
1. Cast White Bronze Cam Handle with Pole Ring
 2. Cast White Bronze Access Control (Custodial) Locks with Removable Handle

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-310 Windows
 - b. Outswing Casement Window
 - c. 3-1/4" (83 mm) frame depth
 - d. C-HC40

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: C-HC40.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 24" x 48" (610 x 1219). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 24" x 48" (610 x 1219). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2873 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, AIR FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTOR AND CFR.

7. U-Factor Simulation: thermal computer simulation per NFRC 100, at the prescribed 24" x 59" (610 X 1499) Non-Residential Size, glazed with 1" insulating glass (1/8" Solarban 60, thermoplastic butyl spacer, air, 1/8" clear): Thermal Transmittance to be maximum 0.48 BTU/HR/SQ.FT/°F.
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series NX-310 Windows - Outswing Casement
 3. 3-1/4" (83 mm) frame depth
 4. C-HC40

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-310 Windows - Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Outswing Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Typical Hardware:
 - a. White Bronze Cam Handles with metal strikes
 - b. (Optional) White Bronze Custodial Locks with 1/4" Hex Key
 - c. Concealed Stainless Steel Hinges (Standard)
 - d. (Optional) Aluminum Butt Hinges
 - e. (Optional) Stainless Steel Limit Arm
 - f. (Optional) Roto Operator

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with snap clips; handle-access wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-3100 Windows
 - b. Outswing Casement Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-C.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (915 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (915 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTOR AND CFR.

8. U-Factor Simulation: thermal computer simulation per NFRC 100, at the prescribed 24" x 60" (610 x 1524) Non-Residential Size, glazed with 1" insulating glass made with exterior 1/4" Solarban 60 glass, thermoplastic butyl spacer, argon gas, and interior 1/4" clear glass: Thermal Transmittance to be maximum 0.49 BTU/HR/SQ.FT/°F U value.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Sound: testing per ASTM E90 with 1" insulating glass (1/8", air, 1/4"): 34 STC and (27 OITC).
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series NX-3100 Windows - Outswing Casement
 3. 3-1/4" (83 mm) frame depth
 4. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-3100 Windows - Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.

- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Outswing Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Cast White Bronze Cam Handles and Strikes
 - b. Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with steel spring clips; handle-access wickets [Enter wicket color choice; White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.

1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.

- b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-3200 Windows
 - b. Inswing Casement Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-C.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (915 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (915 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTOR AND CFR.

8. U-Factor Simulation: thermal computer simulation per NFRC 100, at the prescribed 24" x 60" (610 x 1524) Non-Residential Size, glazed with 1" insulating glass made with exterior 1/4" Solarban 60 low E glass, thermoplastic butyl spacer, argon gas, and interior 1/4" clear glass: Thermal Transmittance to be not more than 0.45 BTU/HR/SQ.FT/°F U value.
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series NX-3200 Windows - Inswing Casement
 - 3. 3-1/4" (83 mm) frame depth
 - 4. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-3200 Windows - Inswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Inswing Casement Window Typical Hardware:

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Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Cast White Bronze Cam Handles and Strikes
 - b. Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.

- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-3700 Windows
 - b. Dual Action Window
 - c. 3-1/4" (83 mm) frame depth
 - d. DAW-AW50

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: DAW-AW50.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 50 psf (2394 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 75 psf (3591 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series NX-3700 Windows - Dual Action
 3. 3-1/4" (83 mm) frame depth
 4. DAW-AW50

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-3700 Windows - Dual Action

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Dual Action Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Option 1: Logical Operation; First motion tilt, second motion turn inward.
 - b. Option 2: Traditional Operation; First motion turn inward, second motion tilt.
 - c. Option 3: Turn-in motion only.
 - d. Handle Finish: White, Black, Silver or Satin Nickel.
 - e. (Optional) Custodial Handle locking out first motion.
 - f. (Optional) Custodial Handle locking out all motion.
 - g. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass or aluminum mesh; PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Fixed Window
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-FW.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .19 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
(CRF_f) frame not less than 78.
(CRF_g) glass not less than 82.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass:
Temperature Index (I_f) frame not less than 67.
Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.

- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Fixed
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 5/8" (15.9 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.

2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Inswing or Outswing Casement Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).

5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade (Outswing Casement only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Outswing Casement only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - 33 (STC) and 26 (OITC).

- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...
Enter the following for an AAMA 2605 70% fluoropolymer paint finish
 - 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.4) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**

4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
6. Coating: **consult your Kawneer representative**

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 3. Patterns: grid patterns to be designated by architect.
 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 3. Interior: (two-piece snap trim;) (stool cover).
 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access **Enter wicket color choice: white, bronze, or black** wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.)

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800-07, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Project-Out only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 33 (STC) and 26 (OITC).
 - b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...
Enter the following for an AAMA 2605 70% fluoropolymer paint finish
 - 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.5) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
 1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].

- c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
- 6. Coating: *consult your Kawneer representative*

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 - 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 - 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 - 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 - 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 - 3. Patterns: grid patterns to be designated by architect.
 - 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 - 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 - 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 - 3. Interior: (two-piece snap trim;) (stool cover).
 - 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access *Enter wicket color choice: white, bronze, or black* wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
 - C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
 - D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
 - E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
 - F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
 - G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
 - H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-2100 Windows
 - b. Outswing Casement Window
 - c. 2-1/4" (57 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG80-C.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (915 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (915 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3840 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5760 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-2100 Windows - Outswing Casement
 3. 2-1/4" (57 mm) frame depth
 4. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-2100 Windows - Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Outswing Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Typical Hardware:
 - a. Cast White Bronze Cam Handles and Strikes
 - b. (Optional) Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

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Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with swivel clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-2200 Windows
 - b. Inswing Casement Window
 - c. 2-1/4" (57 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-C.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (915 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (915 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3832 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5748 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-2200 Windows - Inswing Casement
 3. 2-1/4" (57 mm) frame depth
 4. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-2200 Windows - Inswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Inswing Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Typical Hardware:
 - a. Cast White Bronze Cam Handles and Strikes
 - b. (Optional) Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 5/16" x 1-1/2" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-3100 Windows
 - b. Outswing Casement Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG80-C.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3840 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5760 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, AIR FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTOR AND CFR.

8. Thermal computer simulation: Per NFRC 100, at the prescribed 30" x 60" (914 x 1524) Non-Residential Size, glazed with 1" insulating glass made with exterior 1/4" bronze, 1/2" air, and interior 1/4" AFG Confort E2 glass: Thermal Transmittance to be maximum 0.60 BTU/HR/SQ.FT/°F U-Factor.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, b-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 Manufacturers**

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series TR-3100 Windows - Outswing Casement
 3. 3-1/4" (83 mm) frame depth
 4. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.080" (2.03 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-3100 Windows - Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Outswing Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles with Strikes
 - b. Stainless Steel Limit Arm with Release Key
 - c. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with steel spring clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.

- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-3200 Windows
 - b. Inswing Casement Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-C.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-3200 Windows - Inswing Casement
 3. 3-1/4" (83 mm) frame depth
 4. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.080" (2.03 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-3200 Windows - Inswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Inswing Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles with Strikes
 - b. (Optional) Stainless Steel Limit Arm with Release Key
 - c. Concealed Stainless Steel Hinges

2.6 ACCESSORIES

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.

- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 5/16" x 1-1/2" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-710 Windows
 - b. Outswing Casement Window
 - c. 4-5/8" (117.5 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
 - a. Performance Class and Grade: AW-PG80-C.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (915 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (915 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-710 Windows - Outswing Casement
 3. 4-5/8" (117.5 mm) frame depth
 4. AW-PG80-C.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 1.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-710 Windows - Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Outswing Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Cast White Bronze Cam Handles and Strikes
 - b. (Optional) Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

2.6 ACCESSORIES

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.

- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with swivel clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-720 Windows
 - b. Inswing Casement Window
 - c. 4-5/8" (117.5 mm) frame depth
 - d. AW-PG80-C.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
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 - 5. 084313 "Aluminum-Framed Storefronts"
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 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG80-C.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (915 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (915 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-720 Windows - Inswing Casement
 3. 4-5/8" (117.5 mm) frame depth
 4. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-720 Windows - Inswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Inswing Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Cast White Bronze Cam Handles and Strikes
 - b. (Optional) Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.

- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 5/16" x 1-1/2" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ UT Windows (Structural Silicone Glazed)
 - b. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - c. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Performance Class and Grade:
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles)
 - ii. CW-PG60-AP (with 3-Cam Handles)
 - iii. CW-PG70-AP (with Roto Operator and Hook Lock)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles)
 - ii. CW-PG70-C (with 3-Cam Handles)
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock)
 - ii. AW-PG90-C (with 3-Cam handles)
2. Air leakage: The test specimen shall be tested in accordance with ASTM E283. Air leakage rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.2 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.6 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa). The test specimen shall meet the B7 rating with no water leakage at 12 psf (575 Pa) when tested in accordance with CAN/CSA-A440-00 Windows;
4. Uniform Load Deflection: A minimum static air pressure difference [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C3, C4 or C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-AP (with 3-Cam handles)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 40 psf (1915 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG70-C (with 3-Cam Handles); 70 psf (3552 Pa)
 - 3) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 80 psf (3830 pa)
 - ii. AW-PG90-C (with 3-Cam handles); 90 psf (4309 Pa)
5. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.3% of span length.
 - a. Project-Out Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP (with 2-Cam Handles); 60 psf (2873 Pa)
 - 2) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG60-AP (with 3-Cam Handles); 90 psf (4309 Pa)
 - ii. CW-PG70-AP (with Roto Operator and Hook Lock); 105 psf (5027 Pa)
 - b. Outswing Casement Windows:
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C (with 2-Cam Handles); 60 psf (2873 Pa)
 - ii. CW-PG70-C (with 3-Cam Handles); 105 psf (5027 Pa)
6. Uniform Load Structural: A minimum static air pressure difference of [choose from below] shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
 - a. Project-Out Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-AP (with 3-Cam handles); 135 psf (6464 Pa)

- b. Outswing Casement Windows:
 - 1) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C (with Roto Operator and Hook Lock); 120 psf (5746 Pa)
 - ii. AW-PG90-C (with 3-Cam handles); 135 psf (6464 Pa)
- 7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
- 8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass:
 - 1) Project-Out: U-Factor not more than .56 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) clear glass, aluminum spacer, and interior 3/16" (4.76 mm) glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- b. 1-3/4" insulating glass:
 - 1) Project-Out and Outswing Casement: U-Factor not more than .23 BTU/hr/ft²/°F per AAMA 1503 with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass.
or
 - 2) U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- 9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - i. Project-Out: CRF not less than 73 (frame) and 60 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: CRF not less than 80 (frame) and 82 (glass).
 - 2) Project-Out: CRF not less than 81 (frame) and 83 (glass).
- 10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) clear insulating glass with aluminum spacer:
 - 1) Project-Out: (I) not less than 68 (frame) and 61 (glass).
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 3/16" (4.76 mm) low E glass, 19/32" (15.08 mm) Warm Edge spacer, argon gas, center 3/16" (4.76 mm) low E glass 19/32" (15.08 mm) Warm Edge spacer, argon gas, and interior 3/16" (4.76 mm) clear glass:
 - 1) Outswing Casement: (I) not less than 70 (frame) and 73 (glass).
 - 2) Project-Out: (I) not less than 75 (frame) and 81 (glass).
- 11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" (25.4 mm) insulating glass made with exterior 3/16" (4.76 mm) clear glass, 3/8" (9.52 mm) aluminum spacer, and interior 7/16" (11.11 mm) laminated clear glass:
 - 1) Project-Out: STC not less than 37; OITC not less than 30.
- b. 1-3/4" (44.45 mm) insulating glass made with exterior 9/16" (14.29 mm) clear laminated glass, 7/8" (22.2 mm) aluminum spacer, and interior 5/16" (7.94 mm) clear laminated glass:
 - 1) Outswing Casement: STC not less than 41; OITC not less than 34.
- 12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
- 13. Blast Mitigation performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
- b. Section B-3.1.2 Testing
- c. Section B-3.1.3 ASTM F2248 Design Approach
- 14. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
- b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. GLASSvent™ UT Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 - a. Project-Out Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-AP
 - ii. CW-PG60-AP
 - iii. CW-PG70-AP
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-AP
 - ii. AW-PG90-AP
 - b. Outswing Casement Windows
 - 1) 3-1/8" (79.4 mm); 3-7/8" (98.4 mm) Overall System Depth
 - i. CW-PG40-C
 - ii. CW-PG70-C
 - 2) 4-3/8" (111.1 mm); 5-1/8" (130.2 mm) Overall System Depth
 - i. AW-PG80-C

ii. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ UT Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.
- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
 - 1. Stainless Steel 4-Bar Hinges
 - 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- 3. Cast white Bronze Cam Handle with Pole Ring
- 4. Cast White Bronze Access Control (Custodial) Locks with Removable Handle

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T5 or 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

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2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.2 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 526 Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Operating Window System Performance Requirements:
 1. Operating window air tightness shall meet the A3 rating (less than 0.10 cfm/ft² (0.55 m³/h)/m) at 1.57 psf (75 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 2. Operating window water tightness shall meet the B5 rating (no water leakage at 10.4 psf (500 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 3. Windload resistance for operating windows shall meet the C5 rating when tested with configurations in accordance with CAN/CSA-A440 Windows.
 4. Operating windows shall meet performance criteria for ease of operation, sash strength and stiffness in accordance with CAN/CSA-A440 Windows.
 5. The thermal transmittance (U-Factor) of the window when tested in accordance with CAN/CSA A440.2 shall be:

Inswing Casement	U = 0.43 BTU/hr · ft ² · F (2.4 W/m ² · °C)
Outswing Casement	U = 0.42 BTU/hr · ft ² · F (2.4 W/m ² · °C)

(Note to Specifier: Thermal performance depends on glass specified. Above tests were performed using 25mm double glazed insulated glass unit with 0.10 low emmissivity coating on surface 3, argon gas filled interspace and a thermally broken aluminum glazing spacer.)
Test size 4ft x 6ft (1219mm x 1829mm).

6. The condensation index of the frame when tested in accordance with CAN/CSA-A440 Windows shall be:
- | | |
|-------------------|------------|
| Inswing Casement | $I_r = 54$ |
| Outswing Casement | $I_r = 57$ |

1.5 Submittals

- Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- Samples for Verification: For aluminum windows and components required.
- Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- Basis-of-Design Product:
 - Kawneer Company Inc.
 - Series 526 Thermal Windows – Inswing and Outswing Casement
 - 2-1/4" (57.2 mm) frame depth

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- Subject to compliance with requirements, provide a comparable product by the following:
 - Manufacturer: (_____)
 - Series: (_____)
 - Profile dimension: (_____)
 - Performance Grade: (_____)

- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. 526 Thermal Window - Casement

EDITOR NOTE: IF RAIN SCREEN WINDOW IS REQUIRED, ADD THE FOLLOWING:

- B. All glazing pockets shall be vented, pressure equalized and drained to the exterior.
- C. Elastomeric air seal gasket shall be installed around the full perimeter of glass and sealed at corners with silicone sealant. Air seal gasket must provide adhesion with silicone sealant.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Inswing Casement Windows: Provide the following operating hardware:
 - 1. Butt Hinges
 - 2. Cast White Bronze Cam Locks (Standard)
 - 3. Weep Covers
 - 4. 5" Limit Arm (For Min. Frame Width 13.25" to 17.999") or Friction Arm (For Min. Frame Width 18" to 36")

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- 5. Access Control Locks
 - 6. Rainscreen Sash
- C. Outswing Casement Windows: Provide the following operating hardware:
 - 1. Butt Hinges
 - 2. Cast White Bronze Cam Locks (Standard)
 - 3. Weep Covers
 - 4. 5" Limit Arm (For Min. Frame Width 13.25" to 17.124") or Friction Arm (For Min. Frame Width 17.125" to 36")

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

5. Roto-Operator
6. Hook Lock Handle
7. Access Control Locks
8. Rainscreen Sash

2.6 Accessories

- A. Insect Screens: Insect screen frames shall be extruded aluminum finished to match window frame and rigidly joined at the corners. Screen shall be 18 x 16 glassfiber mesh. Splines shall be extruded elastomer removable to permit re-screening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Frame thermal barrier shall be Kawneer IsoPort™ with a minimum of ¼" (6mm) separation consisting of a one piece polyamide strip installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.

2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 526 Thermal Windows
 - b. Project-In or Project-Out Window
 - c. 2-1/4" (57.2 mm) frame depth

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Operating Window System Performance Requirements:
 - 1. Operating window air tightness shall meet the A3 rating (less than 0.10 cfm/ft (0.55 m³/h)/m) at 1.57 psf (75 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 - 2. Operating window water tightness shall meet the B5 rating (no water leakage at 10.4 psf (500 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 - 3. Windload resistance for operating windows shall meet the C5 rating when tested with configurations in accordance with CAN/CSA-A440 Windows.
 - 4. Operating windows shall meet performance criteria for ease of operation, sash strength and stiffness in accordance with CAN/CSA-A440 Windows.
 - 5. The thermal transmittance (U-Factor) of the window when tested in accordance with CAN/CSA A440.2 shall be:
 - Project-In U = 0.43 BTU/hr · ft² · F
(2.4 W/m² · °C)
 - Project-Out U = 0.42 BTU/hr · ft² · F
(2.4 W/m² · °C)

(Note to Specifier: Thermal performance depends on glass specified. Above tests were performed using 25mm double glazed insulated glass unit with 0.10 low emmissivity coating on surface 3, argon gas filled interspace and a thermally broken aluminum glazing spacer.)
Test size 4ft x 6ft (1219mm x 1829mm).

6. The condensation index of the frame when tested in accordance with CAN/CSA-A440 Windows shall be:
- | | |
|-------------|------------|
| Project-In | $I_r = 55$ |
| Project-Out | $I_r = 60$ |

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 526 Thermal Windows - Project-In or Project-Out
 3. 2-1/4" (57.2 mm) frame depth

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)

- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. 526 Thermal Windows

EDITOR NOTE: IF RAIN SCREEN WINDOW IS REQUIRED, ADD THE FOLLOWING:

- B. All glazing pockets shall be vented, pressure equalized and drained to the exterior.
- C. Elastomeric air seal gasket shall be installed around the full perimeter of glass and sealed at corners with silicone sealant. Air seal gasket must provide adhesion with silicone sealant.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-In Window: Provide the following operating hardware:
 - 1. 4-Bar Hinges
 - 2. Cast White Bronze Cam Locks (Standard)
 - 3. Weep Covers

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- 4. Access Control Locks
- 5. Pole Ring
- 6. Rainscreen Sash

- C. Project-Out Window: Provide the following operating hardware:
 - 1. 4-Bar Hinges
 - 2. Cast White Bronze Cam Locks (Standard)
 - 3. Weep Covers

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

4. Access Control Locks
5. Pivot Shoe Operator
6. Loose Rivet 4-Bar Hinges
7. Hook Lock Handle
8. Rainscreen Sash

2.6 Accessories

- A. Insect Screens: Insect screen frames shall be extruded aluminum finished to match window frame and rigidly joined at the corners. Screen shall be 18 x 16 glassfiber mesh. Splines shall be extruded elastomer removable to permit re-screening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Frame thermal barrier shall be Kawneer IsoPort™ with a minimum of ¼" (6mm) separation consisting of a one piece polyamide strip installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.

2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 5500 Thermal Windows
 - b. Fixed window
 - c. 4" (102 mm) frame depth
 - d. Architectural Window Grade AW-PG80-F

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 90" (1524 x 2286). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 - 2. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 90" (1524 x 2286). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (500 Pa). The test specimen shall meet the B5 rating with no water leakage at 500 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 - 3. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3840 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 - 4. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2874 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
 - 5. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than .34 BTU/hr/ft²/°F.
7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than (72 frame) and (74 glass), or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than (62 frame) and (66 glass).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 5500 Thermal Windows - Fixed
 3. 4" (102) frame depth
 4. Architectural Window Grade AW-PG80-F

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)

2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 5500 Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

- G. Optional Perimeters and Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
- H. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 5525 Thermal Windows
 - b. Fixed window
 - c. 5" (127 mm) frame depth
 - d. Architectural Window Grade AW-PG75-F

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 90" (1524 x 2286). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 2. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 90" (1524 x 2286). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (500 Pa). The test specimen shall meet the B5 rating with no water leakage at 500 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 3. Uniform Load Deflection: A minimum static air pressure difference of 75 psf (3592 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2874 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
 5. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than .35 BTU/hr/ft²/°F.
7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than (73 frame) and (74 glass), or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than (64 frame) and (66 glass).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 5525 Thermal Windows - Fixed
 3. 5" (127) frame depth
 4. Architectural Window Grade AW-PG75-F

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)

2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 5525 Thermal Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

- G. Optional Perimeters and Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
- H. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Fixed Window
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 6' x 6' (1829 x 1829 mm) for F-HC100 and 5' x 8' (1524 x 2438 mm) for F-AW100. The air infiltration rate shall not exceed 0.06 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 6' x 6' (1829 x 1829 mm) for F-HC100 and 5' x 8' (1524 x 2438 mm) for F-AW100. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI/AAMA 101.
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Fixed
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 7225 (Non-Thermal) Fixed Window

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 1" (25,4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS, SEE THE PANNINGS AND TRIMS SECTION OF THE KAWNEER ARCHITECTURAL WINDOWS MANUAL.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.

3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: When closed and locked, test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 3' x 5' (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² of vent perimeter at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 3' x 5' (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: When closed and locked, a minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Uniform Load Structural Test: When closed and locked, a minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, hardware parts, support arms, actuating mechanisms or any other damage which would cause the window to be inoperable, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Inswing and Outswing Casement
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW SYSTEM

- A. Series 7225 Non-Thermal Windows - Inswing and Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Roto-Operator
 - e. Multipoint Lock
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Butt Hinges
 - c. Friction Adjusters
 - d. Limit Stop
- 3. Other:
 - a. Pole Ring

b. Pole

C. Optional Egress Hardware Set:

1. Locking:
 - a. Multipoint Lock
2. Hinging:
 - a. Butt Hinges
3. Friction Adjusters

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

D. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:

1. True Muntins
2. Between The Glass Muntins
3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

E. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.

F. Optional Venetian Blinds: 1" aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

G. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:

1. Profiles that are sharp, straight, and free of defects or deformations.
2. Accurately fit joints; make joints flush, hairline and weatherproof.
3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
4. Physical and thermal isolation of glazing from framing members.
5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
6. Provisions for field replacement of glazing.
7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints

C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.

G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).

H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG90-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: When closed and locked, test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 5' x 3' (1524 x 914 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² of vent perimeter at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 5' x 3' (1524 x 914 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: When closed and locked, a minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: When closed and locked, a minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, hardware parts, support arms, actuating mechanisms or any other damage which would cause the window to be inoperable, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Project-In and Project-Out
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG90-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 7225 Non-Thermal Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Projected Windows Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Pivot Shoe Roto-Operator
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- D. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- E. Optional Venetian Blinds: 1" aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

1. Types of aluminum windows include:
 - a. Kawneer Series 8225TL Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG90-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 36" x 60" (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 36" x 60" (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of $L/175$ of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. Outswing Casement: U-Factor not more than .60 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
 - b. Inswing Casement: U-Factor not more than .62 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. Outswing Casement: (CRF_f) frame not less than 56 with clear glass.
Outswing Casement: (CRF_g) glass not less than 55 with clear glass.
 - b. Inswing Casement: (CRF_f) not less than 56 with clear glass.
Inswing Casement: (CRF_g) not less than 55 with clear glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Inswing and Outswing Casement
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be a Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Inswing and Outswing Casement

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Roto-Operator
 - e. Multipoint Lock
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Butt Hinges
 - c. Friction Adjusters
 - d. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole
- C. Optional Egress Hardware Set:
 - 1. Locking:
 - a. Multipoint Lock
 - 2. Hinging:
 - a. Butt Hinges
 - b. Friction Adjusters
- D. Other:
 - 1. "Escape/Rescue Window" Label

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- E. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 - 1. True Muntins
 - 2. Between The Glass Muntins
 - 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- F. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- G. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- H. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.

- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

1. Types of aluminum windows include:
 - a. Series 8225TL Thermal Windows
 - b. Fixed Window
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 60" x 99" (1524 x 2515 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 60" x 99" (1524 x 2515 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .58 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503 with clear glass, the condensation resistance factor (CRF) shall not be less than (CRF_f 59) frame and (CRF_g 57) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Sound Performance: When tested in accordance with ASTM E 90, the STC shall not be less than (34) and OITC not less than (28) based on 1" (25.4 mm) IG with 1/2" (12.7 mm) air space.
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Fixed
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

1. Types of aluminum windows include:
 - a. Kawneer Series 8225TL Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG90-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG90-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 36" x 60" (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 36" x 60" (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of $L/175$ of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. Project-Out: U-Factor not more than .60 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
 - b. Project-In: U-Factor not more than .62 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. Project-Out: (CRF_f) frame not less than 56 with clear glass.
Project-Out: (CRF_g) glass not less than 55 with clear glass.
 - b. Project-In: (CRF_f) not less than 56 with clear glass.
Project-In: (CRF_g) not less than 55 with clear glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out with 0.125" wall thickness).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Project-Out with 0.125" wall thickness).
10. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Project-In and Project-Out
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG90-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Windows Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Pivot Shoe Roto-Operator
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 - 1. True Muntins
 - 2. Between The Glass Muntins
 - 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- D. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- E. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.

7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:

1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™6400/6500/6600 Windows
 - b. Inswing and Outswing Casement Windows
 - c. 3-9/16" (90.4 mm) Inswing vent depth or 3-3/8" (85.7 mm) Outswing vent depth
 - d. AW-PG70-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-C

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of $L/175$ of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. Outswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
Inswing Casement: U-Factor not more than .40 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
 - b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 71 (frame) and 69 (glass).
 - b. Inswing Casement: CRF not less than 74 (frame) and 68 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: (I) not less than 62 (frame) and 64 (glass).
 - b. Inswing Casement: (I) not less than 70 (frame) and 68 (glass).
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: STC not less than 35; OITC not less than 28.
- b. Inswing Casement: STC not less than 33; OITC not less than 27.

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED STC AND OITC VALUES

12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum windows through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows - Inswing and Outswing Casement
 - 3. 3-9/16" (90.4 mm) Inswing vent depth or 3-3/8" (85.7 mm) Outswing vent depth
 - 4. AW-PG70-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. **Subject to compliance with requirements, provide a comparable product by the following:**
 - 1. **Manufacturer:** (_____)
 - 2. **Series:** (_____)
 - 3. **Profile dimension:** (_____)
 - 4. **Performance Grade:** (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements.
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid window installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. **Substitution Acceptance:** Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. **Aluminum Extrusions:** Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. **Thermal Barrier:** The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. **Fasteners:** Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. **Anchors, Clips, and Accessories:** Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™6400/6500/6600 Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior TPE gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Single Handle Multi-Point Locks (Standard)
 - b. Cast White Bronze Cam Locks (Outswing Casement)
 - c. Access Control Locks (Outswing Casement)
 - 2. Hinging
 - a. 4-Bar Hinges (Inswing Casement)
 - b. Limit Stop
 - c. Concealed Hinges (Outswing Casement)
 - d. Friction Adjusters
 - 3. Other
 - a. Roto Operator (Outswing Casement)

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 - 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- G. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.

4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and/or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

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3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.

- a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™ 6400/6500/6600 Windows
 - b. Fixed Window
 - c. 4" (101.6 mm) AA™ 6400 frame depth, 5" (127 mm) AA™ 6500 frame depth or 6" (152 mm) AA™ 6600 frame depth
 - d. AW-PG70-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
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7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Framing System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-FW

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 75 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. U-Factor not more than .31 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than 77 (frame) and 72 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than 73 (frame) and 66 (glass) for AA™6400 and 70 (frame) and 67 (glass) for AA™6500.
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass made with exterior 3/16" clear glass, 3/8" aluminum spacer, and interior 7/16" laminated clear glass:
 - i. STC not less than 38; OITC not less than 32.
- b. 1-3/4" insulating glass made with exterior 1/2" clear laminated glass, 1" aluminum spacer, and interior 1/4" clear laminated glass:
 - i. STC not less than 48; OITC not less than 38.
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows - Fixed
 - 3. 4" (101.6 mm) AA™6400 frame depth, 5" (127 mm) AA™6500 frame depth or 6" (152 mm) AA™6600 frame depth
 - 4. AW-PG70-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window Framing System

- A. Series AA™6400/6500/6600 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior TPE gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (45,72 cm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Framing: Fabricate components for assembly using manufacture's standard installation instructions.
- C. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.
- D. Thermally Improved Construction: Fabricate aluminum window framing with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™ 6400/6500/6600 Windows
 - b. Project-In and Project-Out Windows
 - c. 3-9/16" (90.4 mm) Project-In vent depth or 3-3/8" (85.7 mm) Project-Out vent depth
 - d. AW-PG70-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-AP

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. Project-Out: U-Factor not more than .43 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
Project-In: U-Factor not more than .40 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
 - b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: CRF not less than 71 (frame) and 69 (glass).
 - b. Project-In: CRF not less than 74 (frame) and 68 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: (I) not less than 62 (frame) and 64 (glass).
 - b. Project-In: (I) not less than 70 (frame) and 68 (glass).
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: STC not less than 35; OITC not less than 28.
- b. Project-In: STC not less than 33; OITC not less than 27.

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED STC AND OITC VALUES

12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum windows through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows
 - 3. Project-In and Project-Out
 - 4. 3-9/16" (90.4 mm) Project-In vent depth or 3-3/8" (85.7 mm) Project-Out vent depth
 - 5. AW-PG70-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements.
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid window installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. **Substitution Acceptance:** Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. **Aluminum Extrusions:** Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. **Thermal Barrier:** The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. **Fasteners:** Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™6400/6500/6600 Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Single Handle Multi-Point Locks (Standard) Project-In
 - b. Dual Handle Multi-Point Locks (Standard) Project-Out
 - c. Cast White Bronze Cam Locks (Project-Out)
 - d. Access Control Locks (Project-Out)
 - 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - 3. Other
 - a. Roto Operator (Project-Out)
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 - 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- G. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. C-HC90 / C-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/11.S.2/A440 (NAFS).
 - a. Performance Class and Grade: C-HC90
 - b. Performance Class and Grade: C-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.

4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 720 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Inswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 61 (53.2 I-frame).
- b. Inswing Casement: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Inswing and Outswing Casement
 - 3. 2-5/8" (67 mm) frame depth
 - 4. C-HC90 / C-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.

- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:

1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
 - c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:

1. True muntins.
2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.

- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Fixed window
 - c. 2-5/8" (67 mm) frame depth
 - d. AW-PG90-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-FW
 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
 5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.

6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than .34 BTU/hr/ft²/°F.
9. Condensation Resistance (CRF): When tested to AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than 67 (66 I-Frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Fixed
 - 3. 2-5/8" (67 mm) frame depth
 - 4. AW-PG90-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacture and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. AP-HC90 / AP-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AP-HC90
 - b. Performance Class and Grade: AP-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 6.24 psf (300 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Project-In: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: CRF not less than 61 (53.2 I-frame).
- b. Project-In: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Project-Out only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Project-In and Project-Out
 - 3. 2-5/8" (67 mm) frame depth
 - 4. AP-HC90 / AP-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window System

- A. Series AA™ 900 Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
- c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
3. Other
 - a. Roto Operator (Project-Out)
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.

2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.

- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ Windows (Structural Silicone Glazed)
 - b. Project-Out and Outswing Casement Windows
 - c. 2-11/16" (68.3 mm) system depth (1/4" Infill), 3-7/16" (87.3 mm) system depth (1" Infill)
 - d. AW-PG90-AP/AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 078466 "Fire-Resistant Joint systems"
 - 3. 079200 "Joint Sealants"
 - 4. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 5. 084113 "Aluminum-Framed Entrances and Windows"
 - 6. 084313 "Aluminum-Framed Windows"
 - 7. 084329 "Sliding Windows"
 - 8. 084413 "Glazed Aluminum Curtain Walls"
 - 9. 084433 "Sloped Glazing Assemblies"
 - 10. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-AP/AW-PG90-C
- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914) Project-Out or 36" x 60" (914 x 1524) Casement Outswing. Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914) Project-Out or 36" x 60" (914 x 1524) Casement Outswing. There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of $L/175$ of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6464 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
7. Thermal testing per AAMA 1503 within 1600 Wall System™1, at the prescribed 59" x 24" (1500 x 600) test size glazed using a single lite of 1" insulating glass composed of 1/4" clear low-E .035 #2, 1/2" air space with warm edge spacer, 1/4" clear with the following results:
 - a. Condensation Resistance Factor: Minimum (51 frame) and (63 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.72 BTU/hr/ft²/°F U-value

or

Thermal Transmittance Test: (U-Factor): The conductive thermal transmittance (U-Factor) shall not be more than (____) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.

8. Sound: Testing per ASTM E 90 glazed with 1" insulating glass made with exterior 1/4" laminated glass x 1/2" air space x interior 1/4" laminated glass: Minimum (31 STC) and (26 OITC).
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Blast Mitigation performance: Tested per ASTM F 1642, GSA-TS01, and UFC 04-010-01 at a peak pressure of 6 psi and a 41 psi-msec impulse. The system shall achieve a minimum "Low Hazard" rating per ASTM F1642-04, a "Performance Condition 3b" per GSA and a "Low Level of Protection" per UFC 4-010-01 (Project-Out only).

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

- a. Section B-3.1.1 Dynamic analysis
- b. Section B-3.1.2 Testing
- c. Section B-3.1.3 ASTM F2248 Design Approach

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. GLASSvent™ Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 3. 2-11/16" (68.3 mm) system depth (1/4" Infill), 3-7/16" (87.3 mm) system depth (1" Infill)
 4. AW-PG90-AP/AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.
- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
 1. 4-Bar Hinges
 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

3. Stainless Steel 4-Bar Hinges
4. Cast white Bronze Cam Handle with Pole Ring
5. Cast White Bronze Access Control (Custodial) Locks with Removable Handle
6. Cast White Bronze Concealed Lock and Key

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION**3.1 Examination**

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: HC40 IS THE CLASS AND GRADE GLAZED WITH 1" GLASS AND TWO (2) CAM LOCKS. HC70 IS THE CLASS AND GRADE GLAZED WITH 1" GLASS AND THREE (3) CAM LOCKS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer GLASSvent™ Windows (Structural Silicone Glazed)
 - b. Project-Out and Outswing Casement Windows
 - c. 2-3/16" (55.5 mm) system depth (1/4" Infill), 2-13/16" (71.4 mm) system depth (1" Infill)
 - d. (P-HC40 – P-HC70) Project-Out Window, (C-HC40 – C-HC70) Outswing Casement Window

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 SOURCE QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 078466 "Fire-Resistant Joint systems"
 - 3. 079200 "Joint Sealants"
 - 4. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 5. 084113 "Aluminum-Framed Entrances and Windows"
 - 6. 084313 "Aluminum-Framed Windows"
 - 7. 084329 "Sliding Windows"
 - 8. 084413 "Glazed Aluminum Curtain Walls"
 - 9. 084433 "Sloped Glazing Assemblies"
 - 10. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: (P-HC40 – P-HC70) Project-Out Window
 - b. Performance Class and Grade: (C-HC40 – C-HC70) Outswing Casement Window
- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915) Project-Out or 36" x 60" (915 x 1524) Casement Outswing. Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915) Project-Out or 36" x 60" (915 x 1524) Casement Outswing. There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of (40 psf (1915 Pa)(2 Locks)) or (70 psf (3352 Pa)(3 Locks)) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural: A minimum static air pressure difference of (60 psf (2873 Pa)(2 Locks)) or (105 psf (5027)(3 Locks)) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS ARE BASED UPON 1" CLEAR INSULATING GLASS. (1/8" – 3/4" AS – 1/8")

7. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out Windows: 0.68 BTU/hr/ft²/°F. (NFRC – 0.62) or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. Outswing Casement Windows: 0.67 BTU/hr/ft²/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than; Frame 51, Glass 54.
or
a. Condensation Index (I): when tested to CSA-A440-00, the condensation index shall not be less than; Frame 47, Glass 48.
9. Thermal Transmittance Test: (U-Factor): The conductive thermal transmittance (U-Factor) shall not be more than (____) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than: 47.7.
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) above grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.

1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. GLASSvent™ Windows (Project-Out or Outswing Casement) (Specifier to Choose)
 3. 2-3/16" (55.5 mm) system depth (1/4" Infill), 2-13/16" (71.4 mm) system depth (1" Infill)
 4. (P-HC40 – P-HC70) Project-Out Window, (C-HC40 – C-HC70) Outswing Casement Window

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of low conductive polymer full depth of infill.
- C. Fasteners: Nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors: Nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. GLASSvent™ Windows - Project-Out or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable for four sided structural silicone glazed aluminum window units.

- B. Glazing System: Glazing method shall be four sided structural silicone glazed in accordance with manufacturer's standards.

2.5 Hardware

EDITOR NOTE: BELOW HARDWARE ITEMS ARE PRODUCT SPECIFIC. EACH PRODUCT TYPE HAS HARDWARE STANDARDS AND OPTIONS; OPTIONS ARE COST/BUDGET RELATED. CONSULT WITH KAWNEER REPRESENTATIVE FOR PARTICULAR HARDWARE REQUIREMENTS FOR SPECIFIC WINDOW TYPE SELECTED.

EDITOR NOTE: REVISE BELOW FOR SPECIFIC HARDWARE FOR EACH SPECIFIC WINDOW TYPE. SEE HARDWARE SELECTION GUIDE FOR HARDWARE OPTIONS OR CONTACT YOUR KAWNEER REPRESENTATIVE.

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out / Outswing Casement Windows: Provide the following operating hardware:
1. Stainless Steel 4-Bar Hinges
 2. Cast White Bronze Cam Locking Handles

EDITOR NOTE: INCLUDE OPTIONAL HARDWARE BASED ON PROJECT REQUIREMENTS.

- C. Project-Out Windows
1. Cast White Bronze Cam Handle with Pole Ring
 2. Cast White Bronze Access Control (Custodial) Locks with Removable Handle
 3. Cast White Bronze Concealed Lock and Key
 4. Cast White Bronze Pull Ring
 5. Pivot-shoe Roto Operator
- D. Outswing Casement Windows
1. Cast White Bronze Cam Handle with Pole Ring
 2. Cast White Bronze Access Control (Custodial) Locks with Removable Handle

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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END OF SECTION 085113

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-3400 Windows
 - b. Project-In Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, AIR FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTOR AND CFR.

8. Thermal testing per AAMA 1503, at the prescribed 60" x 96" (1523 x 1828) test size glazed with 1" insulating glass made with exterior 5/16" clear laminated glass, thermoplastic spacer air filled, and interior 5/16" laminated glass, with the following test results:
 - a. Condensation Resistance Factor: Minimum (61 frame) and (71 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.47 BTU/HR/SQ.FT/°F - U Factor.
9. Thermal computer simulation: Per NFRC 100, at the prescribed 59" x 24" (1498 x 609) Non-Residential Size, glazed with 1" insulating laminated glass made with exterior 1/4" Solarban 60, argon, and interior 1/4" clear glass: Thermal Transmittance to be maximum 0.41 BTU/HR/SQ.FT/°F U Factor.
10. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
11. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Traco
 - 2. Series NX-3400 Windows Project-In
 - 3. 3-1/4" (83 mm) frame depth
 - 4. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW SYSTEM

- A. Series NX-3400 Windows Project-In

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-In Window Typical Hardware:

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Cast White Bronze Cam Handles and Strikes
 - b. Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.

- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-350 Windows
 - b. Overlap Project-Out Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AP-HC40

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AP-HC40.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 32" (1524 x 813). Air infiltration rate shall not exceed 0.3 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 32" (1524 x 813). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

5. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2873 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, KRYPTON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

7. U-Factor: thermal computer simulation per NFRC 100, at the prescribed 59"x 24" (1499 x 610) Non-Residential Size, glazed with 1" insulating glass made with 1/8" glass with a soft coat low E on the #2 surface of the exterior lite, thermoplastic butyl spacer, krypton gas, and 1/8" clear interior glass lite: Thermal Transmittance to be maximum 0.43 BTU/HR/SQ.FT/°F.
8. Condensation Resistance: thermal computer simulation per NFRC 500, at the prescribed 59"x 24" (1499 x 610) Non-Residential Size, glazed with 1" insulating glass made with 1/8" glass with a soft coat low E on the #2 surface of the exterior lite, thermoplastic butyl spacer, krypton gas, and 1/8" clear interior glass lite: Condensation Resistance to be minimum 47.
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer company Inc.
 - 2. Series NX-350 Windows - Overlap Project-Out
 - 3. 3-1/4" (63 mm) frame depth
 - 4. AP-HC40

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-350 Windows - Overlap Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles with metal strikes
 - b. (Optional) White Bronze Custodial Locks with 1/4" Hex Key
 - c. Concealed Stainless Steel Hinges
 - d. (Optional) Exposed Aluminum Butt Hinges
 - e. (Optional) Stainless Steel Limit Arm with Release Key

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with snap clips; handle-access wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-3500 Windows
 - b. Project-Out Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG80-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTORS AND CFR.

8. U-Factor Simulation: thermal computer simulation per NFRC 100, at the prescribed 59" x 24" (1498 x 610) Non-Residential Size, glazed with 1" insulating glass made with exterior 1/4" Solarban 60, thermoplastic butyl spacer, argon gas, and interior 1/4" clear glass: Thermal Transmittance to be not less than 0.41 BTU/HR/SQ.FT/°F - U-Factor.
9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Sound: Testing per ASTM E90 with 1" insulating glass made with 1/8" – air – 1/4" glass: Minimum (34 STC).
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series NX-3500 Windows - Project-Out
 - 3. 3-1/4" (83 mm) frame depth
 - 4. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-3500 Windows - Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles and Strikes
 - b. Stainless Steel Limit Arm with Key Release
 - c. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with steel spring clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.

- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.

2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Fixed Window
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-FW.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .19 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
(CRF_f) frame not less than 78.
(CRF_g) glass not less than 82.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass:
Temperature Index (I_f) frame not less than 67.
Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.

- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Fixed
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 5/8" (15.9 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.

2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

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1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Inswing or Outswing Casement Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
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 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).

5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade (Outswing Casement only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Outswing Casement only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass: 33 (STC) and 26 (OITC).

- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...
Enter the following for an AAMA 2605 70% fluoropolymer paint finish
 - 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.4) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**

4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
6. Coating: **consult your Kawneer representative**

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 3. Patterns: grid patterns to be designated by architect.
 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 3. Interior: (two-piece snap trim;) (stool cover).
 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access **Enter wicket color choice: white, bronze, or black** wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.)

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800-07, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Project-Out only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 33 (STC) and 26 (OITC).
 - b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...
Enter the following for an AAMA 2605 70% fluoropolymer paint finish
 - 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.5) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
 1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].

- c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
- 6. Coating: *consult your Kawneer representative*

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 - 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 - 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 - 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 - 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 - 3. Patterns: grid patterns to be designated by architect.
 - 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 - 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 - 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 - 3. Interior: (two-piece snap trim;) (stool cover).
 - 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access *Enter wicket color choice: white, bronze, or black* wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
 - C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
 - D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
 - E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
 - F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
 - G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
 - H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOW

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-2400 Windows
 - b. Project-In Window
 - c. 2-1/4" (57 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (580 Pa).

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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, AIR FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTOR AND CFR.

8. Thermal testing per AAMA 1503, at 96 1/2" x 96" (2451 x 2438) test size glazed with 1" insulating glass made with exterior 5/16" clear laminated glass, thermoplastic spacer w/ plain air space, and interior 5/16" clear laminated glass, with the following test results:
 - a. Condensation Resistance Factor: Minimum (54 frame) and (61 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.48 BTU/HR/SQ.FT/°F U-value.
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series TR-2400 Windows - Project-In
 - 3. 2-1/4" (57 mm) frame depth
 - 4. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-2400 Windows - Project-In

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-In Window Typical Hardware:

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles and Strikes
 - b. (Optional) Pole Operated White Bronze Cam Handles and Strikes
 - c. (Optional) Custodial Lock with ¼" Hex Key
 - d. (Optional) Stainless Steel Limit Arm with Key Release
 - e. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 5/16" x 1-1/2" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series TR-2500 Windows
 - b. Project-Out Window
 - c. 2-1/4" (57 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).

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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series TR-2500 Windows - Project-Out
 - 3. 2-1/4" (57 mm) frame depth
 - 4. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-2500 Windows - Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

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Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1. Typical Hardware:
 - a. White Bronze Cam Handles and Strikes
 - b. (Optional) Pole Operated White Bronze Cam Handles and Strikes
 - c. (Optional) Custodial Lock with ¼" Hex Key
 - d. (Optional) Stainless Steel Limit Arm with Key Release
 - e. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with swivel clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-3400 Windows
 - b. Project-In Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3840 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5760 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTOR AND CRF.

8. Thermal testing per AAMA 1503, at the prescribed 48" x 72" (1219 x 1828) test size glazed with 1" insulating annealed glass with Solarban 60 Low E coat on surface #2, argon filled, with the following test results:
 - a. Condensation Resistance Factor: Minimum (61 frame) and (72 glass) CRF.
 - b. Thermal Transmittance: Maximum 0.42 BTU/HR/SQ.FT/°F - U Factor.
9. Forced Entry Resistance: All windows shall conform to ASTM F588, GRADE 10.
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series TR-3400 Windows - Project-In
 - 3. 3-1/4" (83 mm) frame depth
 - 4. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.080" (2.03mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-3400 Windows - Project-In

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-In Window Typical Hardware:

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EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles with Strikes
 - b. (Optional) Pole-Operated White Bronze Cam Handles with Strikes
 - c. (Optional) Custodial Lock with ¼" Hex Key
 - d. (Optional) Stainless Steel Limit Arm with Release Key
 - e. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 5/16" x 1-1/2" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
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- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
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1.2 Summary

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 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG65-AP

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 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

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- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG65-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 13 psf (622 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 65 psf (3112 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 97.5 psf (4668 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

8. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
9. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, b-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
10. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
11. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.

1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-3500 Windows - Project-Out
 3. 3-1/4" (83 mm) frame depth
 4. AP-AW65-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.080" (2.03 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-3500 Windows - Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

B. Project-Out Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles with Strikes
 - b. (Optional) Pole-Operated White Bronze Cam Handles with Strikes
 - c. (Optional) Custodial Lock with Removable Handle
 - d. (Optional) Stainless Steel Limit Arm with Release Key
 - e. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with swivel clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-740 Windows
 - b. Project-In Window
 - c. 4-5/8" (117.5 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (580 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-740 Windows - Project-In
 3. 4-5/8" (117.5 mm) frame depth
 4. AP-AW80-AP.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-740 Windows - Project-In

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-In Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles and Strikes
 - b. (Optional) Pole-operated White Bronze Cam Handles and Strikes
 - c. (Optional) Custodial Lock with Hex Key
 - d. (Optional) Stainless Steel Limit Arm with Key Release
 - e. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.

- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 5/16" x 1-1/2" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-750 Windows
 - b. Project-Out Window
 - c. 4-5/8" (117.5 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-AP.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 915). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 915). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer company Inc.
 2. Series TR-750 Windows - Project-Out
 3. 4-5/8" (117.5 mm) frame depth
 4. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-750 Windows - Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Project-Out Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. White Bronze Cam Handles and Strikes
 - b. (Optional) Pole-operated White Bronze Cam Handles and Strikes
 - c. (Optional) Custodial Lock with Removable Handle
 - d. (Optional) Stainless Steel Limit Arm with Key Release
 - e. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.

- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with swivel clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-3700 Windows
 - b. Dual Action Window
 - c. 3-1/4" (83 mm) frame depth
 - d. DAW-AW50

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: DAW-AW50.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 50 psf (2394 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 75 psf (3591 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series NX-3700 Windows - Dual Action
 3. 3-1/4" (83 mm) frame depth
 4. DAW-AW50

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-3700 Windows - Dual Action

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Dual Action Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Typical Hardware:
 - a. Option 1: Logical Operation; First motion tilt, second motion turn inward.
 - b. Option 2: Traditional Operation; First motion turn inward, second motion tilt.
 - c. Option 3: Turn-in motion only.
 - d. Handle Finish: White, Black, Silver or Satin Nickel.
 - e. (Optional) Custodial Handle locking out first motion.
 - f. (Optional) Custodial Handle locking out all motion.
 - g. Concealed Stainless Steel Hinges

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted exterior tracks; two stainless steel leaf springs; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass or aluminum mesh; PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Side load single hung (AW-PG50-H)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Windows"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99".
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than: 75 (frame) and 76 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than: 61 (frame), 75 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.23 to 0.38 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.23 to 0.38 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s·m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa) with a **10 lb. sill** or 15 lbf/sq. ft. (720 Pa) with a **15 lb. sill**.
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 32 (STC) and 24 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.27 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.

2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.41 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- L. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 1. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
(CRF_f) frame not less than 71.
(CRF_g) glass not less than 74.
- M. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 1. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
Temperature Index (I_f) frame not less than 57.
Temperature Index (I_g) glass not less than 77.
- N. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
- O. Air Exfiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Exfiltration Test.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **10 lb. Sill**.
 - b. Maximum Rate: 0.3 cfm/sq. ft. (1.5 L/s•m²) of area at an inward test pressure of 6.2 lbf/sq. ft. (300 Pa) in accordance with ASTM E283 with a **15 lb. Sill**.
- P. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **10 lb. Sill**.
 - b. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **15 lb. Sill**.
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **10 lb. Sill**.
 - b. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa) with a **15 lb. Sill**.
- Q. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-1/4" laminated insulating glass: 35 (STC) and 31 (OITC)

AA™ 5450 (Standard Face) and AA™ 5450 (Beveled Face)

- R. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- S. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- T. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 MANUFACTURERS**

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™5450 Ultra Thermal Singe Hung (Standard Face)
 - 3. Series AA™5450 Ultra Thermal Singe Hung (Beveled Face)
 - 4. 4 5/8" (117.48 mm) frame depth
 - 5. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.

2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Single Hung Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: AW-PG50-H

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Windows: Provide the following operating hardware:
 1. Sash Balances: A Class 5 adjustable spiral balance with stainless steel or other corrosion-resistant components. Two per sash.
 2. Handle: Continuous, integral, bottom sash lift handle.
 3. Sash Lock: White bronze sweep lock and keeper on meeting rails. One or two per sash as required by size. Brushed nickel finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.

- B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 2. Finish: Manufacturer's standard.

EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.

- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch (0.28-mm) diameter, coated aluminum wire.
1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
- D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™, AAMA 2604. Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.6 psf (75 Pa) for CW or 6.2 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Side load double hung (AW-PG50-H)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than 71 (frame) and 76 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than 40 (frame), 74 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.3 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa) with a **10 lb. sill** or 15 lbf/sq. ft. (720 Pa) with a **15 lb. sill**.
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 32 (STC) and 25 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a **15 lb. Sill**.

2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **10 lb. Sill**.
 - b. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a **15 lb. Sill**.

AA™ 5450 (Standard Face) and AA™ 5450 (Beveled Face)

- L. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- M. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- N. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify actual dimensions of aluminum framed window openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

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PART 2 - PRODUCTS**2.1 MANUFACTURERS**

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series AA™5450 Ultra Thermal Double Hung (Standard Face)
 3. Series AA™5450 Ultra Thermal Double Hung (Beveled Face)
 4. 4 5/8" (117.48 mm) frame depth
 5. AW-PG50-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer:
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Double Hung Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
1. Performance Class and Grade: AW-PG50-H

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads and an interior gasket in accordance with AAMA 702 or ASTM C864.

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2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Windows: Provide the following operating hardware:
 - 1. Sash Balances: A Class 5 adjustable spiral balance with stainless steel or other corrosion-resistant components. Two per sash.
 - 2. Handle: Continuous, integral, bottom and top sash lift handle.
 - 3. Sash Lock: White bronze sweep lock and keeper on meeting rails. One or two per sash as required by size. Brushed nickel finish.
 - 4. Aluminum autolock at top sash lift handle.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

- 5. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
- 6. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
- 7. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 - 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.
- B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
 - 1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 - 2. Finish: Manufacturer's standard.

EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.

- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch (0.28-mm) diameter, coated aluminum wire.
 - 1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
- D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
 - 1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 - 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permardize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604. Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within windows to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA™5450 Ultra Thermal (Beveled Face)
 - c. Fixed window (AW-PG70-FW)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 60" x 99"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA™5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than: 78 (frame) and 79 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than: 68 (frame) and 75 (glass).
- F. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.22 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 2. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.19 to 0.37 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32).
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.1 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa).
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 29 (STC) and 23 (OITC)

AA™5450 (Beveled Face)

- K. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 1. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.22 to 0.52 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48).
 2. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - a. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.20 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.34).

AA™5450 (Standard Face) and AA™5450 (Beveled Face)

- L. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™5450 Ultra Thermal Fixed (Standard Face)
 - 3. Series AA™5450 Ultra Thermal Fixed (Beveled Face)
 - 4. 4 5/8" (117.48 mm) frame depth
 - 5. AW-PG70-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Fixed Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 1. Performance Class and Grade: AW-PG70-FW

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: None required

2.6 INSECT SCREENS

- A. General: None required

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.

1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.

- a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™5450 Ultra Thermal
 - b. Horizontal Sliding (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.

- B. Related Sections:
 - 1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 - 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Windows"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - 1. Design pressure number in pounds force per square foot used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:
 - 1. Size required by AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 - 2. Test size: 99" x 79"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

- 1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.

- a. Basic Wind Speed (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Deflection Test or structural computations.
- C. Thermal Movements: Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (____) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series AA™5450 Ultra Thermal Horizontal Sliding Window
 3. 4 5/8" (117.48 mm) frame depth

4. (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Horizontal Sliding Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
1. Performance Class and Grade: (Single Slide: AW-PG40-HS; Double Slide: AW-PG50-HS)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- C. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than Single Slide: 76 (frame) and 77 (glass) or Double Slide: 69 (frame) and 77 (glass).
- D. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than Single Slide: 57 (frame) and 73 (glass) or Double Slide: 36 (frame) and 74 (glass).
- E. Thermal Transmittance: Provide aluminum windows tested for thermal performance according to AAMA 1503.
1. Provide aluminum windows tested for thermal performance according to AAMA 1503, with a thermal transmittance (U-factor) no more than Single Slide: 0.25 BTU/hr/sf/F or Double Slide: 0.28 BTU/hr/sf/F.
 2. Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-factor) range of; Single Slide: 0.23 to 0.38 BTU/hr/sf/F or Double Slide: 0.25 to 0.39 BTU/hr/sf/F (Based on center of glass U-factor range 0.10 to 0.32 for triple glazing).

- F. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- G. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 - 1. Maximum Rate: 0.3 cfm/sq. ft. (0.5 L/s·m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- H. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 - 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa).
- I. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- J. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.
- L. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - 1. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass:
XO UNIT = 32 (STC) and 26 (OITC)
XX UNIT = 33 (STC) and 26 (OITC)

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Windows: Provide the following operating hardware:
 - 1. Handle: Continuous, integral pulls.
 - 2. Sash Locks.
 - 3. Composite adjustable tandem roller.
 - 4. Stainless Steel roller track.
 - 5. Standard auto lock.
 - 6. Limit device.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

- 7. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
- 8. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.
 - 1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.
 - B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
 - 1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 - 2. Finish: Manufacturer's standard.
- EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.**
- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch- (0.28-mm-) diameter, coated aluminum wire.
 - 1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
 - D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
 - 1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 - 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12.7 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604. Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.

3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed storefront system and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 516/518 Thermal Windows
 - b. Fixed Window
 - c. 4" (101.6 mm) 516 frame depth, 5" (127 mm) 518 frame depth

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Fixed Window Performance Requirements:
 1. Fixed window air tightness shall meet the FIXED rating (less than 0.045 cfm/ft² (0.25 (m³/h) m⁻¹) at 1.57 psf (75 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 2. Fixed window water tightness shall meet the B7 rating (no water leakage at 14.6 psf (700 Pa)) when tested in accordance with CAN/CSA-A440 Windows.
 3. Structural performance shall be based on CSA Standard CAN3-S157 "Strength Design in Aluminum" and a maximum deflection of 1/175 of the span.
 4. Windload resistance for fixed windows shall meet the C5 rating when tested with configurations in accordance with CAN/CSA-A440 Windows.
 5. The fixed window thermal transmittance U-Factor shall be:
 - a. Series 516 Window; 0.39 BTU /hr-ft² · °F (2.2 W/m² · °C) when tested in accordance with AAMA 1503.1 and CAN/CSA-A440.2.
 - b. Series 518 Window; 0.37 BTU /hr-ft² · °F (2.1 W/m² · °C) when tested in accordance with AAMA 1503.1 and CAN/CSA-A440.2.

(Note to Specifier: Thermal performance depends on glass specified. Above tests were performed using 25mm double glazed insulated glass unit with 0.10 low emissivity coating on surface 3, argon gas filled interspace and a thermally broken aluminum glazing spacer.)
Test size 4ft x 6ft (1219mm x 1829mm).

6. The fixed window condensation temperature index of the frame (I_f) shall be:
 - a. Series 516 Window; 66 and temperature index of the glass (I_g) shall be 68 when tested in accordance with CAN/CSA-A440 Windows.
 - b. Series 518 Window; 67 and temperature index of the glass (I_g) shall be 67 when tested in accordance with CAN/CSA-A440 Windows.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 516/518 Thermal Windows - Fixed
 3. 4" (101.6 mm) 516 frame depth, 5" (127 mm) 518 frame depth

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.

4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window Framing System

- A. Series 516/518 Thermal Window - Fixed

EDITOR NOTE: IF RAIN SCREEN WINDOW IS REQUIRED, ADD THE FOLLOWING :

- B. All glazing pockets shall be vented, pressure equalized and drained to the exterior.
- C. Elastomeric air seal gasket shall be installed around the full perimeter of glass and sealed at corners with silicone sealant. Air seal gasket must provide adhesion with silicone sealant.

EDITOR NOTE: IF 526 THERMAL WINDOW OPERATING SASH IS REQUIRED, ADD SPECIFICATION FOR 526 THERMAL WINDOW VENTS.

EDITOR NOTE: IF 512 VENTROW THERMAL VENTILATOR INSERTS ARE REQUIRED, ADD SPECIFICATION FOR 512 VENTROW THERMAL VENTILATOR.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

2.6 Accessories

- A. General: None required

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Frame thermal barrier shall be Kawneer IsoPort™ with a minimum of 1/4" (6mm) separation consisting of a one piece polyamide strip installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weatherstripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 5500 Thermal Windows
 - b. Fixed window
 - c. 4" (102 mm) frame depth
 - d. Architectural Window Grade AW-PG80-F

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 90" (1524 x 2286). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 2. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 90" (1524 x 2286). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (500 Pa). The test specimen shall meet the B5 rating with no water leakage at 500 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 3. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3840 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2874 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
 5. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than .34 BTU/hr/ft²/°F.
7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than (72 frame) and (74 glass), or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than (62 frame) and (66 glass).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 5500 Thermal Windows - Fixed
 3. 4" (102) frame depth
 4. Architectural Window Grade AW-PG80-F

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)

2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 5500 Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

- G. Optional Perimeters and Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
- H. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 5525 Thermal Windows
 - b. Fixed window
 - c. 5" (127 mm) frame depth
 - d. Architectural Window Grade AW-PG75-F

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 90" (1524 x 2286). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 2. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 90" (1524 x 2286). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (500 Pa). The test specimen shall meet the B5 rating with no water leakage at 500 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 3. Uniform Load Deflection: A minimum static air pressure difference of 75 psf (3592 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2874 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
 5. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.

6. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than .35 BTU/hr/ft²/°F.
7. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than (73 frame) and (74 glass), or Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than (64 frame) and (66 glass).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 5525 Thermal Windows - Fixed
 3. 5" (127) frame depth
 4. Architectural Window Grade AW-PG75-F

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)

2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 5525 Thermal Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

- G. Optional Perimeters and Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
- H. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window framing shall be designed for screw spline corner construction. Operating sash extrusions shall be tubular with mitred, clip, adhesive, stake joint construction. All framing joints shall be sealed to provide neat weathertight connections.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Fixed Window
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 6' x 6' (1829 x 1829 mm) for F-HC100 and 5' x 8' (1524 x 2438 mm) for F-AW100. The air infiltration rate shall not exceed 0.06 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 6' x 6' (1829 x 1829 mm) for F-HC100 and 5' x 8' (1524 x 2438 mm) for F-AW100. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI/AAMA 101.
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Fixed
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 7225 (Non-Thermal) Fixed Window

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 1" (25,4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS, SEE THE PANNINGS AND TRIMS SECTION OF THE KAWNEER ARCHITECTURAL WINDOWS MANUAL.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.

3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: When closed and locked, test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 3' x 5' (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² of vent perimeter at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 3' x 5' (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: When closed and locked, a minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: When closed and locked, a minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, hardware parts, support arms, actuating mechanisms or any other damage which would cause the window to be inoperable, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Inswing and Outswing Casement
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW SYSTEM

- A. Series 7225 Non-Thermal Windows - Inswing and Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Roto-Operator
 - e. Multipoint Lock
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Butt Hinges
 - c. Friction Adjusters
 - d. Limit Stop
- 3. Other:
 - a. Pole Ring

b. Pole

C. Optional Egress Hardware Set:

1. Locking:
 - a. Multipoint Lock
2. Hinging:
 - a. Butt Hinges
3. Friction Adjusters

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

D. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:

1. True Muntins
2. Between The Glass Muntins
3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

E. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.

F. Optional Venetian Blinds: 1" aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

G. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:

1. Profiles that are sharp, straight, and free of defects or deformations.
2. Accurately fit joints; make joints flush, hairline and weatherproof.
3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
4. Physical and thermal isolation of glazing from framing members.
5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
6. Provisions for field replacement of glazing.
7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints

C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.

G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).

H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 7225 Non-Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-1/4" (57.2 mm) frame depth
 - d. AW-PG90-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: When closed and locked, test specimen shall be tested in accordance with ASTM E283 at a minimum vent size of 5' x 3' (1524 x 914 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² of vent perimeter at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum vent size of 5' x 3' (1524 x 914 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: When closed and locked, a minimum static air pressure difference of 90 psf (4309 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: When closed and locked, a minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
8. Life cycle testing for architectural grade windows when tested in accordance with AAMA 910, there shall be no damage to fasteners, hardware parts, support arms, actuating mechanisms or any other damage which would cause the window to be inoperable, and air infiltration and water resistance tests shall not exceed the primary performance specified herein.
9. Hurricane Resistance: Tested in accordance with the South Florida Building Code (SFBC) Protocols 201, 202 and 203.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

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- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series 7225 Non-Thermal Windows - Project-In and Project-Out
 3. 2-1/4" (57.2 mm) frame depth
 4. AW-PG90-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 7225 Non-Thermal Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Projected Windows Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Pivot Shoe Roto-Operator
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- D. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- E. Optional Venetian Blinds: 1" aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

1. Types of aluminum windows include:
 - a. Kawneer Series 8225TL Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG90-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/1.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG90-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 36" x 60" (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 36" x 60" (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of $L/175$ of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. Outswing Casement: U-Factor not more than .60 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
 - b. Inswing Casement: U-Factor not more than .62 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. Outswing Casement: (CRF_f) frame not less than 56 with clear glass.
Outswing Casement: (CRF_g) glass not less than 55 with clear glass.
 - b. Inswing Casement: (CRF_f) not less than 56 with clear glass.
Inswing Casement: (CRF_g) not less than 55 with clear glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Inswing and Outswing Casement
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG90-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be a Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Inswing and Outswing Casement

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Roto-Operator
 - e. Multipoint Lock
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Butt Hinges
 - c. Friction Adjusters
 - d. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole
- C. Optional Egress Hardware Set:
 - 1. Locking:
 - a. Multipoint Lock
 - 2. Hinging:
 - a. Butt Hinges
 - b. Friction Adjusters
- D. Other:
 - 1. "Escape/Rescue Window" Label

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- E. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 - 1. True Muntins
 - 2. Between The Glass Muntins
 - 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- F. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- G. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- H. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.

- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

1. Types of aluminum windows include:
 - a. Series 8225TL Thermal Windows
 - b. Fixed Window
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 60" x 99" (1524 x 2515 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 60" x 99" (1524 x 2515 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .58 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503 with clear glass, the condensation resistance factor (CRF) shall not be less than (CRF_f 59) frame and (CRF_g 57) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Sound Performance: When tested in accordance with ASTM E 90, the STC shall not be less than (34) and OITC not less than (28) based on 1" (25.4 mm) IG with 1/2" (12.7 mm) air space.
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8225TL Thermal Windows - Fixed
 - 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: SELECT 0.090" (2.3 mm) OR 0.125" (3.2 mm) WALL THICKNESS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8225TL Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 - d. AW-PG90-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
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 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG90-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 36" x 60" (914 x 1524 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 36" x 60" (914 x 1524 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. Project-Out: U-Factor not more than .60 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
 - b. Project-In: U-Factor not more than .62 BTU/hr/sf/°F or ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. Project-Out: (CRF_f) frame not less than 56 with clear glass.
Project-Out: (CRF_g) glass not less than 55 with clear glass.
 - b. Project-In: (CRF_f) not less than 56 with clear glass.
Project-In: (CRF_g) not less than 55 with clear glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out with 0.125" wall thickness).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Project-Out with 0.125" wall thickness).
10. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
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- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

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 2. Series 8225TL Thermal Windows - Project-In and Project-Out
 3. 2-1/4" (57.2 mm) frame depth, with 0.090" (2.3 mm) or 0.125" (3.2 mm) wall thickness
 4. AW-PG90-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.090" (2.3 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (9.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8225TL Thermal Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Windows Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- 1. Locking:
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Access Control Locks
 - c. Hook Lock Handle
 - d. Pivot Shoe Roto-Operator
- 2. Hinging:
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
- 3. Other:
 - a. Pole Ring
 - b. Pole

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 - 1. True Muntins
 - 2. Between The Glass Muntins
 - 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- D. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- E. Optional Venetian Blinds: 1" (25.4 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 - 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 - 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.

7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:

1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8430TL Single Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG70-H

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG70-H

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .51 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 55) (Glass = 62).

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.
13. Sound: Testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (34 STC) and (29 OITC).

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8400TL Thermal Windows
 3. Model 8430TL Single Hung Window
 4. 4" (101.6 mm) frame depth
 5. AW-PG70-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 1/4" (6.35 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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2.3 Window System

- A. Series 8400TL Thermal Windows - Single Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Single Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Limit Device: Sash stop limit device; for bottom sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.

3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8450TL Double Hung Window
 - c. 4" (101.6 mm) frame depth
 - d. H-HC70 / H-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: H-HC70
 - b. Performance Class and Grade: H-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 66" x 120" (1676 x 3048 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 66" x 120" (1676 x 3048 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Condensation Resistance Test (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
 - a. CRF (Frame = 51) (Glass = 63) .
8. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than:
 - a. U-Factor not more than .52 BTU/hr/sf/°F or (___) BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Sound: testing per ASTM 1801 with 1" (25.4 mm) insulating glass made with (1/4" [6.35 mm] annealed exterior with 1/2" [12.7 mm] air space, 1/4" [6.35 mm] annealed interior): minimum (33 STC) and (29 OITC).
11. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series 8400TL Thermal Windows
 3. Model 8450TL Double Hung Window
 4. 4" (101.6 mm) frame depth
 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Double Hung Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Sash Balances: A Class 5 adjustable spring balance with stainless steel or other corrosion-resistant components. Two per sash.
2. Handle: Continuous, integral, bottom and top sash lift handle.
3. Sash Lock: Zinc die cast cam-action sweep lock and keeper on meeting rails. One or two per sash as required by size. Powder coating finish.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

4. Optional Lower Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
5. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
6. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-Spline, Factory sealed frame and vent corner Joints
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8410TL Fixed Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 60" x 99" (1524 x 2515 mm). The air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 60" x 99" (1524 x 2515 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
- 4. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4788 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.

5. Uniform Load Structural Test: A minimum static air pressure difference of 150 psf (7182 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .48 BTU/hr/sf/°F or (____) BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503 with 1" (25,4 mm) insulating clear glass, the condensation resistance factor shall not be less than (CRF_f 67) frame and (CRF_g 66) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, HP GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

9. Sound Performance: When tested in accordance with ASTM E 90 and E 413, the sound transmission loss (STL) shall not be less than 39.
10. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8410TL Fixed Window
 - 4. 4" (101.6 mm) frame depth
 - 5. AW-PG100FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Windows - Fixed Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- C. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and mechanically clipped and/or staked, factory sealed frame and vent corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series 8400TL Thermal Windows
 - b. Model 8470TL Horizontal Sliding Window
 - c. 4" (101.6 mm) frame depth
 - d. HS-HC70 / HS-AW70

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: HS-HC70
 - b. Performance Class and Grade: HS-AW70

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283 at a minimum window size of 96" x 80" (2438 x 2032 mm). The air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 PA).

3. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331 at a minimum window size of 96" x 80" (2438 x 2032 mm). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).
4. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member.
5. Uniform Load Structural Test: A minimum static air pressure difference of 105 psf (5027 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Temperature Index Test: (CRF) when tested in accordance with CAN/CSA A440, the Temperature Index shall not be less than (CRF_f 38.2) frame and (CRF_g 61.2) glass
8. Thermal Transmittance Test: (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than .55 BTU/hr/sf/°F or () BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test: (CRF) when tested in accordance with AAMA 1503, the condensation resistance factor shall not be less than (CRF_f 50) frame and (CRF_g 61) glass.

EDITOR NOTE: UNLESS OTHERWISE SPECIFIED, WINDOWS TESTED AND CERTIFIED FOR CONDENSATION RESISTANCE AND THERMAL TRANSMITTANCE SHALL BE GLAZED WITH NO MORE THAN TWO LITES OF CLEAR, UNCOATED, ANNEALED GLASS. SEALED INSULATING GLASS SHALL BE OF STANDARD CONSTRUCTION. HIGHER PERFORMANCE GLASS MAY YIELD IMPROVED CRF AND "U" FACTORS.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound: Testing per ASTM 1801 with 1" insulating glass made with (1/4" annealed exterior with, 1/2" airspace, 1/4" annealed interior): minimum (34 STC) and (29 OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems..

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

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- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 8400TL Thermal Windows
 - 3. Model 8470TL Horizontal Sliding Window
 - 4. 4" (101.6 mm) frame depth
 - 5. HS-HC70 / HS-AW70

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.78) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier:
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (6.5 mm) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series 8400TL Thermal Window - Horizontal Sliding Window.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Horizontal Sliding Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

1. Continuous Integral Pulls
2. Stainless Steel Ball Bearing Rollers
3. Stainless Steel Roller Track
4. Plunger Lock

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- C. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- D. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Screw-spline, factory sealed frame and vent corner joints.

- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/1.S.2/A440-08 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar material to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.

- b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™6400/6500/6600 Windows
 - b. Inswing and Outswing Casement Windows
 - c. 3-9/16" (90.4 mm) Inswing vent depth or 3-3/8" (85.7 mm) Outswing vent depth
 - d. AW-PG70-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-C

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of $L/175$ of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. Outswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
Inswing Casement: U-Factor not more than .40 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
 - b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 71 (frame) and 69 (glass).
 - b. Inswing Casement: CRF not less than 74 (frame) and 68 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: (I) not less than 62 (frame) and 64 (glass).
 - b. Inswing Casement: (I) not less than 70 (frame) and 68 (glass).
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: STC not less than 35; OITC not less than 28.
- b. Inswing Casement: STC not less than 33; OITC not less than 27.

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED STC AND OITC VALUES

12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum windows through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows - Inswing and Outswing Casement
 - 3. 3-9/16" (90.4 mm) Inswing vent depth or 3-3/8" (85.7 mm) Outswing vent depth
 - 4. AW-PG70-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. **Subject to compliance with requirements, provide a comparable product by the following:**
 - 1. **Manufacturer:** (_____)
 - 2. **Series:** (_____)
 - 3. **Profile dimension:** (_____)
 - 4. **Performance Grade:** (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements.
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid window installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. **Substitution Acceptance:** Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. **Aluminum Extrusions:** Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. **Thermal Barrier:** The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. **Fasteners:** Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. **Anchors, Clips, and Accessories:** Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™6400/6500/6600 Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior TPE gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Single Handle Multi-Point Locks (Standard)
 - b. Cast White Bronze Cam Locks (Outswing Casement)
 - c. Access Control Locks (Outswing Casement)
 - 2. Hinging
 - a. 4-Bar Hinges (Inswing Casement)
 - b. Limit Stop
 - c. Concealed Hinges (Outswing Casement)
 - d. Friction Adjusters
 - 3. Other
 - a. Roto Operator (Outswing Casement)

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 - 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- G. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.

4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and/or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.

- a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™ 6400/6500/6600 Windows
 - b. Fixed Window
 - c. 4" (101.6 mm) AA™ 6400 frame depth, 5" (127 mm) AA™ 6500 frame depth or 6" (152 mm) AA™ 6600 frame depth
 - d. AW-PG70-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084313 "Aluminum-Framed Storefronts"
6. 084329 "Sliding Storefronts"
7. 084413 "Glazed Aluminum Curtain Walls"
8. 084433 "Sloped Glazing Assemblies"
9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Framing System Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-FW

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 75 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. U-Factor not more than .31 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than 77 (frame) and 72 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than 73 (frame) and 66 (glass) for AA™6400 and 70 (frame) and 67 (glass) for AA™6500.
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass made with exterior 3/16" clear glass, 3/8" aluminum spacer, and interior 7/16" laminated clear glass:
 - i. STC not less than 38; OITC not less than 32.
- b. 1-3/4" insulating glass made with exterior 1/2" clear laminated glass, 1" aluminum spacer, and interior 1/4" clear laminated glass:
 - i. STC not less than 48; OITC not less than 38.
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows - Fixed
 - 3. 4" (101.6 mm) AA™6400 frame depth, 5" (127 mm) AA™6500 frame depth or 6" (152 mm) AA™6600 frame depth
 - 4. AW-PG70-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window Framing System

- A. Series AA™6400/6500/6600 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior TPE gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (45.72 cm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Framing: Fabricate components for assembly using manufacture's standard installation instructions.
- C. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.
- D. Thermally Improved Construction: Fabricate aluminum window framing with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™ 6400/6500/6600 Windows
 - b. Project-In and Project-Out Windows
 - c. 3-9/16" (90.4 mm) Project-In vent depth or 3-3/8" (85.7 mm) Project-Out vent depth
 - d. AW-PG70-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG70-AP

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.57 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.

5. Uniform Load Deflection: A minimum static air pressure difference of 70 psf (3352 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 105 psf (5028 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load with permanent set not to exceed 0.2% of span length.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 and AAMA 910.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. 1" insulating glass:
 - i. Project-Out: U-Factor not more than .43 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
Project-In: U-Factor not more than .40 BTU/hr/ft²/°F per AAMA 1503 with exterior 1/4" low-e glass, 1/2" Technoform TGI spacer, and interior 1/4" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
 - b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
9. Condensation Resistance Test (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: CRF not less than 71 (frame) and 69 (glass).
 - b. Project-In: CRF not less than 74 (frame) and 68 (glass).
10. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index (I) not less than:

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: (I) not less than 62 (frame) and 64 (glass).
 - b. Project-In: (I) not less than 70 (frame) and 68 (glass).
11. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: STC not less than 35; OITC not less than 28.
- b. Project-In: STC not less than 33; OITC not less than 27.

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED STC AND OITC VALUES

12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.

- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum windows through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. **Field Measurements:** Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. Kawneer Series AA™6400/6500/6600 Windows
 - 3. Project-In and Project-Out
 - 4. 3-9/16" (90.4 mm) Project-In vent depth or 3-3/8" (85.7 mm) Project-Out vent depth
 - 5. AW-PG70-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements.
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid window installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. **Substitution Acceptance:** Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. **Aluminum Extrusions:** Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. **Thermal Barrier:** The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. **Fasteners:** Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™6400/6500/6600 Windows - Project-In and Project-Out

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be TPE gasket. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:

- 1. Locking
 - a. Single Handle Multi-Point Locks (Standard) Project-In
 - b. Dual Handle Multi-Point Locks (Standard) Project-Out
 - c. Cast White Bronze Cam Locks (Project-Out)
 - d. Access Control Locks (Project-Out)
- 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
- 3. Other
 - a. Roto Operator (Project-Out)
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD TRIMS, SEE KAWNEER.COM.

- E. Optional interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 - 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- F. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- G. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 6. Provisions for field replacement of glazing.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Vent and/or Vent Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed vent and /or vent frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Inswing and Outswing Casement Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. C-HC90 / C-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/11.S.2/A440 (NAFS).
 - a. Performance Class and Grade: C-HC90
 - b. Performance Class and Grade: C-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 36" x 60" (914 x 1524). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 300Pa when tested in accordance with CAN/CSA-A440-00 Windows.

4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 36" x 60" (914 x 1524). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 720 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Inswing Casement: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Outswing Casement: CRF not less than 61 (53.2 I-frame).
- b. Inswing Casement: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Outswing Casement only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Outswing Casement only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Inswing and Outswing Casement
 - 3. 2-5/8" (67 mm) frame depth
 - 4. C-HC90 / C-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Inswing and Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.

- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.

- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:

1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
 - c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:

1. True muntins.
2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 - 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.

- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Fixed window
 - c. 2-5/8" (67 mm) frame depth
 - d. AW-PG90-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window System Performance Requirements:
 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG90-FW
 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the Fixed rating of less than 0.25 (m³/h)/m at 300 Pa when tested in accordance with CAN/CSA-A440-00 Windows.
 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
 5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.

6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than .34 BTU/hr/ft²/°F.
9. Condensation Resistance (CRF): When tested to AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than 67 (66 I-Frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade.
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Fixed
 - 3. 2-5/8" (67 mm) frame depth
 - 4. AW-PG90-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™900 Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
 1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) OR ARCHITECTURAL WINDOWS (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 1. Types of aluminum windows include:
 - a. Kawneer Series AA™900 Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 2-5/8" (67 mm) frame depth
 - d. AP-HC90 / AP-AW90

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.

- B. Window Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AP-HC90
 - b. Performance Class and Grade: AP-AW90

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 6.24 psf (300 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa). The test specimen shall meet the B7 rating with no water leakage at 15 psf (720 Pa) when tested in accordance with CAN/CSA-A440-00 Windows.
5. Uniform Load Deflection: A minimum static air pressure difference of 90 psf (4310 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member. The test specimen shall meet the C5 rating when tested in accordance with CAN/CSA-A440-00 Windows.
6. Uniform Load Structural: A minimum static air pressure difference of 135 psf (6465 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440-05.
8. Thermal Transmittance (U-Factor): When tested to AAMA Specification 1503, the thermal transmittance (U-Factor) shall not be more than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: U-Factor not more than .47 BTU/hr/ft²/°F.
 - b. Project-In: U-Factor not more than .43 BTU/hr/ft²/°F.
9. Condensation Resistance Test (CRF): When tested in accordance with AAMA Specification 1503 and CAN/CSA-A440, the condensation resistance factor (CFR) shall not be less than;

EDITOR NOTE: SELECT FROM BELOW

- a. Project-Out: CRF not less than 61 (53.2 I-frame).
- b. Project-In: CRF not less than 64 (50.2 I-frame).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED "U" VALUES AND CFR.

10. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996 and TAS 201/203.
 - a. Large – Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small – Missile Impact: For aluminum-framed systems located above 30 feet (9.1m) of grade (Project-Out only).
11. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
12. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) OR (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™900 Thermal Windows - Project-In and Project-Out
 - 3. 2-5/8" (67 mm) frame depth
 - 4. AP-HC90 / AP-AW90

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Window System

- A. Series AA™ 900 Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
1. Locking
 - a. Single Handle Multi-Point Locks (Standard)

EDITOR NOTE: SELECT WHITE, BLACK OR SILVER POWDER COAT PAINTED FINISH

- b. Cast White Bronze Cam Locks
 - c. Access Control Locks
2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
3. Other
 - a. Roto Operator (Project-Out)
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".

EDITOR NOTE: TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- G. Optional Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated.
1. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- H. Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- I. Optional Insect Screens: Extruded aluminum frames, 6063-T6 alloy and temper, joined at corners: 18 x 16 mesh aluminum screen cloth; frames finished to match aluminum windows; splines shall be extruded vinyl, removable to permit rescreening.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.

2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall be Kawneer IsoWeb™ consisting of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.

- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-380 Windows
 - b. Fixed Window
 - c. 3-1/4" (83 mm) frame depth
 - d. F-HC40

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 - a. Performance Class and Grade: F-HC40.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 72" x 72" (1829 x 1829). Air infiltration rate shall not exceed 0.30 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 72" x 72" (1829 x 1829). There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (479 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Uniform Load Structural: A minimum static air pressure difference of 60 psf (2873 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
6. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, GAS FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YEILD IMPROVED U-FACTOR AND CFR.

7. U-Factor Test: thermal testing per NFRC 102 at the prescribed 47" x 59" (1194 x 1499) test size glazed with 1" insulating glass made with 1/8" clear exterior glass lite, thermoplastic butyl spacer, krypton gas, and 1/8" glass with a soft coat low E coating on the #3 surface of the interior glass lite: Standardized Thermal Transmittance to be maximum 0.32 BTU/HR/SQ.FT/°F.
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series NX-380 Windows - Fixed
 3. 3-1/4" (83 mm) frame depth
 4. F-HC40

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-380 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 - 1. True muntins.
 - 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.6 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances.

Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.

1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-3800 Windows
 - b. Fixed Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG100-FW.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4800 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 150 psf (7200 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTOR AND CFR.

8. U-Factor Test: thermal test per NFRC 102, at the prescribed 48" x 60" (1219 x 1524) Non-Residential Size, glazed with 1" insulating glass (1/4" Solarban 60, thermoplastic butyl spacer, argon gas, 1/4" clear: Thermal Transmittance to be no more than 0.33 BTU/HR/SQ.FT/°F - U value.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
10. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
11. Sound: testing per ASTM E90 with 1" insulating glass (1/8", air, 1/4"): 32 STC.
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series NX-3800 Windows - Fixed
 - 3. 3-1/4" (83 mm) frame depth
 - 4. AW-PG80-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-3800 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.6 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.7 Aluminum Finishes

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series NX-7400 Windows
 - b. Fixed Window
 - c. 3-1/4" (83 mm) frame depth
 - d. CW-PG65-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: CW-PG65 - 60" x 60" (1524 mm x 1524 mm) -FW.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Leakage: The test specimen shall be tested in accordance with ASTM E283. Air leakage rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 6.2 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 65 psf (3120 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Structural Load: No glass breakage or permanent damage to fasteners, and maximum .3% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 97.5 psf (4668 PA).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series NX-7400 Windows - Fixed
 3. 3-1/4" (83 mm) frame depth
 4. CW-PG65-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of two parallel glass fiber-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series NX-7400 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.6 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural thermal break made with glass-reinforced nylon strips installed continuously and mechanically bonded to the aluminum.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.

2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Leakage Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.6 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- D. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

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SECTION 085113 ALUMINUM WINDOWS

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Fixed Window
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-FW.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .19 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC 100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
(CRF_f) frame not less than 78.
(CRF_g) glass not less than 82.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:
 - a. 1-3/4" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass:
Temperature Index (I_f) frame not less than 67.
Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.

- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

EDITOR NOTE: INSULATING GLASS WARRANTIES ARE 5 YEARS FOR SINGLE SEAL UNITS AND 10 YEARS FOR DOUBLE SEAL UNITS. SPECIFIER TO CHOOSE.

- B. Insulating Glass: Warranted to be free from defects (excluding breakage) for a period of five (5) years.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Fixed
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Fixed.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: None required.

EDITOR NOTE: FOR OPTIONAL MUNTIN GRIDS BELOW, A COMBINATION OF EXTERIOR APPLIED AND BETWEEN THE GLASS MUNTINS ARE AVAILABLE. THE FINISH OF THE BETWEEN THE GLASS MUNTINS SHALL MATCH THE WINDOWS OR AS OTHERWISE SPECIFIED.

- B. Optional Muntin Grids: Extruded aluminum profiles. 6063-T6 alloy and temper as follows:
 1. True Muntins
 2. Between The Glass Muntins
 3. Applied Muntins

EDITOR NOTE: RETAIN BELOW TO SUIT PROJECT REQUIREMENTS; DELETE WORD "OPTIONAL" IF RETAINED.

- C. Optional Dual glazing (Interior Access Panels): Extruded aluminum profiles, 6063-T6 alloy and temper, mitered and fastened joints. Optional Dual Glazing (Interior Access Panels) shall be lift-off or hinged type.
- D. Optional Venetian Blinds: 5/8" (15.9 mm) aluminum venetian blinds with braided ladder cords. Finish shall be (_____) baked on polyester powder coat conforming to AAMA 2604. Provide tilt control knob with slip mechanism to prevent over tilting.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- E. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 4" (101.6 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

2.6 Accessories

- A. General: None required.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- F. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- G. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- H. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.

2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Inswing or Outswing Casement Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-C

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-C

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).

5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).
6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade (Outswing Casement only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Outswing Casement only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, therm-oplastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - 33 (STC) and 26 (OITC).

- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...
Enter the following for an AAMA 2605 70% fluoropolymer paint finish
 - 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-C

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Inswing or Outswing Casement.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.4) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**

4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
6. Coating: **consult your Kawneer representative**

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Casement Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 3. Patterns: grid patterns to be designated by architect.
 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 3. Interior: (two-piece snap trim;) (stool cover).
 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access **Enter wicket color choice: white, bronze, or black** wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.)

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800-07, and crimped.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series AA™4325 Ultra Thermal Windows
 - b. Project-In and Project-Out Windows
 - c. 3-1/4" (82.5 mm) frame depth
 - d. AW-PG80-AP

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:
 - 1. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
 - a. Performance Class and Grade: AW-PG80-AP

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Air Infiltration: after the AAMA 910 life cycle test, meet AAMA 101 standard of maximum 0.10 cfm/ft² when tested per ASTM E 283 at a static air pressure differential of 6.24 psf (300 PA).
- 3. Water Penetration: after the AAMA 910 life cycle test, no uncontrolled water leakage when tested per ASTM E 547 and ASTM E 331 at a static air pressure differential of 15 psf (720 PA).
- 4. Uniform Deflection: no more than L/175 when tested per ASTM E 330 at a static air pressure differential of 80 psf (3840 PA).
- 5. Uniform Structural: window to be operable, and maximum .2% permanent deformation per member when tested per ASTM E 330 at a static air pressure differential of 120 psf (5748 PA).

6. Component Testing: Window components shall be tested in accordance with procedures described in ANSI AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
7. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass:
 - i. U-Factor not more than .44 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
- b. 1-3/4" triple insulating glass:
 - i. U-Factor not more than .27 BTU/hr/sf/°F per AAMA 1503 with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass.
 - or
 - ii. U-Factor not more than ____ BTU/hr/sf/°F per AAMA 507 or NFRC100 when using project specified glass.
8. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 70.
 - (CRF_g) glass not less than 66.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - (CRF_f) frame not less than 76.
 - (CRF_g) glass not less than 79.
9. Condensation Resistance (I): When tested to CSA A-440, the condensation index shall not be less than:

EDITOR NOTE: SELECT FROM BELOW.

- a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 63.
 - Temperature Index (I_g) glass not less than 67.
- b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass:
 - Temperature Index (I_f) frame not less than 68.
 - Temperature Index (I_g) glass not less than 79.
10. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade (Project-Out only).
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade (Project-Out only).
11. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.

To meet UFC 04-010.01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:

 - a. Section B-3.1.1 Dynamic analysis
 - b. Section B-3.1.2 Testing
 - c. Section B-3.1.3 ASTM F2248 Design Approach
12. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
13. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 - a. 1" insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 33 (STC) and 26 (OITC).
 - b. 1-3/4" triple insulating glass made with exterior 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, center 3/16" soft coat low E glass, thermo-plastic butyl spacer, argon gas, and interior 3/16" clear glass: 32 (STC) and 25 (OITC).
14. Thermal Barrier Tests: Testing shall be in general accordance with AAMA 505 Dry Shrinkage and Composite Thermal Cycling test procedure, AAMA TIR-A8, Structural Performance of Composite Thermal Barrier systems.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Windows: warrant for two years against defects in material or workmanship under normal use.
- C. Insulating glass units: warrant seal for five years **Contact Kawneer for other time frames** against visual obstruction from film formation or moisture collection between internal glass surfaces, excluding that caused by glass breakage or abuse.
- D. Paint finish: PPG...
Enter the following for an AAMA 2605 70% fluoropolymer paint finish
 - 1. Permafluor™ organic finish conforming to AAMA 2605: warrant for ten years against chipping, peeling, cracking, chalking, or fading.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out Windows
 - 2. 3-1/4" (82.5 mm) frame depth
 - 3. AW-PG80-AP

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish.
- B. Thermal Barrier: Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series AA™4325 Ultra Thermal Windows - Project-In and Project-Out.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Glazing: Exterior extruded silicone gasket with 2-part structural silicone; 1" (25.4) insulating glass or 1-3/4" (44.5) triple insulating glass; Interior aluminum glazing bead; open cell foam encased in black thermoplastic elastomeric (TPE) gasket; glass description in paragraph 2.4; glazed by the window manufacturer.
- D. Insulating Glass Units
 1. Materials
 - a. Spacer: extruded thermoplastic butyl with integrated desiccant.
 - b. Spacer color: black.
 - c. Secondary seal: silicone.
 - d. Air space fill: plain air [argon].
 2. Performance
 - a. Dual-seal durability: conformance to ASTM E 2190; visible, permanent IGCC certification label.
 - b. Other: **Enter U value, etc., information as required**
 3. Exterior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [bronze] [gray].
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 4. Center glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"]
 - b. Tint: clear [pattern #62 obscure]
 - c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
 - d. Coating: **consult your Kawneer representative**
 5. Interior glass lite
 - a. Thickness: 1/8" [3/16"] [1/4"].
 - b. Tint: clear [pattern #62 obscure].

- c. Type: annealed [tempered] [laminated *Enter interlayer and lite descriptions*].
- 6. Coating: *consult your Kawneer representative*

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Projected Window Typical Hardware:

EDITOR NOTE: SELECT FROM BELOW.

- C. Typical Hardware:
 - 1. Locking
 - a. Cast White Bronze Cam Locks (Standard)
 - b. Single Handle Multi-Point Locks
 - c. Access Control Locks
 - 2. Hinging
 - a. 4-Bar Hinges (Standard)
 - b. Limit Stop
 - c. Butt Hinges
 - d. Friction Adjusters
 - 3. Other
 - a. Roto Operator
 - b. Pole Ring
 - c. Pole

2.6 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Muntins:
 - 1. Material: extruded aluminum or roll-formed aluminum; with exposed surfaces finished to match window exterior and interior colors; concealed fasteners; designed for unrestricted expansion and contraction.
 - 2. Design: muntin bar cross-section profile and material chosen from manufacturer's standards.
 - 3. Patterns: grid patterns to be designated by architect.
 - 4. Locations:
 - a. Exterior and Interior.
 - b. Internal: (Encapsulated between the two glass lites in the insulating glass unit to protect them from damage and dirt buildup).
- F. Glazing: Factory glazing as required and specified in Division 8 Section "Glazing".
- G. Accessories
 - 1. Material: extruded aluminum; nominal .062" (1.57 mm) wall; with exposed surfaces finished to match window color and finish performance; concealed fasteners; required weatherseals; designed for unrestricted expansion and contraction.
 - 2. Exterior: (wrap around panning;) (preset panning;) (two-piece mullion cover;) (two-piece head and jamb receptor with thermal break;) (subsill with thermal break and end dams sealed by the window manufacturer;) (sill cover;) (slip-on expanders).
 - 3. Interior: (two-piece snap trim;) (stool cover).
 - 4. Mullions: with thermal break; (integral: mounted between frame members;) (stack;) (offset stack;) (three-piece).
- H. Insect Screens: full; field-mounted on interior with steel spring clips; handle-access *Enter wicket color choice: white, bronze, or black* wickets; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [aluminum] mesh; PVC spline.

2.7 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 - 4. Physical and thermal isolation of glazing from framing members.
 - 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Frame and Vent: All members double tubular; corners mitered, double gusset reinforced, factory-sealed with sealant conforming to AAMA 800, and crimped.
 - C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
 - D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
 - E. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Structural thermal break made with glass-reinforced nylon strips, (closed cell PVC foam strips) installed by the window manufacturer in the frame and vent members.
 - F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
 - G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
 - H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum-framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum-framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 - 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-2800 Windows
 - b. Fixed Window
 - c. 2-1/4" (57 mm) frame depth
 - d. AW-PG80-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-FW.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTOR AND CFR.

8. U-Factor Simulation: thermal computer simulation per NFRC 100, at the prescribed 24"x 24" (609 x 609) Non-Residential Size, glazed with 1" insulating clear glass (1/8", air, 1/8"): Thermal Transmittance to be no more than 0.59 BTU/HR/SQ.FT/°F.
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series TR-2800 Windows - Fixed
 3. 2-1/4" (57 mm) frame depth
 4. AW-PG80-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-2800 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".

- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS, REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.6 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-7100 Windows
 - b. Fixed Window
 - c. 3-1/4" (83 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, ARGON FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTORS AND CFR.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG100-FW.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" X 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" X 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (730 Pa).
5. Uniform Load Deflection: A minimum static air pressure difference of 100 psf (4800 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 150 psf (7200 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Sound: Testing per ASTM E90 with 1" insulating glass made with exterior 1/4" laminated glass – 1/8" glass/.060 PVB/1/8" glass – and interior 3/16" annealed glass: Minimum (38 STC) and (31 OITC).
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. Series TR-7100 Windows - Fixed
 3. 3-1/4" (83 mm) frame depth
 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.060" (1.52 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-7100 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".

D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:

1. True muntins.
2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.

G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.6 Fabrication

A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:

1. Profiles that are sharp, straight, and free of defects or deformations.
2. Accurately fit joints; make joints flush, hairline and weatherproof.
3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
4. Physical and thermal isolation of glazing from framing members.
5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
6. Provisions for field replacement of glazing.
7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.

C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.

D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.

E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.

1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.

F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.

G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.

H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.7 Aluminum Finishes

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- D. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-780 Windows
 - b. Fixed Window
 - c. 4-5/8" (117.5 mm) frame depth
 - d. AW-PG80-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG80-FW.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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5. Uniform Load Deflection: A minimum static air pressure difference of 80 psf (3830 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 120 psf (5746 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Sound: Testing per ASTM E90 on 48" x 96" (1219 x 2438) test size glazed with 1" insulating glass made with exterior ¼" glass x ½" air space x interior ¼" laminated, 3-1/8" unsealed air space, and interior ¼" laminated glass: Minimum (48 STC) and (37 OITC).
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-780 Windows - Fixed
 3. 4-5/8" (117.5 mm) frame depth
 4. AW-PG80-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.125" (3.18 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-780 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type .062" (1.57 mm) glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.
- C. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- D. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- E. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- G. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 - 1. True muntins.
 - 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- H. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.

1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- I. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.5 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.6 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.

1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9450 Windows
 - b. Fixed Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (730 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 100 psf (4800 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 150 psf (7200 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-9450 Windows - Fixed
 3. 4" (101.6 mm) frame depth
 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)

4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.080" (2.03 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9450 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.

2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.6 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.

4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9500 Windows
 - b. Fixed Window
 - c. 4" (101.6 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG100-FW

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 96" (1524 x 2438). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 96" (1524 x 2438). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 100 psf (4788 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 150 psf (7182 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
8. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
9. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 1. Kawneer Company Inc.
 2. Series TR-9500 Windows - Fixed
 3. 4" (101.6 mm) frame depth
 4. AW-PG100-FW

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)

4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.062" (1.57 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9500 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
 1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
 1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.

2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.6 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (2.4 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.

4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
 - 1. Types of aluminum windows include:
 - a. Kawneer Series TR-9950 Windows
 - b. Fixed Window
 - c. 4-1/2" (114.3 mm) frame depth
 - d. AW-PG100-FW

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 086300 "Metal-Framed Skylights"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG100-FW.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 99" (1524 x 2515). Air infiltration rate shall not exceed 0.10 cfm/ft² at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 99" (1524 x 2515). There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).
- 5. Uniform Deflection: No more than L/175 when tested per ASTM E330 at a static air pressure difference of 100 psf (4800 Pa).

6. Uniform Structural Load: no glass breakage or permanent damage to fasteners, and maximum .2% permanent deformation of the span of any frame member when tested per ASTM E330 at a static air pressure difference of 150 psf (7182 Pa).
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

EDITOR NOTE: VALUES LISTED ARE BASED UPON 1" LOW E, GAS FILLED INSULATING GLASS. OTHER GLASS TYPES MAY YIELD IMPROVED U-FACTOR AND CFR.

8. U-Factor Simulation: thermal computer simulation per NFRC 100, at the prescribed 24"x 24" (1149 x 1149) Non-Residential Size, glazed with 1" insulating clear glass made with triple glazed w/ suspended film, (2) 3/8" krypton gas spacers, soft coat low E coating: Thermal Transmittance to be maximum 0.48 BTU/HR/SQ.FT°F.
9. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
10. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements." Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 Project Conditions

- A. Field Measurements: Verify aluminum window openings by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series TR-9950 Windows - Fixed
 - 3. 4-1/2" (114.3 mm) frame depth
 - 4. AW-PG100-FW.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.094" (2.39 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Window System

- A. Series TR-9950 Windows - Fixed

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Accessories

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
1. True muntins.
 2. Between the glass muntins.

EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
 2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.

2.6 Fabrication

- A. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
1. Profiles that are sharp, straight, and free of defects or deformations.
 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation within framing members, and moisture migrating within the system to exterior.
 4. Physical and thermal isolation of glazing from framing members.
 5. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 6. Provisions for field replacement of glazing.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.070" (1.78 mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

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2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

B. Factory Finishing:

1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install aluminum framed window system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install aluminum framed window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 085113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 084113 ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
1. Types of Kawneer Aluminum Entrances include:
 - a. 2000T Terrace Doors; 4-3/8" (111.13) nominal face dimension, 2-1/4" (57.2) depth, moderate traffic applications.
 - b. Single Door - Outswing:
 - 1) 4" (101.6) frame; AW-PG90-ATD.
 - 2) 5" (127) frame; AW-PG90-ATD.
 - 3) 4" (101.6) frame; Low Profile Sill: AW-PG90-ATD.
 - 4) 4" (101.6) frame; Small and Large Missile Impact (IR - Wet Glazed): AW-PG90-ATD.
 - 5) 4" (101.6) frame; Large Missile Impact (IR - Dry Glaze): AW-PG70-ATD.
 - c. Single Door - Inswing:
 - 1) 4" (101.6) frame; AW-PG90-ATD.
 - 2) 4" (101.6) frame; Small and Large Missile Impact (IR - Wet Glazed): AW-PG90-ATD.
 - 3) 4" (101.6) frame; Large Missile Impact (IR - Dry Glaze): AW-PG70-ATD.
 - d. Pairs of Doors - Outswing:
 - 1) 4" (101.6) frame; Medium Astragal: AW-PG65-ATD.
 - 2) 5" (127) frame; Medium Astragal: AW-PG65-ATD.
 - 3) 4" (101.6) frame; Low Profile Sill with Medium Astragal: AW-PG65-ATD.
 - 4) 4" (101.6) frame; Small Missile Impact with Medium Astragal (IR - Wet Glazed): AW-PG90-ATD.
 - 5) 4" (101.6) frame; Large Missile Impact with Large Astragal (IR - Wet Glazed): AW-PG90-ATD.
 - e. Pairs of Doors - Inswing:
 - 1) 4" (101.6) frame; Medium Astragal: AW-PG65-ATD.
 - 2) 5" (127) frame; Medium Astragal: AW-PG65-ATD.
 - 3) 4" (101.6) frame; Small Missile Impact with Medium Astragal (IR - Wet Glazed): AW-PG90-ATD.
 - 4) 4" (101.6) frame; Large Missile Impact with Large Astragal (IR - Wet Glazed): AW-PG90-ATD.
 - 5) 4" (101.6) frame; Large Missile Impact with Large Astragal (IR - Dry Glaze): AW-PG70-ATD.
 - f. 1" x 4" (25.4 x 101.6) door frame.
 - g. 1-1/2" x 5" (38.1 x 127) door frame.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084313 "Aluminum-Framed Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"

12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed terrace doors representing those indicated for this project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Terrace Door Entrance Performance Requirements:
1. Provide aluminum terrace doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
 2. Performance Class and Grade:
 - a. Single Door - Outswing:
 - 1) 4" (101.6) frame; AW-PG90-ATD.
 - 2) 5" (127) frame; AW-PG90-ATD.
 - 3) 4" (101.6) frame; Low Profile Sill: AW-PG90-ATD.
 - 4) 4" (101.6) frame; Small and Large Missile Impact (IR - Wet Glazed): AW-PG90-ATD.
 - 5) 4" (101.6) frame; Large Missile Impact (IR - Dry Glaze): AW-PG70-ATD.
 - b. Single Door – Inswing:
 - 1) 4" (101.6) frame; AW-PG90-ATD.
 - 2) 4" (101.6) frame; Small and Large Missile Impact (IR - Wet Glazed): AW-PG90-ATD.
 - 3) 4" (101.6) frame; Large Missile Impact (IR - Dry Glaze): AW-PG70-ATD.
 - c. Pairs of Doors - Outswing:
 - 1) 4" (101.6) frame; Medium Astragal: AW-PG65-ATD.
 - 2) 5" (127) frame; Medium Astragal: AW-PG65-ATD.
 - 3) 4" (101.6) frame; Low Profile Sill with Medium Astragal: AW-PG65-ATD.
 - 4) 4" (101.6) frame; Small Missile Impact with Medium Astragal (IR – Wet Glazed): AW-PG90-ATD.
 - 5) 4" (101.6) frame; Large Missile Impact with Large Astragal (IR – Wet Glazed): AW-PG90-ATD.
 - d. Pairs of Doors – Inswing:
 - 1) 4" (101.6) frame; Medium Astragal: AW-PG65-ATD.
 - 2) 5" (127) frame; Medium Astragal: AW-PG65-ATD.
 - 3) 4" (101.6) frame; Small Missile Impact with Medium Astragal (IR – Wet Glazed): AW-PG90-ATD.
 - 4) 4" (101.6) frame; Large Missile Impact with Large Astragal (IR – Wet Glazed): AW-PG90-ATD.
 - 5) 4" (101.6) frame; Large Missile Impact with Large Astragal (IR - Dry Glaze): AW-PG70-ATD.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR TERRACE DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- C. Air Infiltration: Outswing and Inswing Doors: When closed and locked, the test specimen shall be tested in accordance with ASTM E 283 entrance doors and frame shall not exceed 0.30 cfm/ft² at a pressure differential of 6.2 psf (300 Pa). The test specimen shall meet the A3 rating of less than 0.55 (m³/h)/m at 1.5 psf (75 Pa) when tested in accordance with CAN/CSA-A440-00.
- D. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E 331 and ASTM E 547 there shall be no uncontrolled leakage as defined in the test method at a static air pressure differential of 12 psf (575 Pa). The test specimen shall meet the B5 rating with no water leakage at 12 psf (575 Pa) when test in accordance with CAN/CSA-A440-00.
- E. Uniform Load Deflection: When closed and locked, the test specimen shall be tested in accordance with ASTM E 330 at a minimum static air design pressure of 90 psf (4309 Pa) for single and 65 psf (3112 Pa) for pairs applied in a positive and negative direction. The test specimen shall meet the C4 or C5 rating when tested in accordance with CAN/CSA-A440-00.
- F. Uniform Load Structural: When closed and locked, the test specimen shall be tested in accordance with ASTM E 330 at a minimum static air design pressure of 135 psf (6464 Pa) for single and 97.5 psf (4668 Pa) for pairs (1.5 x design load) applied in a positive and negative direction.

EDITOR NOTE: THERMAL TRANSMITTANCE, CONDENSATION RESISTANCE, AND CONDENSATION INDEX VALUES ARE BASED ON 1" CLEAR INSULATING GLASS (1/4" Low-E GLASS / 1/2" ARGON AIR SPACE / 1/4" GLASS). ACOUSTICAL PERFORMANCE STC AND OITC VALUES ARE BASED ON DOUBLE LAMINATED INSULATING GLASS (1/8", 0.060 PVB, 1/8"/ 1/2" AIR SPACE / 1/8", 0.060 PVB, 1/8").

- G. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than 0.49 BTU/hr/sf/F.

EDITOR NOTE: SELECT CONDENSATION PERFORMANCE BASED ON U.S. STANDARD (H) OR CANADIAN STANDARD (I) FROM BELOW.

- H. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than $55_{\text{frame}}, 75_{\text{glass}}$.
- I. Condensation Index: When tested in accordance with CSA-A440 the condensation index shall not be less than $44_{\text{frame}}, 61_{\text{glass}}$.
- J. Acoustical Performance: When tested to AAMA Specification 1801 and in accordance with ASTM E 1425 the STC (Sound Transmission Class) Rating shall not be less than 39, and the OITC (Outside Inside Transmission Class) shall not be less than 32.
- K. Forced Entry Resistance: Terrace Doors shall conform to ASTM F588, Grade 10.

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

- L. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, ASTM E1996, and TAS 201/203.
 - 1. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - 2. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum terrace door and frame system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum terrace door and frame system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, and grade of aluminum terrace door and frame.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
 - 1. Joinery, showing mitered, clip and stake joint construction.
 - 2. Glazing.
- G. Other Action Submittals:
 - 1. Terrace Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of terrace door hardware, as well as procedures and diagrams. Coordinate final terrace door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of terrace door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum terrace doors and frames that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum terrace doors and frames through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum terrace doors and frames, and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of terrace door(s) and frame(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum terrace door and frame openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 Manufacturers**

- A. Basis-of-Design Product:
1. Kawneer Company Inc.
 2. 2000T Terrace Doors
 3. Entrance Member Profile: 4-3/8" (111.13) nominal face dimension, 2-1/4" (57.2) depth, moderate traffic applications.
 4. Major portions of the door members to be 0.125" (3.2) nominal in thickness and glazing molding to be 0.07" (1.8) thick.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid terrace door and frame installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for terrace door and frame system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum terrace doors and frames for a period of not less than ten (10) years. (Company Name)
 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum (Terrace Door and Components): Alloy and temper recommended by manufacturer for type of use and finish indicated, complying with the requirements of standards indicated below.
1. Extruded Material Standard: ASTM B 221, 6063-T6 alloy and temper.
- B. Glazing Gaskets / Setting Blocks: Manufacturer's standard glazing system of black, resilient glazing gaskets, setting blocks, and shims or spacers, fabricated from an elastomer of type and in hardness recommended by system and gasket manufacturer to comply with system performance requirements.
- C. Fasteners: Where exposed, shall be 300 Series, Stainless Steel.
- D. Weather Stripping: Co-extruded dual durometer EPDM (black).
- E. Thermal Barrier: Shall be two continuous rows of polyamide glass reinforced 6/6 nylon at door rails, door stiles, small astragal, medium astragal and 4" (101.6) frame. The large astragal on pairs of doors shall be Kawneer IsoStrut™. The 5" (127) frame thermal barrier shall be Kawneer IsoLock™ with a nominal 3/8" (9.5) separation consisting of a two-part, chemically curing high density polyurethane which is mechanically and adhesively bonded to the aluminum.

2.3 Terrace Door Framing System

- A. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- B. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

- C. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- D. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle terrace door and frame material, and components to avoid damage. Protect terrace door and frame material against damage from elements, construction activities, and other hazards before, during and after terrace door and frame installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum terrace door units.
- B. Glazing System: Glazing method shall be a type in accordance with manufacturer's standards. Glazing shall be snap-in type glazing beads with a gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and secure aluminum terrace doors and frames.

EDITOR NOTE: REVISE BELOW FOR SPECIFIC HARDWARE FOR EACH SPECIFIC ENTRANCE TYPE. TO INSURE SINGLE SOURCE RESPONSIBILITY AND TIMELY COORDINATION, THE KAWNEER COMPANY RECOMMENDS THAT YOUR FINISH HARDWARE REQUIREMENTS BE INCLUDED IN THIS SECTION. IF THESE REQUIREMENTS MUST BE FURNISHED UNDER THE "FINISH HARDWARE" SECTION OF THE SPECIFICATIONS, THE FOLLOWING STATEMENT SHOULD BE INCLUDED. "THE FINISH HARDWARE SUPPLIER SHALL BE RESPONSIBLE FOR FURNISHING PHYSICAL HARDWARE TO THE ENTRANCE MANUFACTURER PRIOR TO FABRICATION, AND FOR COORDINATING HARDWARE DELIVERY REQUIREMENTS WITH THE HARDWARE MANUFACTURER, THE GENERAL CONTRACTOR AND THE ENTRANCE MANUFACTURER TO INSURE THE BUILDING PROJECT IS NOT DELAYED".

- B. Standard Entrance Hardware: Provide heavy-duty hardware units indicated in sizes, number and type recommended by manufacturer for entrances indicated. Finish exposed parts to match door finish, unless otherwise indicated.
- C. Hinges:
 - 1. Butt Hinges: Provide manufacturer's standard mortised, top, bottom and intermediate aluminum 3-way adjustable butt hinges.

EDITOR NOTE: SELECT FROM BELOW IF REQUIRED.

- D. Door Control:
 - General: Comply with manufacturer's recommendations for closer size, depending on door size, exposure to weather, anticipated frequency of use and accessibility requirements.
 - 1. Overhead Door Stop: Shall be stainless steel with rubber bumper door check mounted in the top rail of the door leaf.
 - 2. (Optional) Closer: LCN 1260 surface mounted closer and drop plate.
- E. Standard Locking Hardware:
 - 1. Singles (Outswing or Inswing):
Active Leaf: Stainless steel multipoint locking gearbox consisting of swinghooks, latch lock and dead bolt activated by a lever handle.
 - 2. Pairs (Outswing or Inswing):
Active Leaf: Stainless steel multipoint locking gearbox consisting of swinghooks, latch lock and dead bolt activated by a lever handle.
Inactive Leaf: Stainless steel locking gearbox with top and bottom shootbolts activated by a lever handle into stainless steel shootbolt keepers.

EDITOR NOTE: SELECT FROM BELOW.

- F. Trim Sets:
 - 1. Hoppe solid brass Rodos style lever handle with escutcheon.
 - 2. Keyed cylinder and thumbturn included:
 - a. Singles: Key exterior / thumbturn interior
 - b. Pairs: Active leaf - key exterior / thumbturn interior, or
Active leaf - blank exterior / thumbturn interior.
Inactive leaf - blank exterior / thumbturn interior.

EDITOR NOTE: SELECT FROM BELOW.

- G. Trim Set Finish:
 - 1. Polished Brass.
 - 2. Brushed Chrome.
 - 3. Rustic Umber.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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- H. Thresholds: Provide manufacturer's standard thermally broken threshold with removable threshold cover, cutouts coordinated for operating hardware, and anchors in the following material. Optional non-thermal low profile threshold.
1. Material: Aluminum, finish to match door and frame.

2.6 Fabrication

- A. Entrance System Fabrication:
1. Door corner construction shall be neatly mitered and reinforced with heavy-duty aluminum corner blocks forming a rigid watertight joint. Corners shall be mechanically fastened.
 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 3. Arrange fasteners and attachments to conceal from view.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight terrace door and frame installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum terrace doors and frames, hardware, accessories, and other components.
- B. Install aluminum terrace doors and frames level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing terrace doors and frames. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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SECTION 084116 ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) Project Resource Manual ("Manual of Practice"), including the recommendations for the CSI Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Aluminum Entrances, glass and glazing, and door hardware and components.
 - 1. Types of Kawneer Aluminum Entrances include:
 - a. NX-8910 Terrace Doors (Outswing) 2-3/4" (69.8) depth, moderate traffic applications.
 - 1) AW-PG50-ATD – Single (Standard Sill).
 - 2) ATD-HC45 – Pair (Standard Sill).
 - 3) ATD-HC45 – Single (Low-profile Sill).
 - b. NX-8920 Terrace Doors (Inswing) 2-3/4" (69.8) depth, moderate traffic applications.
 - 1) AW-PG50-ATD – Single (Standard Sill).
 - c. 3-1/4" (82.5) or 4-5/8" (117.5) frame depth.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084313 "Aluminum-Framed Storefronts"
 - 5. 084329 "Sliding Storefronts"
 - 6. 084413 "Glazed Aluminum Curtain Walls"
 - 7. 084433 "Sloped Glazing Assemblies"
 - 8. 085113 "Aluminum Windows"
 - 9. 086300 "Metal-Framed Skylights"
 - 10. 087000 "Hardware"
 - 11. 088000 "Glazing"
 - 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed terrace doors representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Terrace Door Entrance Performance Requirements:
 - 1. Provide aluminum terrace doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - 2. Performance Class and Grade: AW-PG50-ATD.

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR TERRACE DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- C. Air Infiltration: Outswing and Inswing Doors: When closed and locked, the test specimen shall be tested in accordance with ASTM E 283 entrance doors and frame shall not exceed 0.10 cfm/ft² (Inswing), 0.40 cfm/ft² (Outswing) at a pressure differential of 6.24 psf (300 Pa).
- D. Water Resistance: When closed and locked, the test specimen shall be tested in accordance with ASTM E 331 and ASTM E 547 there shall be no uncontrolled leakage as defined in the test method at a static air pressure differential of 15 psf (720 Pa) (Outswing - Standard Sill), 12 psf (574 Pa) (Outswing - Low-profile Sill), 12 psf (574 Pa) (Inswing – Standard Sill).
- E. Uniform Design Load Test: When closed and locked, the test specimen shall be tested in accordance with ASTM E 330 at a minimum static air design pressure of:
1. NX-8910 Terrace Doors (Outswing).
 - a. AW-PG50-ATD – Single (Standard Sill) 50 psf (2394 Pa) applied in a positive and negative direction.
 - b. ATD-HC45 – Pair (Standard Sill) 45 psf (2155 Pa) applied in a positive and negative direction.
 - c. ATD-HC45 – Single (Low-profile Sill) 45 psf (2155 Pa) applied in a positive and negative direction..
 2. NX-8920 Terrace Doors (Inswing).
 - a. AW-PG50-ATD – Single (Standard Sill) 50 psf (2394 Pa) applied in a positive and negative direction.
- F. Uniform Load Structural Test: When closed and locked, the test specimen shall be tested in accordance with ASTM E 330 at a minimum static air design pressure of:
1. NX-8910 Terrace Doors (Outswing).
 - a. AW-PG50-ATD – Single (Standard Sill) 75 psf (3591 Pa) (1.5 x design load) applied in a positive and negative direction.
 - b. ATD-HC45 – Pair (Standard Sill) 67.5 psf (3232 Pa) (1.5 x design load) applied in a positive and negative direction.
 - c. ATD-HC45 – Single (Low-profile Sill) 67.5 psf (3232 Pa) (1.5 x design load) applied in a positive and negative direction.
 2. NX-8920 Terrace Doors (Inswing).
 - a. AW-PG50-ATD – Single (Standard Sill) 75 psf (3591 Pa) (1.5 x design load) applied in a positive and negative direction.
- EDITOR NOTE: THERMAL TRANSMITTANCE, CONDENSATION RESISTANCE, AND CONDENSATION INDEX VALUES ARE BASED ON 1" CLEAR INSULATING GLASS (1/8" Low-E GLASS / 3/4" ARGON AIR SPACE / 1/8" Low-E GLASS).**
- G. Thermal Transmittance Test (U-Factor): When tested in accordance with AAMA 1503, the conductive thermal transmittance (U-Factor) shall not be more than 0.42 BTU/hr/ft²/F.
- H. Condensation Resistance Test (CRF): When tested in accordance with AAMA 1503, the condensation resistance factor (CRF) shall not be less than 60_{frame}, 78_{glass}.
- I. Acoustical Performance: When tested to AAMA Specification 1801 and in accordance with ASTM E 1425 the STC (Sound Transmission Class) Rating shall not be less than 36, and the OITC (Outside Inside Transmission Class) shall not be less than 30.
- J. Forced Entry Resistance: Terrace Doors shall conform to ASTM F588, Grade 10.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum terrace door and frame system indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum terrace door and frame system and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, of aluminum terrace door and frame.
- F. Fabrication Sample: Corner sample consisting of a door stile and rail, of full-size components and showing details of the following:
1. Joinery, showing mitered, clip and stake joint construction.
 2. Glazing.
- G. Other Action Submittals:
1. Terrace Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of terrace door hardware, as well as procedures and diagrams. Coordinate final terrace door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of terrace door hardware.

1.6 Quality Assurance

- A. **Installer Qualifications:** An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. **Manufacturer Qualifications:** A manufacturer capable of fabricating aluminum terrace doors and frames that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. **Source Limitations:** Obtain aluminum terrace doors and frames through one source from a single manufacturer.
- D. **Product Options:** Drawings indicate size, profiles, and dimensional requirements of aluminum terrace doors and frames, and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. **Mockups:** Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of terrace door(s) and frame(s) indicated, in location(s) shown on Drawings.
- F. **Pre-installation Conference:** Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. **Field Measurements:** Verify actual dimensions of aluminum terrace door and frame openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. **Manufacturer's Warranty:** Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. **Warranty Period:** Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. **Basis-of-Design Product:**
 - 1. Kawneer Company Inc.
 - 2. NX-8910 Terrace Doors – Outswing.
 - 3. NX-8920 Terrace Door – Inswing.
 - 4. Entrance Member Profile: 4.125" (104.7) nominal face dimension, 2-3/4" (69.8) depth, moderate traffic applications.
 - 5. 3-1/4" (82.5) or 4-5/8" (117.5) frame depth.

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. **Substitutions:** Refer to Substitutions Section for procedures and submission requirements
 - 1. **Pre-Contract (Bidding Period) Substitutions:** Submit written requests ten (10) days prior to bid date.
 - 2. **Post-Contract (Construction Period) Substitutions:** Submit written request in order to avoid terrace door and frame installation and construction delays.
 - 3. **Product Literature and Drawings:** Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. **Certificates:** Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for terrace door and frame system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum terrace doors and frames for a period of not less than ten (10) years. (Company Name)
 - 5. **Test Reports:** Submit test reports verifying compliance with each test requirement required by the project.
 - 6. **Samples:** Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. **Substitution Acceptance:** Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

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Laws and building and safety codes governing the design and use of glazed necessary for product improvement.
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2.2 Materials

- A. Aluminum (Terrace Door and Components): Alloy and temper recommended by manufacturer for type of use and finish indicated, complying with the requirements of standards indicated below.
 - 1. Extruded Material Standard: ASTM B 221, 6063-T6 alloy and temper.
- B. Glazing Gaskets / Setting Blocks: Manufacturer's standard glazing system of black, resilient glazing gaskets, setting blocks, and shims or spacers, fabricated from an elastomer of type and in hardness recommended by system and gasket manufacturer to comply with system performance requirements.
- C. Fasteners: Where exposed, shall be 300 Series, Stainless Steel.
- D. Weather Stripping: Hollow black thermoplastic elastomer (TPE) bulb gasket with rigid polypropylene backing.
- E. Thermal Barrier: Shall be two continuous rows of polyamide glass reinforced 6/6 nylon at door rails, door stiles and frame.

2.3 Terrace Door Framing System

- A. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- B. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- C. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- D. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle terrace door and frame material, and components to avoid damage. Protect terrace door and frame material against damage from elements, construction activities, and other hazards before, during and after terrace door and frame installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Glazing shall be silicone back bedding sealant and snap-in type glazing beads with a gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and secure aluminum terrace doors and frames.
- B. Standard Entrance Hardware: Provide heavy-duty hardware units indicated in sizes, number and type recommended by manufacturer for entrances indicated. Finish exposed parts to match door finish, unless otherwise indicated.
- C. Hinges:
 - 1. Butt Hinges: Provide manufacturer's standard mortised, top, bottom and intermediate aluminum 3-way adjustable butt hinges.

EDITOR NOTE: SELECT FROM BELOW IF REQUIRED.

- D. Door Control:
 - 1. Overhead Door Stop: Shall be stainless steel with rubber bumper door check mounted in the top rail of the door leaf.
- E. Standard Locking Hardware:
 - 1. Singles (Outswing or Inswing):
 - Active Leaf: Stainless steel multipoint locking gearbox consisting of roundbolts, latch lock, and dead bolt activated by a lever handle.
 - a. Optional: Stainless steel 5-point locking gearbox consisting of roundbolts, latch lock, dead bolt, and shootbolts activated by a lever handle.
 - 2. Pairs (Outswing or Inswing):
 - Active Leaf: Stainless steel multipoint locking gearbox consisting of roundbolts, latch lock and dead bolt activated by a lever handle.
 - Inactive Leaf: Dummy handle with manual flushbolts into aluminum flushbolt keepers.

EDITOR NOTE: SELECT FROM BELOW.

- F. Trim Sets:
 - 1. Hoppe solid brass lever handle with escutcheon.
 - a. Rodos Style

- b. Verona Style
- c. Munchen Style
- d. New Orleans Style
- e. Toronto Style
- 2. Keyed cylinder and thumbturn included:
 - a. Singles: Key exterior / thumbturn interior.
 - b. Pairs: Active leaf - key exterior / thumbturn interior, or
Active leaf - blank exterior / thumbturn interior.
Inactive leaf - blank exterior / thumbturn interior.

EDITOR NOTE: SELECT FROM BELOW.

- G. Trim Set Finish:
 - 1. Polished Brass.
 - 2. Satin Nickle
 - 3. Antique Brass
 - 4. Oil-Rubbed Brass
 - 5. Matte Black
 - 6. Polished Chrome
 - 7. Pure White
- H. Thresholds: Provide manufacturer's standard thermally broken threshold, cutouts coordinated for operating hardware, and anchors in the following material.
 - 1. Material: Aluminum, finish to match door and frame.

2.6 Fabrication

- A. Entrance System Fabrication:
 - 1. Door corner construction shall be neatly mitered and reinforced with heavy-duty aluminum corner blocks forming a rigid watertight joint. Corners shall be crimped.
 - 2. Accurately fit and secure joints and corners. Make joints hairline in appearance.
 - 3. Arrange fasteners and attachments to conceal from view.

2.7 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight terrace door and frame installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum terrace doors and frames, hardware, accessories, and other components.

- B. Install aluminum terrace doors and frames level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill threshold in bed of sealant, as indicated, for weather tight construction.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing terrace doors and frames. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084113

SECTION 083213 - SLIDING ALUMINUM-FRAMED GLASS DOORS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS COMMERCIAL (C) OR HEAVY COMMERCIAL (HC) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer sliding aluminum-framed glass doors, including factory glazing, operating hardware and accessories designed for exterior applications.
 - 1. Types of sliding aluminum-framed glass doors include:
 - a. Kawneer Series 990 Sliding Door
 - b. SD-C-60 / SGD-HC-60

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 4. 084313 "Aluminum-Framed Storefronts"
 - 5. 084329 "Sliding Storefronts"
 - 6. 084413 "Glazed Aluminum Curtain Walls"
 - 7. 084433 "Sloped Glazing Assemblies"
 - 8. 085113 "Aluminum Windows"
 - 9. 086300 "Metal-Framed Skylights"
 - 10. 087000 "Hardware"
 - 11. 088000 "Glazing"
 - 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Sliding aluminum-framed glass door system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Sliding Aluminum-Framed Glass Door Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS COMMERCIAL (C) OR HEAVY COMMERCIAL (HC) BASED ON PROJECT REQUIREMENTS.

- 1. Performance Requirements: Provide sliding aluminum-framed glass doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: SD-C-60
 - b. Performance Class and Grade: SGD-HC-60

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR SLIDING ALUMINUM-FRAMED GLASS DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

- 2. Wind loads: Provide sliding door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s•m²) at a static air pressure differential of 1.57 psf (75 Pa).
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331. There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (480 Pa).
5. Forced Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 842.
6. Operating Force: Tested according to and complying with ASTM E2068.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding aluminum-framed glass doors indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding aluminum-framed glass door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding aluminum-framed glass doors. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 1. Sliding Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding door hardware, as well as procedures and diagrams. Coordinate final sliding door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding aluminum-framed glass doors and storefronts that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding aluminum-framed glass door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding aluminum-framed glass doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of sliding aluminum-framed glass door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding aluminum-framed glass door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS COMMERCIAL (C) OR HEAVY COMMERCIAL (HC) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series 990 Sliding Doors
 - 3. SD-C-60 / SGD-HC-60

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding aluminum-framed glass door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding aluminum-framed glass doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed glass door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding door, provide sliding door manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Sliding Door

- A. Sliding Aluminum-Framed Glass Doors:
 - 1. 990 Sliding Doors.
 - 2. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
 - 3. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
 - 4. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
 - 5. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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6. Storage and Protection: Store sliding door materials protected from exposure to harmful weather conditions. Handle material and components to avoid damage. Protect material against damage from elements, construction activities, and other hazards before, during and after sliding door installation.

2.4 Glazing

- A. Glazing System: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding aluminum-framed glass doors units.
- B. Glazing System: Glazing method shall be a channel type PVC gasket (marine glazed) which is compatible with aluminum and shall be resistant to deterioration by all forms of weathering and suitably retained to maintain a watertight seal between the glass and the surrounding frame.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding aluminum-framed glass doors.
- B. Standard Hardware:
 1. One pair of stainless steel tandem rollers per sliding panel.
 2. Stainless steel roller track.
 3. Adams Rite 1847 Stainless Steel Deadlock.
 4. Blank extruded pull handle exterior.
 5. Extruded pull with slide operator interior.
- C. Optional Hardware:

EDITOR NOTE: SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Adams Rite MS 1850A-505 Hookbolt Lock.
2. Mortise cylinder, interior or exterior.
3. Thumbturn, interior.
4. Flush pull blank or with cylinder exterior.
5. Flush pull blank or with slide operator interior.

2.6 Insect Screens

- A. Optional Insect Screens: Extruded aluminum frames, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum sliding doors; splines shall be extruded vinyl, removable to permit rescreening.
- B. Hardware: Manufacturer's standard flush pull, adjustable stainless steel or steel rollers and continuous EPDM closure strip at jamb.

2.7 Fabrication

- A. Fabricate sliding aluminum-framed glass doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate sliding aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
 1. Master Frame: Joined together with butt type joints, neatly sealed and assembled by a minimum of 2 stainless steel fasteners per joint anchored into continuous integral screw raceways.
 2. Sliding Panels: Shall have coped butt type joinery secured with stainless steel fasteners. Sliding panels shall not be removable when in a locked position.
 3. Fixed Panels: Shall have coped butt type joinery secured with stainless steel fasteners.
- C. Weather Stripping: Provide weather stripping locked into extruded grooves in door panels or frames as indicated on manufactures drawings and details.
- D. Weep Holes: Provide weep holes and internal drainage passages to conduct infiltrating water to exterior as detailed.
- E. Factory-Glazed Fabrication: Glaze sliding aluminum-framed glass doors in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding doors, hardware, accessories, and other components.
- B. Install sliding doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding doors and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed sliding doors shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct in accordance with ASTM E 783. Tests shall be conducted at a minimum uniform static test pressure of 1.57 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted at a static test pressure equal to 2/3 of the tested laboratory performance test pressure.
 2. Testing Extent: Architect shall select sliding door units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured and prior to the installation of interior finishes and trim. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding doors. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect sliding door surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding door surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding door surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 083213

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 083213 - SLIDING ALUMINUM-FRAMED GLASS DOORS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes Kawneer Sliding aluminum-framed glass doors, including factory glazing, operating hardware and accessories designed for exterior applications.
 - 1. Types of sliding aluminum-framed glass doors include:
 - a. Kawneer Series AA™3200 Thermal Sliding Doors
 - b. 6-3/4" (171.5 mm) frame depth
 - c. AW-PG135-SD

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 084113 "Aluminum-Framed Entrances and Storefronts"
- 4. 084313 "Aluminum-Framed Storefronts"
- 5. 084329 "Sliding Storefronts"
- 6. 084413 "Glazed Aluminum Curtain Walls"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 087000 "Hardware"
- 11. 088000 "Glazing"
- 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Sliding aluminum-framed glass door system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Sliding Aluminum-Framed Glass Door Performance Requirements:
 - 1. Performance Requirements: Provide sliding aluminum-framed glass doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: AW-PG135-SD

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR SLIDING ALUMINUM-FRAMED GLASS DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- 2. Wind loads: Provide sliding door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s•m²) at a static air pressure differential of 1.56 psf (75 Pa).

4. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331. There shall be no leakage as defined in the test method at a static air pressure differential of 15 psf (718 Pa).
 - a. Water performance for optional low profile sill of 4 psf (192 Pa).
5. Uniform Load: A static air design load of 40 PSF (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing member in excess of 0.2% of the clear spans shall occur.
6. Forced Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 842.
7. Operating Force: Tested according to and complying with ASTM E2068.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE PERFORMANCE RESULTS ARE BASED UPON 1" HIGH PERFORMANCE (HP) INSULATING GLASS (1/4" CLEAR WITH $\epsilon=0.035$ LOW E COATING ON #2 SURFACE, 1/2" AS WITH WARM EDGE SPACER AND 90% ARGON GAS, 1/4" CLEAR).

8. Thermal Transmittance (U-Factor): The thermal transmittance (U-Factor) shall not be more than 0.45 when tested to AAMA 1503.

EDITOR NOTE: SELECT CONDENSATION PERFORMANCE BASED ON U.S STANDARD (CRF) OR CANADIAN STANDARD (I) FROM BELOW.

9. Condensation Resistance Factor (CRF): When tested to AAMA 1503, the Condensation Resistance Factor shall not be less than:
 - a. 57_{frame} and 66_{glass}.
10. The Condensation Index (I): When tested to CSA-A440 shall not be less than:
 - a. 39_{frame} and 53_{glass}.

EDITOR NOTE: SOUND TRANSMISSION CLASS (STC) AND OUTDOOR-INDOOR TRANSMISSION CLASS (OITC) TEST RESULTS ARE BASED UPON 1" CLEAR DOUBLE LAMINATED INSULATING GLASS WITH PVB INTERLAYER (1/8", .030", 1/8", 1/2" AS, 1/8", .030", 1/8").

11. Sound Transmission class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with ASTM E90, the STC and OITC rating shall not be less than:
 - a. 38 (STC) and 33 (OITC).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

12. Windborne-Debris-Impact-Resistance Performance: Shall be tested in accordance with ASTM E 1886 and information in ASTM E 1996.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1 m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding aluminum-framed glass door indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding aluminum-framed glass door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding aluminum-framed glass doors. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 1. Sliding Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding door hardware, as well as procedures and diagrams. Coordinate final sliding door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding aluminum-framed glass doors that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding aluminum-framed glass door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding aluminum-framed glass doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of sliding door(s) indicated, in location(s) shown on Drawings.

- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding aluminum-framed glass door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA™3200 Thermal Sliding Doors
 - 3. 6-3/4" (171.5 mm) frame depth
 - 4. AW-PG135-SD

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding aluminum-framed glass doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed glass door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding door, provide sliding door manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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2.3 Sliding Door

- A. Sliding Aluminum-Framed Glass Doors:
1. AA™3200 Thermal Sliding Doors.
 2. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
 3. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
 4. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
 5. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
 6. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle sliding door material and components to avoid damage. Protect sliding door material against damage from elements, construction activities, and other hazards before, during and after sliding door installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding aluminum-framed glass doors units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding aluminum-framed glass doors.
- B. Standard Hardware:
1. One pair of stainless steel tandem rollers per sliding panel.
 2. Stainless steel roller track.
 3. Hookbolt lock: [1-point Hookbolt lock] or [2-point Hookbolt lock].
 4. Pull handle exterior: [Flush finger pull] or ["D" Pull].
 5. Pull handle interior: [Flush finger pull] or ["D" Pull].

2.6 Insect Screens

- A. Optional Insect Screens: Extruded aluminum frames, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum sliding doors; splines shall be extruded vinyl, removable to permit rescreening.
- B. Hardware: Manufacturer's standard flush pull, adjustable stainless steel or steel rollers and continuous EPDM closure strip at jamb.

2.7 Fabrication

- A. Fabricate sliding aluminum-framed glass doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate sliding aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
1. Master Frame: Joined together with butt type joints, neatly sealed and assembled by a minimum of 2 stainless steel fasteners per joint anchored into continuous integral screw raceways.
 2. Sliding Panels: Shall have coped butt type joinery secured with stainless steel fasteners. Sliding panels shall not be removable when in a locked position.
 3. Fixed Panels: Shall have coped butt type joinery secured with stainless steel fasteners.
- C. Weather Stripping: Provide weather stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.
- D. Weep Holes: Provide weep holes and internal drainage passages to conduct infiltrating water to exterior as detailed.
- E. Factory-Glazed Fabrication: Glaze sliding aluminum-framed glass doors in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding doors, hardware, accessories, and other components.
- B. Install sliding doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding doors and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed sliding doors shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct in accordance with ASTM E 783. Tests shall be conducted at a minimum uniform static test pressure of 1.57 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted at a static test pressure equal to 2/3 of the tested laboratory performance test pressure.
 - 2. Testing Extent: Architect shall select sliding door units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured and prior to the installation of interior finishes and trim. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding doors. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect sliding door surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding door surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding door surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 083213

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 083213 - SLIDING ALUMINUM-FRAMED GLASS DOORS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Aluminum Sliding Glass Doors, including factory glazing, operating hardware and accessories designed for exterior applications.

1. Types of sliding aluminum-framed glass doors include:
 - a. Kawneer Series HPS™ Monumental Sliding Doors
 - b. 6-1/2" (165 mm) sill frame depth
 - c. SGD-HC60 / SGD-HC80 / SGD-HC100 / SGD-HC120

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 084113 "Aluminum-Framed Entrances and Storefronts"
4. 084313 "Aluminum-Framed Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 087000 "Hardware"
11. 088000 "Glazing"
12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Sliding aluminum-framed glass door system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Sliding Aluminum-Framed Glass Door Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS SGD-HC60 / SGD-HC80 / SGD-HC100 / SGD-HC120 BASED ON PROJECT REQUIREMENTS.

1. Performance Requirements: Provide sliding aluminum-framed glass doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: SGD-HC60
 - b. Performance Class and Grade: SGD-HC80
 - c. Performance Class and Grade: SGD-HC100
 - d. Performance Class and Grade: SGD-HC120

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR SLIDING ALUMINUM-FRAMED GLASS DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide sliding aluminum-framed glass door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 6.24 psf (300 Pa).
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
5. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
6. Forced Entry Resistance: Comply with Performance Grade 10 requirements when tested according to AAMA 1303.5.
7. Deglazing Force: When tested in accordance with ASTM E 987, the panel shall not move from their original position, in relation to the glazing materials, by more than the original glass bite.
8. Operating Force: With each movable panel adjusted, the maximum force to open shall not exceed 40 lbf (178 N) and the force to keep in motion shall not exceed 25 lbf (111 N).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E 1886, information in ASTM E 1996 and TAS 201/203.
 - a. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding aluminum-framed glass doors indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding aluminum-framed glass door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding aluminum-framed glass doors. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 1. Sliding Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding door hardware, as well as procedures and diagrams. Coordinate final sliding door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding aluminum-framed glass doors that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding aluminum-framed glass door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding aluminum-framed glass doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of sliding door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding aluminum-framed glass door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) BASED ON PROJECT REQUIREMENTS

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series HPS™ Monumental Sliding Doors
 - 3. 6-1/2" (165 mm) sill frame depth
 - 4. SGD-HC-60 / SGD-HC-80 / SGD-HC-100 / SGD-HC-120

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding aluminum-framed glass doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed glass door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding door, provide sliding door manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Sliding Door

- A. Sliding Aluminum-Framed Glass Doors:
 - 1. HPS™ Monumental Sliding Doors.
 - 2. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
 - 3. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
 - 4. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

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5. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
6. Storage and Protection: Store sliding door materials protected from exposure to harmful weather conditions. Handle material and components to avoid damage. Protect material against damage from elements, construction activities, and other hazards before, during and after sliding door installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding aluminum-framed glass doors units.
- B. Glazing System: Glazing method for operable panel shall be a channel type PVC gasket (marine glazed) which is compatible with aluminum and shall be resistant to deterioration by all forms of weathering and suitably retained to maintain a watertight seal between the glass and the surrounding frame. Glazing method for fixed panel shall be manufacturer's standard compression types; replaceable, extruded EPDM rubber.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding aluminum-framed glass doors.
- B. Standard Hardware:
 1. One pair of stainless steel tandem rollers per sliding panel.
 2. Stainless steel roller track.
 3. Adams Rite 1847 Stainless Steel Deadlock.
 4. Extruded pull handle exterior.
- C. Optional Hardware:

EDITOR NOTE: SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Adams Rite MS 1850A-505 Hookbolt Lock.
2. Mortise cylinder, interior or exterior.
3. Thumbturn, interior.
4. Flush pull.

2.6 Insect Screens

- A. Optional Insect Screens: Extruded aluminum frames, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum sliding doors; splines shall be extruded vinyl, removable to permit rescreening.
- B. Hardware: Manufacturer's standard flush pull, adjustable stainless steel or steel rollers and continuous EPDM closure strip at jamb.

2.7 Fabrication

- A. Fabricate sliding aluminum-framed glass doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate sliding aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
 1. Master Frame: Joined together with butt type joints, neatly sealed and assembled by a minimum of 2 stainless steel fasteners per joint anchored into continuous integral screw raceways.
 2. Sliding Panels: Shall have coped butt type joinery secured by means of 2 stainless steel fasteners per joint. Sliding panels shall not be removable when in a locked position.
 3. Fixed Panels: Shall have coped butt type joinery secured by means of 2 stainless steel fasteners per joint.
- C. Weather Stripping: Provide weather stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.
- D. Weep Holes: Provide weep holes and internal drainage passages to conduct infiltrating water to exterior as detailed.
- E. Factory-Glazed Fabrication: Glaze sliding aluminum-framed glass doors in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
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 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
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 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding doors, hardware, accessories, and other components.
- B. Install sliding doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding doors and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed sliding doors shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct in accordance with ASTM E 783. Tests shall be conducted at a minimum uniform static test pressure of 1.57 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted at a static test pressure equal to 2/3 of the tested laboratory performance test pressure.
 - 2. Testing Extent: Architect shall select sliding door units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured and prior to the installation of interior finishes and trim. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding doors. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect sliding door surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding door surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding door surfaces, remove contaminants immediately according to manufacturer's written recommendations.

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This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 083213

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS HEAVY COMMERCIAL (HC) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Sliding Aluminum-Framed Glass Doors, including factory glazing, operating hardware and accessories designed for exterior applications.

- 1. Types of sliding aluminum-framed glass doors include:
 - a. Kawneer Series HPX Monumental Sliding Doors
 - b. 6-3/4" (171.5 mm) sill frame depth
 - c. SGD-HC115 / SGD-HC125 / SGD-HC137 / SGD-HC160

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 084113 "Aluminum-Framed Entrances and Storefronts"
- 4. 084313 "Aluminum-Framed Storefronts"
- 5. 084329 "Sliding Storefronts"
- 6. 084413 "Glazed Aluminum Curtain Walls"
- 7. 084433 "Sloped Glazing Assemblies"
- 8. 085113 "Aluminum Windows"
- 9. 086300 "Metal-Framed Skylights"
- 10. 087000 "Hardware"
- 11. 088000 "Glazing"
- 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Sliding aluminum-framed glass door system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Sliding Aluminum-Framed Glass Door Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS SGD-HC115 / SGD-HC125 / SGD-HC137 / SGD-HC160 BASED ON PROJECT REQUIREMENTS.

- 1. Performance Requirements: Provide sliding aluminum-framed glass doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. Performance Class and Grade: SGD-HC115
 - b. Performance Class and Grade: SGD-HC125
 - c. Performance Class and Grade: SGD-HC137
 - d. Performance Class and Grade: SGD-HC160

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR SLIDING ALUMINUM-FRAMED GLASS DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

2. Wind loads: Provide sliding aluminum-framed glass door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s·m²) at a static air pressure differential of 6.24 psf (300 Pa).
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331. There shall be no leakage as defined in the test method at a static air pressure differential of 12 psf (574 Pa).
5. Uniform Load: A static air design load of 20 psf (958 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member. At a structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.
6. Forced Entry Resistance: Comply with Performance Grade 30 requirements when tested according to ASTM F 842.
7. Deglazing Force: When tested in accordance with ASTM E 987, the panel shall not move from their original position, in relation to the glazing materials, by more than the original glass bite.
8. Operating Force: With each movable panel adjusted, the maximum force to open shall not exceed 40 lbf (178 N) and the force to keep in motion shall not exceed 25 lbf (111 N).

EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.

9. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
 - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
 - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding aluminum-framed glass doors indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding aluminum-framed glass door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding aluminum-framed glass doors. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 1. Sliding Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding door hardware, as well as procedures and diagrams. Coordinate final sliding door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding aluminum-framed glass doors that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding aluminum-framed glass door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding aluminum-framed glass doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of sliding door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding aluminum-framed glass door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS (HC) BASED ON PROJECT REQUIREMENTS

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series HPX Monumental Sliding Doors
 - 3. 6-3/4" (171.5 mm) sill frame depth
 - 4. SGD-HC115 / SGD-HC125 / SGD-HC137 / SGD-HC160

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding aluminum-framed glass doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed glass door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 - 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding door, provide sliding door manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Sliding Door

- A. Sliding Aluminum-Framed Glass Doors:
 - 1. HPX Monumental Sliding Doors.
 - 2. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
 - 3. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
 - 4. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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5. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
6. Storage and Protection: Store sliding door materials protected from exposure to harmful weather conditions. Handle material and components to avoid damage. Protect material against damage from elements, construction activities, and other hazards before, during and after sliding door installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding aluminum-framed glass doors units.
- B. Glazing System: Glazing method shall be a channel type PVC gasket (marine glazed) which is compatible with aluminum and shall be resistant to deterioration by all forms of weathering and suitably retained to maintain a watertight seal between the glass and the surrounding frame.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding aluminum-framed glass doors.
- B. Standard Hardware:
 1. One pair of stainless steel tandem rollers per sliding panel.
 2. Stainless steel roller track.
 3. Adams Rite 1847 Stainless Steel Deadlock.
 4. Extruded pull handle.
- C. Optional Hardware:

EDITOR NOTE: SUBSTITUTE OPTIONAL HARDWARE PER PROJECT REQUIREMENTS.

1. Mortise cylinder, interior or exterior.
2. Thumbturn, interior.

2.6 Insect Screens

- A. Optional Insect Screens: Extruded aluminum frames, joined at corners: 18 x 16 mesh fiberglass screen cloth; frames finished to match aluminum sliding doors; splines shall be extruded vinyl, removable to permit rescreening.
- B. Hardware: Manufacturer's standard flush pull, adjustable stainless steel or steel rollers and continuous EPDM closure strip at jamb.

2.7 Fabrication

- A. Fabricate sliding aluminum-framed glass doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate sliding aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
 1. Master Frame: Joined together with butt type joints, neatly sealed and assembled by a minimum of 2 stainless steel fasteners per joint anchored into continuous integral screw raceways.
 2. Sliding Panels: Shall have coped butt type joinery secured by means of 2 stainless steel fasteners per joint. Sliding panels shall not be removable when in a locked position
 3. Fixed Panels: Shall have coped butt type joinery secured by means of 2 stainless steel fasteners per joint.
- C. Weather Stripping: Provide weather stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.
- D. Weep Holes: Provide weep holes and internal drainage passages to conduct infiltrating water to exterior as detailed.
- E. Factory-Glazed Fabrication: Glaze sliding aluminum-framed glass doors in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.
- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding doors, hardware, accessories, and other components.
- B. Install sliding doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding doors and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed sliding doors shall take place as follows:
 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct in accordance with ASTM E 783. Tests shall be conducted at a minimum uniform static test pressure of 1.57 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted at a static test pressure equal to 2/3 of the tested laboratory performance test pressure.
 2. Testing Extent: Architect shall select sliding door units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured and prior to the installation of interior finishes and trim. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, And Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing sliding doors. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

- E. Protect sliding door surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding door surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding door surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 083213

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 083213 - SLIDING ALUMINUM-FRAMED GLASS DOORS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

EDITOR NOTE: CHOOSE PERFORMANCE CLASS COMMERCIAL WINDOW (CW) OR ARCHITECTURAL WINDOW (AW) BASED ON PROJECT REQUIREMENTS.

- A. Section includes Kawneer Sliding Aluminum-Framed Glass Doors, including factory glazing, operating hardware and accessories designed for exterior applications.
 - 1. Types of Kawneer sliding aluminum-framed glass doors include:
 - a. NX-840 Sliding Glass Doors
 - b. 4-3/8" (112 mm) or 4-5/8" (118 mm) frame depth
 - c. CW-PG30-SD, OX or XO Unit without reinforcement
 - d. CW-PG50-SD, OX or XO Unit with aluminum reinforcement
 - e. AW-PG40-SD, OX or XO Unit with reinforced interlock stile
 - f. AW-PG40-SD, OX or XO Unit with steel reinforcement in interlock stile

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER, KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 4. 084313 "Aluminum-Framed Storefronts"
 - 5. 084329 "Sliding Storefronts"
 - 6. 084413 "Glazed Aluminum Curtain Walls"
 - 7. 084433 "Sloped Glazing Assemblies"
 - 8. 085113 "Aluminum Windows"
 - 9. 086300 "Metal-Framed Skylights"
 - 10. 087000 "Hardware"
 - 11. 088000 "Glazing"
 - 12. 280000 "Electronic Safety and Security"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

- A. General Performance: Sliding aluminum-framed glass door system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Sliding Aluminum-Framed Glass Door Performance Requirements:

EDITOR NOTE: CHOOSE PERFORMANCE CLASS COMMERCIAL WINDOW (CW) OR ARCHITECTURAL WINDOW (AW) BASED ON PROJECT REQUIREMENTS.

- 1. Performance Requirements: Provide sliding aluminum-framed glass doors of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
 - a. CW-PG30-SD, OX or XO Unit without reinforcement
 - b. CW-PG50-SD, OX or XO Unit with aluminum reinforcement
 - c. AW-PG40-SD, OX or XO Unit with reinforced interlock stile
 - d. AW-PG40-SD, OX or XO Unit with steel reinforcement in interlock stile

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR SLIDING ALUMINUM-FRAMED GLASS DOOR SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

2. Wind loads: Provide sliding door system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.
3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283.
 - a. CW-PG30-SD, OX or XO Unit without reinforcement. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s•m²) at a static air pressure differential of 1.57 psf (75 Pa).
 - b. CW-PG50-SD, OX or XO Unit with aluminum reinforcement. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s•m²) at a static air pressure differential of 1.57 psf (75 Pa).
 - c. AW-PG40-SD, OX or XO Unit with reinforced interlock stile or with steel reinforcement in door stile. The air infiltration rate shall not exceed 0.30 cfm/ft² (1.5 L/s•m²) at a static air pressure differential of 6.27 psf (300 Pa).
4. Water Resistance: The test specimen shall be tested in accordance with ASTM E 547 and ASTM E 331.
 - a. CW-PG30-SD, OX or XO Unit without reinforcement. There shall be no leakage as defined in the test method at a static air pressure differential of 6 psf (290 Pa).
 - b. CW-PG50-SD, OX or XO Unit with aluminum reinforcement. There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (480 Pa).
 - c. AW-PG40-SD, OX or XO Unit with reinforced interlock stile or with steel reinforcement in door stile. There shall be no leakage as defined in the test method at a static air pressure differential of 10 psf (480 Pa).
5. Uniform Load:
 - a. CW-PG30-SD, OX or XO Unit without reinforcement. A static air design load of 45 PSF (2160 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing member in excess of 0.3% of the clear spans shall occur.
 - b. CW-PG50-SD, OX or XO Unit with aluminum reinforcement. A static air design load of 75 PSF (3600 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing member in excess of 0.3% of the clear spans shall occur.
 - c. AW-PG40-SD, OX or XO Unit with reinforced interlock stile or with steel reinforcement in door stile. A static air design load of 60 PSF (2880 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing member in excess of 0.2% of the clear spans shall occur.
6. Forced Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 842.
7. Operating Force: Tested according to and complying with ASTM E2068.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, and fabrication methods, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of sliding aluminum-framed glass doors indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For sliding aluminum-framed glass door and components required.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of sliding aluminum-framed glass doors. Test results based on use of downsized test units will not be accepted.
- F. Other Action Submittals:
 1. Sliding Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of sliding aluminum-framed glass door hardware, as well as procedures and diagrams. Coordinate final sliding door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of sliding door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating sliding aluminum-framed glass doors that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain sliding aluminum-framed glass door through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of sliding aluminum-framed glass doors and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of sliding door(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of sliding aluminum-framed glass door openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 Manufacturers

EDITOR NOTE: CHOOSE PERFORMANCE CLASS COMMERCIAL WINDOW (CW) OR ARCHITECTURAL WINDOW (AW) BASED ON PROJECT REQUIREMENTS.

- A. Basis-of-Design Product:
 - 1. Kawneer Company, Inc.
 - 2. NX-840 Sliding Glass Doors
 - 3. 4-3/8" (112 mm) or 4-5/8" (118 mm) frame depth
 - 4. CW-PG30, OX or XO Unit without reinforcement
 - 5. CW-PG50, OX or XO Unit with aluminum reinforcement
 - 6. AW-PG40, OX or XO Unit with reinforced interlock stile
 - 7. AW-PG40, OX or XO Unit with steel reinforcement in interlock stile

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sliding door installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sliding door system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of sliding aluminum-framed glass doors for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by sliding aluminum-framed glass door manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with sliding aluminum-framed glass door members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated sliding door, provide sliding door manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 Sliding Door

- A. Sliding Aluminum-Framed Glass Doors:
1. NX-840 Sliding Glass Doors.
 2. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
 3. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
 4. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
 5. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
 6. Storage and Protection: Store sliding aluminum-framed glass door materials protected from exposure to harmful weather conditions. Handle material and components to avoid damage. Protect material against damage from elements, construction activities, and other hazards before, during and after sliding door installation.

2.4 Glazing

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed sliding aluminum-framed glass door units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads with an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 Hardware

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock sliding aluminum-framed glass doors.
- B. Standard Hardware:
1. One pair of zinc dichromate tandem rollers per sliding panel [Optional stainless steel rollers].
 2. Stainless steel roller track cover.
 3. Hookbolt lock: 1-point Hookbolt lock.
 4. Pull handle exterior: Finger pull.
 5. Pull handle interior: ["D" pull] or [Extruded finger pull].

2.6 Insect Screens

- A. Insect Screens: Extruded aluminum frames, joined at corners: 18 x 16 mesh dark fiberglass screen cloth [Optional Aluminum screen]; frames finished to match sliding aluminum-framed glass doors; splines shall be extruded vinyl, removable to permit rescreening.
- B. Hardware: Manufacturer's standard interior/exterior pull handle, adjustable stainless steel rollers and continuous EPDM closure strip at interlock.

2.7 Fabrication

- A. Fabricate sliding aluminum-framed glass doors in sizes indicated. Include a complete system for assembling components and anchoring doors.
- B. Fabricate sliding aluminum-framed glass doors that are reglazable without dismantling perimeter framing.
1. Master Frame: Joined together with coped butt type joints, neatly sealed and assembled by a minimum of 2 stainless steel fasteners per joint anchored into continuous integral screw raceways.
 2. Sliding Panels: Shall have coped butt type joinery secured with stainless steel fasteners. Sliding panels shall not be removable when in a locked position
 3. Fixed Panels: Shall have coped butt type joinery secured with stainless steel fasteners.
- C. Weather Stripping: Provide weather stripping locked into extruded grooves in door panels or frames as indicated on manufacturer's drawings and details.
- D. Weep Holes: Provide weep holes and internal drainage passages to conduct infiltrating water to exterior as detailed.
- E. Factory-Glazed Fabrication: Glaze sliding aluminum-framed glass doors in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440.

2.8 Finishes, General

- A. Comply with AAMA-AFPA "Anodic Finishes/Painted Aluminum" for recommendations for applying and designating finishes.

- B. Appearance of Finished Work: Variations in appearance of abutting or adjacent pieces are acceptable if they are within one-half of the range of approved Samples. Noticeable variations in the same piece are not acceptable. Variations in appearance of other components are acceptable if they are within the range of approved Samples and are assembled or installed to minimize contrast.

2.9 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight sliding door installation.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76.2 mm) of opening.
 - 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 - 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing sliding doors, hardware, accessories, and other components.
- B. Install sliding doors level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weather tight construction.
- D. Install sliding doors and components to drain condensation, water penetrating joints, and moisture migrating within sliding door to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
 - 1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed sliding doors shall take place as follows:
 - 1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct in accordance with ASTM E 783.
 - i. CW rating; Tests shall be conducted at a minimum uniform static test pressure of 1.57 psf (75 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - ii. AW rating; Tests shall be conducted at a minimum uniform static test pressure of 6.27 psf (300 Pa). The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted at a static test pressure equal to 2/3 of the tested laboratory performance test pressure.
 - 2. Testing Extent: Architect shall select sliding door units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured and prior to the installation of interior finishes and trim. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 - 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 Adjusting, Cleaning, and Protection

- A. Adjust operating door panels, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing sliding doors. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.

- C. Clean factory-glazed glass immediately after installing sliding doors. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect sliding door surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor sliding door surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, mortar, alkaline deposits, stains, or other contaminants. If contaminating substances do contact sliding door surfaces, remove contaminants immediately according to manufacturer's written recommendations.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 083213

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 107113 EXTERIOR SUN CONTROL DEVICES

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Aluminum Sunshade Systems, including accessories, mountings, and shims. Sunshades are anchored directly to the vertical and/or horizontal mullions.
 - 1. Types of Kawneer Sunshades include:
 - a. Versoleil™ Horizontal Single Blade SunShade compatible with:
 - 1) 1600 Wall System™1 Curtain Wall
 - 2) 1600UT System™1 Curtain Wall
 - 3) 1600 Wall System™2 Curtain Wall
 - 4) 1600 Wall System™5 Curtain Wall
 - 5) 1600 SS™ Curtain Wall System
 - 6) 1600 SS™ (SSG) Curtain Wall System
 - 7) IR 501T/IR 501UT Storefront Framing Systems
 - 8) Trifab™ VG (Center Glaze) 451/451T/451UT
 - 9) Trifab™ (Center Glaze) 601/601T/601UT
 - b. Versoleil™ Vertical Single Blade SunShade compatible with:
 - 1) 1600 Wall System™1Curtain Wall
 - 2) 1600UT System™1 Curtain Wall
 - 3) 1600 Wall System™5 Curtain Wall
 - 4) 1600 SS™ Curtain Wall System

EDITOR NOTE: TO VIEW THE CORRELATING GUIDE SPECIFICATION FOR COMPATIBLE CURTAIN WALL AND STOREFRONT SYSTEMS PLEASE VISIT KAWNEER.COM

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 085113 "Aluminum Windows"
- 10. 086300 "Metal-Framed Skylights"
- 11. 088000 "Glazing"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: PROVIDE WIND LOAD, SNOW LOAD, & ICE LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

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- A. Structural Performance:
1. Combined load on sunshade configurations to be determined in accordance with ASCE 7 or applicable code requirements. Combined load consists of wind, snow and ice loads
 2. Design sunshade configurations to withstand stresses due to combined load. Stresses resulting from thermal expansion/contraction, shall not cause permanent deformation of sunshade assemblies or disengagement from the glazed system.
 3. Test horizontal and vertical sunshade configurations to meet a minimum load of 65 psf with a factor of safety of 2 times the design load for the horizontal blade and a factor of safety of 1.5 times the design load for the vertical blade.
 4. The assembled sunshade shall be capable of supporting a uniformly distributed load of ___ psf without damage, permanent deformation, or disengagement from the glazed system mullion.
 5. Blade deflection shall not exceed L/120 of span length.
 6. Submit test reports verifying compliance with each test requirement required by the project.

EDITOR NOTE: PLEASE REFER TO THE ARCHITECTURAL DETAIL MANUAL FOR STRUCTURAL CHARTS, AND BLADE STYLES.

- B. Shading Performance:
1. Design shall allow for one time adjustment of the aerofoil blade angle and size to optimize the shading performance based on project location, latitude, altitude, building orientation, surrounding conditions, and aesthetic requirements.
 - a. Blades shall be capable of orientations of:
 - 1) Horizontal sunshade configurations: Clockwise is positive and anti-clockwise negative 0°, -5°, -10°, -15°, -20°, -25°, -30°, and -35°.
 - 2) Vertical Sunshade configurations: Clockwise is positive and anti-clockwise negative -35°, -30°, -25°, -20°, -15°, -10°, -5°, 0°, 5°, 10°, 15°, 20°, 25°, 30°, 35°.
 - b. Following blade sizes are available [Width in inches (in mm)]: 6"(152), 8"(203), 10"(254), 12"(305), 14"(356).
- C. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 120 deg F (49 deg C), ambient; 180 deg F (82 deg C), material surfaces.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For aluminum exterior sunshades. Include plans, elevations, sections, blade angles, blade spacing and attachments to compatible systems.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. LEED Submittals:
1. Materials and Resources: Provide product information and certification letter indicating percentages by weight of post consumer and pre consumer recycled content for products having recycled content.
 2. Optimize Energy Performance: Provide information confirming that products contribute to increasing levels of energy performance above the baseline in the prerequisite standard to reduce environmental and economic impacts associated with excessive energy use.
 3. Daylighting 75 Percent of Spaces: Provide information confirming that products provide the building occupants a connection between indoor spaces and the outdoors through the introduction of daylight and views into the regularly occupied areas of the building.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating exterior sunshades, and glazed aluminum curtain wall and storefront systems, that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum exterior sunshades and glazed aluminum curtain walls and storefront systems through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of sunshade elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for sunshades by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR'S NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Versoleil™ Single Blade Horizontal Sunshade, Versoleil™ Single Blade Vertical Sunshade by Kawneer Company Inc.

EDITOR'S NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sunshade installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sunshade performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls, storefront systems, and sunshades for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall and storefront system manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6, 6105-T5, or 6061-T6 alloy and temper.
- B. Thermal Barrier: When applied on a thermally broken compatible system, sunshade shall be thermally isolated from the interior aluminum mullions by a nominal 0.25" (6.3 mm) thick low conductance material.
- C. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- D. Sealant: For sealants required within fabricated sunshade system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- E. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall and storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Sunshades

- A. Sunshade Members: Manufacturer's standard extruded or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle sunshade materials and components to avoid damage. Protect sunshade materials against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762-mm) thickness per coat.

2.5 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are straight, and free of defects or deformations.
 2. Accurately fitted joints with ends coped or mitered.
 3. Physical and thermal isolation of glazing from framing members.
 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- C. Sunshade: Fabricate components for assembly following approved shop drawings and/or manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to approved shop drawings.

2.6 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
 1. Comply with manufacturer's written instructions. Refer to installation instructions of the compatible curtain wall or storefront system.
 2. Please note that the installation instructions can differ from one compatible system to another one.
 3. Do not install damaged components.
 4. Fit joints to produce hairline joints free of burrs and distortion.
 5. Rigidly secure non-movement joints.
 6. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 7. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 8. Seal joints watertight where shown on approved shop drawings and/or manufacturer's standard installation instructions.
- B. Metal Protection:
 1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.

2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components plumb and true in alignment with established lines and grades.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- E. Install glazing as specified in Division 08 Section "Glazing."

3.3 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum sunshade system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

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END OF SECTION 107113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 107113 EXTERIOR SUN CONTROL DEVICES

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Aluminum Sunshade Systems, including accessories, mountings, and shims. Sunshades are anchored directly to the vertical curtain wall or storefront mullions.
 - 1. Compatible Systems:
 - a. 1600 Wall System™1 Curtain Wall
 - b. 1600 Wall System™2 Curtain Wall
 - c. 1600UT System™1 Curtain Wall
 - d. 1600UT System™2 Curtain Wall
 - e. 1600 Wall System™5 Curtain Wall
 - f. 1600 SS Curtain Wall System
 - g. 1600 SS (SSG) Curtain Wall System
 - h. 1630 SS IR Curtain Wall System
 - i. Trifab™ VersaGlaze™ 451/451T/451UT (Center Glaze) Framing System
 - j. Trifab™ 601/601T/601UT Framing System

EDITOR NOTE: TO VIEW THE CORRELATING GUIDE SPECIFICATION FOR COMPATIBLE CURTAIN WALL AND STOREFRONT SYSTEMS PLEASE VISIT KAWNEER.COM

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 - 1. 072700 "Air Barriers"
 - 2. 079200 "Joint Sealants"
 - 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 - 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 - 5. 084313 "Aluminum-Framed Storefronts"
 - 6. 084329 "Sliding Storefronts"
 - 7. 084413 "Glazed Aluminum Curtain Walls"
 - 8. 084433 "Sloped Glazing Assemblies"
 - 9. 085113 "Aluminum Windows"
 - 10. 086300 "Metal-Framed Skylights"
 - 11. 088000 "Glazing"
 - 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: PROVIDE WIND LOAD, SNOW LOAD, & ICE LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- A. Structural Performance:
 - 1. Combined load on sunshade configurations to be determined in accordance with ASCE 7 or applicable code requirements. Combined load consists of wind, snow and ice loads.
 - 2. Design sunshade configurations to withstand stresses due to combined load. Stresses resulting from thermal expansion/contraction, shall not cause permanent deformation of sunshade assemblies or disengagement from the glazed system.
 - a. 1600 Wall System™1 Curtain Wall:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing

- 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- b. 1600 Wall System™2 Curtain Wall:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- c. 1600UT (Ultra Thermal) System™1 Curtain Wall (1" Double Glazed Infill):
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- d. 1600UT (Ultra Thermal) System™1 Curtain Wall (1-3/4" Triple Glazed Infill):
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- e. 1600 Wall System™5 Curtain Wall:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- f. 1600 SS Curtain Wall System:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- g. 1600 SS (SSG) Curtain Wall System:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- h. 1630 SS IR Curtain Wall System:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- i. Trifab™ VersaGlaze™ 451/451T/451UT (Center Glazed) Framing System:
 - 1) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- j. Trifab™ 601/601T/601UT Framing System:
 - 1) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing

EDITOR NOTE: PLEASE REFER TO THE ARCHITECTURAL DETAIL MANUAL FOR STRUCTURAL CHARTS, AND BLADE STYLES.

- 3. The assembled sunshade shall be capable of supporting the specified combined load without damage, permanent deformation, or disengagement from the glazed system mullion.
 - 4. Blade deflection shall not exceed L/120 of span length.
 - 5. Submit test reports verifying compliance with each test requirement required by the project.
- B. Shading Performance:**
- 1. Design of standard configurations will allow for negligible direct sunlight to show through the blades based on project location, latitude, altitude, building orientation, surrounding conditions, and aesthetic requirements, except for round, diamond and square louver styles.
- C. Thermal Movements:** Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
- 1. Temperature Change (Range): 120 deg F (49 deg C), ambient; 180 deg F (82 deg C), material surfaces.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For aluminum exterior sunshades. Include plans, elevations, sections, blade angles, blade spacing and attachments to compatible systems.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. LEED Submittals:
 - 1. Materials and Resources: Provide product information and certification letter indicating percentages by weight of post consumer and pre consumer recycled content for products having recycled content.
 - 2. Optimize Energy Performance: Provide information confirming that products contribute to increasing levels of energy performance above the baseline in the prerequisite standard to reduce environmental and economic impacts associated with excessive energy use.
 - 3. Daylighting 75 Percent of Spaces: Provide information confirming that products provide the building occupants a connection between indoor spaces and the outdoors through the introduction of daylight and views into the regularly occupied areas of the building.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating exterior sunshades, and glazed aluminum curtain walls and storefront systems that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum exterior sunshades and glazed aluminum curtain walls and storefront system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of sunshade elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for sunshades by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR'S NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Versoleil™ Sunshade Outrigger System by Kawneer Company Inc.

EDITOR'S NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sunshade installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sunshade performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls, storefront systems, and sunshades for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

Law and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall and storefront system manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6, 6105-T5, or 6061-T6 alloy and temper.
- B. Thermal Barrier: When applied on a thermally broken captured system, sunshade shall be thermally isolated from the interior aluminum mullions by a nominal 0.25" (6.3 mm) thick low conductance material.
- C. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- D. Sealant: For sealants required within fabricated sunshade system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- E. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall and storefront members members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Sunshades

- A. Sunshade Members: Manufacturer's standard extruded or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
- B. Fasteners and accessories: Nonmagnetic stainless steel to be non-corrosive and compatible with aluminum members, anchors, and other components.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle sunshade materials and components to avoid damage. Protect sunshade materials against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.5 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are straight, and free of defects or deformations.
 - 2. Accurately fitted joints with ends coped or mitered.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- C. Sunshade: Fabricate components for assembly following approved shop drawings and/or manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to approved shop drawings.

2.6 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
 - 1. Comply with manufacturer's written instructions. Refer to installation instructions of the compatible curtain wall or storefront system.
 - 2. Please note that the installation instructions can differ from one compatible system to another one.
 - 3. Do not install damaged components.
 - 4. Fit joints to produce hairline joints free of burrs and distortion.
 - 5. Rigidly secure non-movement joints.
 - 6. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 - 7. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 - 8. Seal joints watertight where shown on approved shop drawings and/or manufacturer's standard installation instructions.
- B. Metal Protection:
 - 1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 - 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components plumb and true in alignment with established lines and grades.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- E. Install glazing as specified in Division 08 Section "Glazing".

3.3 Adlusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum sunshade system from damage from grinding and polishing compounds, plaster, lime, cement, acid and/or acid wash, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

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PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Aluminum Sunshade Systems, including accessories, mountings, and shims. Sunshades are anchored directly to the vertical and/or horizontal mullions.
 - 1. Types of Kawneer Sunshades include:
 - a. Versoleil™ Horizontal Single Blade SunShade compatible with:
 - 1) 1600 Wall System™1 Curtain Wall
 - 2) 1600UT System™1 Curtain Wall
 - 3) 1600 Wall System™2 Curtain Wall
 - 4) 1600 Wall System™5 Curtain Wall
 - 5) 1600 SS™Curtain Wall System
 - 6) 1600 SS™ (SSG) Curtain Wall System
 - 7) IR 501T/IR 501UT Storefront Framing Systems
 - 8) Trifab™ VG (Center Glaze) 451/451T/451UT
 - 9) Trifab™ (Center Glaze) 601/601T/601UT
 - b. Versoleil™ Vertical Single Blade SunShade compatible with:
 - 1) 1600 Wall System™1Curtain Wall
 - 2) 1600UT System™1 Curtain Wall
 - 3) 1600 Wall System™5 Curtain Wall
 - 4) 1600 SS™ Curtain Wall System

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B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 085113 "Aluminum Windows"
- 10. 086300 "Metal-Framed Skylights"
- 11. 088000 "Glazing"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

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- A. Structural Performance:
1. Combined load on sunshade configurations to be determined in accordance with ASCE 7 or applicable code requirements. Combined load consists of wind, snow and ice loads
 2. Design sunshade configurations to withstand stresses due to combined load. Stresses resulting from thermal expansion/contraction, shall not cause permanent deformation of sunshade assemblies or disengagement from the glazed system.
 3. Test horizontal and vertical sunshade configurations to meet a minimum load of 65 psf with a factor of safety of 2 times the design load for the horizontal blade and a factor of safety of 1.5 times the design load for the vertical blade.
 4. The assembled sunshade shall be capable of supporting a uniformly distributed load of ___ psf without damage, permanent deformation, or disengagement from the glazed system mullion.
 5. Blade deflection shall not exceed L/120 of span length.
 6. Submit test reports verifying compliance with each test requirement required by the project.

EDITOR NOTE: PLEASE REFER TO THE ARCHITECTURAL DETAIL MANUAL FOR STRUCTURAL CHARTS, AND BLADE STYLES.

- B. Shading Performance:
1. Design shall allow for one time adjustment of the aerofoil blade angle and size to optimize the shading performance based on project location, latitude, altitude, building orientation, surrounding conditions, and aesthetic requirements.
 - a. Blades shall be capable of orientations of:
 - 1) Horizontal sunshade configurations: Clockwise is positive and anti-clockwise negative 0°, -5°, -10°, -15°, -20°, -25°, -30°, and -35°.
 - 2) Vertical Sunshade configurations: Clockwise is positive and anti-clockwise negative -35°, -30°, -25°, -20°, -15°, -10°, -5°, 0°, 5°, 10°, 15°, 20°, 25°, 30°, 35°.
 - b. Following blade sizes are available [Width in inches (in mm)]: 6"(152), 8"(203), 10"(254), 12"(305), 14"(356).
- C. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 120 deg F (49 deg C), ambient; 180 deg F (82 deg C), material surfaces.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For aluminum exterior sunshades. Include plans, elevations, sections, blade angles, blade spacing and attachments to compatible systems.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. LEED Submittals:
1. Materials and Resources: Provide product information and certification letter indicating percentages by weight of post consumer and pre consumer recycled content for products having recycled content.
 2. Optimize Energy Performance: Provide information confirming that products contribute to increasing levels of energy performance above the baseline in the prerequisite standard to reduce environmental and economic impacts associated with excessive energy use.
 3. Daylighting 75 Percent of Spaces: Provide information confirming that products provide the building occupants a connection between indoor spaces and the outdoors through the introduction of daylight and views into the regularly occupied areas of the building.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating exterior sunshades, and glazed aluminum curtain wall and storefront systems, that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum exterior sunshades and glazed aluminum curtain walls and storefront systems through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of sunshade elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for sunshades by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR'S NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Versoleil™ Single Blade Horizontal Sunshade, Versoleil™ Single Blade Vertical Sunshade by Kawneer Company Inc.

EDITOR'S NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sunshade installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sunshade performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls, storefront systems, and sunshades for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall and storefront system manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6, 6105-T5, or 6061-T6 alloy and temper.
- B. Thermal Barrier: When applied on a thermally broken compatible system, sunshade shall be thermally isolated from the interior aluminum mullions by a nominal 0.25" (6.3 mm) thick low conductance material.
- C. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- D. Sealant: For sealants required within fabricated sunshade system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- E. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall and storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Sunshades

- A. Sunshade Members: Manufacturer's standard extruded or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle sunshade materials and components to avoid damage. Protect sunshade materials against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762-mm) thickness per coat.

2.5 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are straight, and free of defects or deformations.
 2. Accurately fitted joints with ends coped or mitered.
 3. Physical and thermal isolation of glazing from framing members.
 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- C. Sunshade: Fabricate components for assembly following approved shop drawings and/or manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to approved shop drawings.

2.6 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
 1. Comply with manufacturer's written instructions. Refer to installation instructions of the compatible curtain wall or storefront system.
 2. Please note that the installation instructions can differ from one compatible system to another one.
 3. Do not install damaged components.
 4. Fit joints to produce hairline joints free of burrs and distortion.
 5. Rigidly secure non-movement joints.
 6. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 7. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 8. Seal joints watertight where shown on approved shop drawings and/or manufacturer's standard installation instructions.
- B. Metal Protection:
 1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.

2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components plumb and true in alignment with established lines and grades.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- E. Install glazing as specified in Division 08 Section "Glazing."

3.3 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum sunshade system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 107113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 107113 EXTERIOR SUN CONTROL DEVICES

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Aluminum Sunshade Systems, including accessories, mountings, and shims. Sunshades are anchored directly to the vertical curtain wall or storefront mullions.
 - 1. Compatible Systems:
 - a. 1600 Wall System™1 Curtain Wall
 - b. 1600 Wall System™2 Curtain Wall
 - c. 1600UT System™1 Curtain Wall
 - d. 1600UT System™2 Curtain Wall
 - e. 1600 Wall System™5 Curtain Wall
 - f. 1600 SS Curtain Wall System
 - g. 1600 SS (SSG) Curtain Wall System
 - h. 1630 SS IR Curtain Wall System
 - i. Trifab™ VersaGlaze™ 451/451T/451UT (Center Glaze) Framing System
 - j. Trifab™ 601/601T/601UT Framing System

EDITOR NOTE: TO VIEW THE CORRELATING GUIDE SPECIFICATION FOR COMPATIBLE CURTAIN WALL AND STOREFRONT SYSTEMS PLEASE VISIT KAWNEER.COM

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

- 1. 072700 "Air Barriers"
- 2. 079200 "Joint Sealants"
- 3. 083213 "Sliding Aluminum-Framed Glass Doors"
- 4. 084113 "Aluminum-Framed Entrances and Storefronts"
- 5. 084313 "Aluminum-Framed Storefronts"
- 6. 084329 "Sliding Storefronts"
- 7. 084413 "Glazed Aluminum Curtain Walls"
- 8. 084433 "Sloped Glazing Assemblies"
- 9. 085113 "Aluminum Windows"
- 10. 086300 "Metal-Framed Skylights"
- 11. 088000 "Glazing"
- 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: PROVIDE WIND LOAD, SNOW LOAD, & ICE LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

A. Structural Performance:

- 1. Combined load on sunshade configurations to be determined in accordance with ASCE 7 or applicable code requirements. Combined load consists of wind, snow and ice loads.
- 2. Design sunshade configurations to withstand stresses due to combined load. Stresses resulting from thermal expansion/contraction, shall not cause permanent deformation of sunshade assemblies or disengagement from the glazed system.
 - a. 1600 Wall System™1 Curtain Wall:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing

- 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- b. 1600 Wall System™2 Curtain Wall:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- c. 1600UT (Ultra Thermal) System™1 Curtain Wall (1" Double Glazed Infill):
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- d. 1600UT (Ultra Thermal) System™1 Curtain Wall (1-3/4" Triple Glazed Infill):
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- e. 1600 Wall System™5 Curtain Wall:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- f. 1600 SS Curtain Wall System:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- g. 1600 SS (SSG) Curtain Wall System:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- h. 1630 SS IR Curtain Wall System:
 - 1) 36" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
 - 2) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- i. Trifab™ VersaGlaze™ 451/451T/451UT (Center Glazed) Framing System:
 - 1) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing
- j. Trifab™ 601/601T/601UT Framing System:
 - 1) 30" Outrigger: To meet ___ psf with _____ style louver and ___ feet mullion spacing

EDITOR NOTE: PLEASE REFER TO THE ARCHITECTURAL DETAIL MANUAL FOR STRUCTURAL CHARTS, AND BLADE STYLES.

- 3. The assembled sunshade shall be capable of supporting the specified combined load without damage, permanent deformation, or disengagement from the glazed system mullion.
 - 4. Blade deflection shall not exceed L/120 of span length.
 - 5. Submit test reports verifying compliance with each test requirement required by the project.
- B. Shading Performance:**
- 1. Design of standard configurations will allow for negligible direct sunlight to show through the blades based on project location, latitude, altitude, building orientation, surrounding conditions, and aesthetic requirements, except for round, diamond and square louver styles.
- C. Thermal Movements:** Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
- 1. Temperature Change (Range): 120 deg F (49 deg C), ambient; 180 deg F (82 deg C), material surfaces.

1.5 Submittals

- A. **Product Data:** For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. **Shop Drawings:** For aluminum exterior sunshades. Include plans, elevations, sections, blade angles, blade spacing and attachments to compatible systems.
- C. **Samples for Initial Selection:** For units with factory-applied color finishes.
- D. **Samples for Verification:** For each type of exposed finish required, in manufacturer's standard sizes.
- E. **LEED Submittals:**
 - 1. **Materials and Resources:** Provide product information and certification letter indicating percentages by weight of post consumer and pre consumer recycled content for products having recycled content.
 - 2. **Optimize Energy Performance:** Provide information confirming that products contribute to increasing levels of energy performance above the baseline in the prerequisite standard to reduce environmental and economic impacts associated with excessive energy use.
 - 3. **Daylighting 75 Percent of Spaces:** Provide information confirming that products provide the building occupants a connection between indoor spaces and the outdoors through the introduction of daylight and views into the regularly occupied areas of the building.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating exterior sunshades, and glazed aluminum curtain walls and storefront systems that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum exterior sunshades and glazed aluminum curtain walls and storefront system through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 - 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockups for type(s) of sunshade elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for sunshades by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR'S NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Versoleil™ Sunshade Outrigger System by Kawneer Company Inc.

EDITOR'S NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sunshade installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sunshade performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls, storefront systems, and sunshades for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall and storefront system manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6, 6105-T5, or 6061-T6 alloy and temper.
- B. Thermal Barrier: When applied on a thermally broken captured system, sunshade shall be thermally isolated from the interior aluminum mullions by a nominal 0.25" (6.3 mm) thick low conductance material.
- C. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- D. Sealant: For sealants required within fabricated sunshade system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- E. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall and storefront members members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Sunshades

- A. Sunshade Members: Manufacturer's standard extruded or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
- B. Fasteners and accessories: Nonmagnetic stainless steel to be non-corrosive and compatible with aluminum members, anchors, and other components.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle sunshade materials and components to avoid damage. Protect sunshade materials against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.5 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 1. Profiles that are straight, and free of defects or deformations.
 2. Accurately fitted joints with ends coped or mitered.
 3. Physical and thermal isolation of glazing from framing members.
 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- C. Sunshade: Fabricate components for assembly following approved shop drawings and/or manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to approved shop drawings.

2.6 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
 - 1. Comply with manufacturer's written instructions. Refer to installation instructions of the compatible curtain wall or storefront system.
 - 2. Please note that the installation instructions can differ from one compatible system to another one.
 - 3. Do not install damaged components.
 - 4. Fit joints to produce hairline joints free of burrs and distortion.
 - 5. Rigidly secure non-movement joints.
 - 6. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 - 7. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 - 8. Seal joints watertight where shown on approved shop drawings and/or manufacturer's standard installation instructions.
- B. Metal Protection:
 - 1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 - 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components plumb and true in alignment with established lines and grades.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- E. Install glazing as specified in Division 08 Section "Glazing".

3.3 Adlusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum sunshade system from damage from grinding and polishing compounds, plaster, lime, cement, acid and/or acid wash, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 107113

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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SECTION 122600 INTERIOR DAYLIGHTING DEVICES

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer InLighten™ Aluminum Lightshelf System, including accessories, mountings, and panels. Lightshelves are anchored directly to the vertical curtain wall or storefront mullions and is an interior product.
 1. Compatible Systems:
 - a. Curtain wall system mounting mullion with face width of 2" (51 mm) or greater and wall thickness greater than 0.080" (2 mm).
 - b. Center or Front Set Storefront system with single piece tubular mounting mullion, with face width of 2" (51 mm) or greater and mounting mullion wall thickness greater than 0.080" (2 mm)

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 085113 "Aluminum Windows"
 10. 086300 "Metal-Framed Skylights"
 11. 088000 "Glazing"
 12. 107113 "Exterior Sun Control Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions, refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: LIGHTSHELF IS DESIGNED TO HOLD ITS OWN WEIGHT ONLY.

- A. Structural Performance:
 1. Dead load on Lightshelf is designed to hold its own weight only.

EDITOR NOTE: LIGHTSHELF IS A SELF-SUPPORTING STRUCTURE THAT REFLECTS DAYLIGHT AND SHOULD NOT BE USED FOR ANY OTHER PURPOSE, SPECIALLY AS A SHELF FOR HOLDING OTHER OBJECTS WHICH CAN NOT ONLY IMPACT PERFORMANCE BUT ALSO RESULT IN INJURY DUE TO STRUCTURAL FAILURE.

2. Panel deflection shall not exceed L/120 of span length.
 3. Mullion spacing not to exceed 6' (1.83 m).
 4. Panel projection not to exceed 30" (762 mm).
- B. Daylighting Performance:
 1. Design will allow for tiltability of the panel in the anchor to allow for cleaning of the reflecting surface.
 2. Design of standard configurations will allow for minimal direct sunlight to show through the gaps between two adjacent shelves based on project location, latitude, altitude, building orientation, surrounding conditions, and aesthetic requirements.
 3. Design shall allow for flexibility of either using opaque aluminum composite panels or translucent polycarbonate panels as panel material.
 4. Design will allow for coverage around 90° corner conditions by providing for attachment method on specified corner conditions.

- C. Thermal Movements: Allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures:
1. Temperature Change (Range): 120°F (49°C), ambient; 180°F (82°C), material surfaces.

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For aluminum lightshelves. Include plans, elevations, sections, and attachments to compatible systems.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. LEED Submittals:
1. Materials and Resources: Provide product information and certification letter indicating percentages by weight of post-consumer and pre-consumer recycled content for products having recycled content.
 2. Optimize Energy Performance: Provide information confirming that products contribute to increasing levels of energy performance above the baseline in the prerequisite standard to reduce environmental and economic impacts associated with excessive energy use.
 3. Daylighting 75 Percent of Spaces: Provide information confirming that products provide the building occupants a connection between indoor spaces and the outdoors through the introduction of daylight and views into the regularly occupied areas of the building.

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating lightshelves, and glazed aluminum curtain walls and storefront systems that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum lightshelves and glazed aluminum curtain walls and storefront systems through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
1. Build mockups for type(s) of lightshelf elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for lightshelves by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
1. Warranty Period: Two (2) years from Date of Substantial Completion of the project, provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR'S NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
1. InLighten™ Light Shelf System by Kawneer Company Inc.

EDITOR'S NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING TEN (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid lighshelf installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
Certificates: Submit certificate(s) attesting that the substitute manufacturer (1) adheres to specification requirements for lightshelf performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls, storefront systems, sunshades, and lightshelves for a period of not less than ten (10) years. (Company Name)
 - 4. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 5. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall and storefront system manufacturer for strength, corrosion resistance, and application of required finish, and complying with ASTM B 221: 6063-T6, 6105-T5, or 6061-T6 alloy and temper. Wall thickness at any location for the main frame to be not less than 0.070" (1.78 mm).
- B. Aluminum Composite Material (ACM): Panels shall be Reynobond® Aluminum Composite Material (ACM) as manufactured by Alcoa Architectural Products.
- C. Polycarbonate Panel: Monolithic or multilayered extruded cellular polycarbonate panels.
- D. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall and storefront system members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Lightshelves

- A. Lightshelf Members: Manufacturer's standard extruded or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
- B. Panel Materials: Aluminum composite or polycarbonate materials.
- C. Fasteners and Accessories: Nonmagnetic stainless steel to be non-corrosive and compatible with aluminum members, anchors, and other components.
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- E. Packing, Shipping, Handling, and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- F. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle lightshelf materials and components to avoid damage. Protect lightshelf materials against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.5 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are straight, and free of defects or deformations.
 - 2. Accurately fitted joints with ends coped or mitered.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- C. Lightshelf: Fabricate components for assembly following approved shop drawings and/or manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to approved shop drawings.

2.6 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadiize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General:
 - 1. Comply with manufacturer's written instructions. Refer to installation instructions of the compatible curtain wall or storefront system.
 - 2. Please note that the installation instructions can differ from one compatible system to another one.
 - 3. Do not install damaged components.
 - 4. Fit joints to produce hairline joints free of burrs and distortion.
 - 5. Rigidly secure non-movement joints.
 - 6. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 - 7. Weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 - 8. Seal joints watertight where shown on approved shop drawings and/or manufacturer's standard installation instructions.
- B. Metal Protection:
 - 1. Where aluminum will contact dissimilar metals, protect against galvanic action by painting contact surfaces with primer or by applying sealant or tape or installing nonconductive spacers as recommended by manufacturer for this purpose.
 - 2. Where aluminum will contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components plumb and true in alignment with established lines and grades.
- D. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.
- E. Install glazing as specified in Division 08 Section "Glazing".

3.3 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum lightshelf system from damage from grinding and polishing compounds, plaster, lime, cement, acid and/or acid wash, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm and the particular requirements of a specific construction project.

END OF SECTION 122600

SECTION 084433 SLOPED GLAZING ASSEMBLIES

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section includes: Kawneer Aluminum Sloped Glazing Systems, including perimeter trims, accessories, shims and anchors, and perimeter sealing of sloped glazed framing.
 1. Types of Kawneer Aluminum Sloped Glazing include:
 - a. 1600 Sloped Glazing – 2-1/2" x 4-3/4" (63.5 x 120.7) or 2-1/2" x 6" (63.5 x 152.4), outside glazed pressure plate system.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
 1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 085113 "Aluminum Windows"
 9. 086300 "Metal-Framed Skylights"
 10. 088000 "Glazing"
 11. 107113 "Exterior Sun Control Devices"
 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum sloped glazing representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
 1. Glazed aluminum sloped glazing shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum sloped glazing, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION

- C. Wind loads: Provide Sloped Glazing system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

EDITOR NOTE: PROVIDE WIND LOAD, SNOW LOAD, & ICE LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- D. Snow loads: Provide Sloped Glazing system; include anchorage, capable of withstanding snow load design pressures of (____) lbs./sq. ft.. The design pressures are based on the (____) Building Code; (____) Edition.
- E. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (.0003 m³/s·m²) at a static air pressure differential of 6.24 PSF (300 Pa).
- F. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 PSF (575 Pa) as defined in AAMA 501.
- G. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 PSF (575 Pa) as defined in AAMA 501.
- H. Uniform Load: A static air design load of 40 PSF (1916 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- I. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.46 (clear) or Project Specific (____) BTU/hr/ft² /°F. per AAMA 507 or (____) BTU/hr/ft² /°F. per NFRC 100.
- J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 68_{frame} and 66_{glass} (clear),

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum sloped glazing. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum sloped glazing, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed sloped glazing systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating exterior sunshades, glazed aluminum sloped glazing, curtain wall and storefront systems, that meet or exceed performance requirements.
- C. Source Limitations: Obtain aluminum exterior sunshades, sloped glazing, glazed aluminum curtain walls and storefront systems through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of sunshade elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for sunshades by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 1600 Sloped Glazing.
 - 3. System depth: 2-1/2" x 4-3/4" (63.5 x 120.7) or 2-1/2" x 6" (63.5 x 152.4), outside glazed pressure plate system.
 - 4. Tested to AAMA 501.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid sloped glazing installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for sloped glazing system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum sloped glazing for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum sloped glazing manufacturer for strength, corrosion resistance, and application of required finish and each framing member shall provide structural strength to meet specified performance requirements and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated sloped glazing system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible PVC (Poly Vinyl Chloride).

- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed sloped glazing members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Sloped Glazing Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4 " (6.3) or 1" (25.4) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum sloped glazing as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle sloped glazing material and components to avoid damage. Protect sloped glazing material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 1600 Sloped Glazing: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum sloped glazing to exterior.
- C. Sloped Glazing Framing: Fabricate components for assembly following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install sloped glazing systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select sloped glazing units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum sloped glazing system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084433

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

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SECTION 086300 METAL-FRAMED SKYLIGHTS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Skylight System, including perimeter trims, accessories, shims and anchors, and perimeter sealing of skylight framing.
1. Types of Kawneer Aluminum Skylights include:
 - a. 2000 Skylight – 2.5" x 5.59" (63.5 x 142.0), 2.5" x 7.09" (63.5 x 180.0) and 2.5" x 8.34" (63.5 x 211.8) nominal dimensions; outside glazed pressure plate system.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE. HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

- B. Related Sections:
1. 072700 "Air Barriers"
 2. 079200 "Joint Sealants"
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 085113 "Aluminum Windows"
 10. 088000 "Glazing"
 11. 107113 "Exterior Sun Control Devices"
 12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

- A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.
1. Glazed aluminum skylights shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Loosening or weakening of fasteners, attachments, and other components.
 - d. Failure of operating units.
- B. Delegated Design: Design glazed aluminum skylights, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- C. Wind loads: Provide Skylight system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. inward and (____) lbs./sq. ft. outward. The design pressures are based on the (____) Building Code; (____) Edition.

EDITOR NOTE: PROVIDE WIND LOAD, SNOW LOAD, & ICE LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

- D. Snow loads: Provide Sloped Glazing system; include anchorage, capable of withstanding snow load design pressures of (____) lbs./sq. ft.. The design pressures are based on the (____) Building Code; (____) Edition.
- E. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft² (.0003 m³/s·m²) at a static air pressure differential of 6.24 PSF (300 Pa) or CAN/CSA-A440 fixed rating.
- F. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 547. There shall be no leakage at static air pressure differentials of 15 PSF (718 Pa) minimum or CAN/CSA-A440 B7 rating.
- G. Uniform Load: A static air design load of 40 PSF (1916 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur or CAN/CSA-A440 C5 rating.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- H. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, the thermal transmittance (U-factor) shall not be more than: 0.43 (clear) or Project Specific (____) BTU/hr/ft² /°F. per AAMA 507 or (____) BTU/hr/ft² /°F. per NFRC 100.
- I. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than 67_{frame} and 65_{glass} (clear).

1.5 Submittals

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. Shop Drawings: For glazed aluminum skylights. Include plans, elevations, sections, full-size details, and attachments to other work.
- C. Samples for Initial Selection: For units with factory-applied color finishes.
- D. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.
- F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed skylight systems, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery
 2. Glazing

1.6 Quality Assurance

- A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating exterior sunshades, and glazed aluminum curtain wall and storefront systems, that meet or exceed performance requirements.
- C. Source Limitations: Obtain glazed aluminum skylights, curtain wall systems and storefront systems through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockups for type(s) of sunshade elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual locations of structural supports for sunshades by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION; ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE. DO NOT USE THE PHRASE "OR EQUAL" / "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.1 Manufacturers

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. 2000 Skylight
 - 3. System depth: 2.5" x 5.59" (63.5 x 142.0), 2.5" x 7.09" (63.5 x 180.0) and 2.5" x 8.34" (63.5 x 211.8); outside glazed pressure plate system.

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS (IF ANY), AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer: (_____)
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid curtain wall installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for curtain wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum curtain walls for a period of not less than ten (10) years. (Company Name).
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum skylight manufacturer for strength, corrosion resistance, and application of required finish and each framing member shall provide structural strength to meet specified performance requirements and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.
- F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- G. Sealant: For sealants required within fabricated skylight system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible PVC (Poly Vinyl Chloride).
- I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed skylight members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Sloped Glazing Framing

- A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 - 1. Glazing System: 4 sided captured.
 - 2. Glazing Plane: Front.
- B. Glass: 1" (25.4) insulating glass option. 1/4 " (6.3) or 1" (25.4) for Spandrel applications.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Framing Sealants: Shall be suitable for glazed aluminum skylight as recommended by sealant manufacturer.
- E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- G. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle skylight material and components to avoid damage. Protect skylight material against damage from elements, construction activities, and other hazards before, during and after installation.

2.4 Glazing

- A. Glazing: Comply with Division 08 Section "Glazing". Following glazing options are available.
 - 1. 2000 Skylight Glazing: Outside glazed pressure plate format with 1" (25.4) double glazed insulating glass.
- B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: As recommended by manufacturer for joint type.

2.5 Operable Units

- A. Doors: Comply with Division 08 Section "Aluminum-Framed Entrances and Storefronts".
- B. Windows: Comply with Division 08 Section "Aluminum Windows".

2.6 Accessory Materials

- A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.
- B. Gaskets: Interior glazing gaskets shall comply with ASTM C864 and be extruded of a silicone compatible EPDM rubber. Exterior glazing gaskets to be Tremco Visionstrip®.

2.7 Fabrication

- A. Form or extrude aluminum shapes before finishing.
- B. Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fitted joints.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
 - 5. Provisions for field replacement of glazing from exterior.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum skylight to exterior.
- C. 2000 Skylight Framing: Fabricate components for assembly following manufacturer's standard installation instructions.
- D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Factory Finishing:
 - 1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 - 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 - 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 - 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 - 5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 - 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____).
 - 7. Other: Manufacturer _____ Type _____ (Color _____).

PART 3 - EXECUTION

3.1 Examination

- A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

- A. General: Install skylight systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
 - 1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
 - 2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" (228.6) on center.
 - 3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.
- B. Related Products Installation Requirements:
 - 1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
 - 2. Glass: Refer to Glass and Glazing Section.
 - a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

3.3 Field Quality Control

- A. Field Tests: Architect shall select skylight units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.
 - 1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
 - a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², which ever is greater.
 - b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).
- B. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning and Protection

- A. Protection: Protect installed product's finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.
- B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer's instructions prior to owner's acceptance. Remove construction debris from project site and legally dispose of debris.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 086300

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.

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SECTION 081216 ALUMINUM FRAMES

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice", including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI nor AIA endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract", published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

- A. Section Includes: Kawneer Architectural Aluminum Storefront Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of storefront units.
 1. Types of Kawneer Aluminum Storefront Systems include:
 - a. InFrame™ Interior Framing System - 2" x 6" (50.8 x 152.4) nominal dimension; Non-Thermal; Center Glazed, Screw Spline, Punched Opening Fabrication.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

B. Related Sections:

1. 072700 "Air Barriers"
2. 079200 "Joint Sealants"
3. 083213 "Sliding Aluminum-Framed Glass Doors"
4. 084113 "Aluminum-Framed Entrances and Storefronts"
5. 084329 "Sliding Storefronts"
6. 084413 "Glazed Aluminum Curtain Walls"
7. 084433 "Sloped Glazing Assemblies"
8. 085113 "Aluminum Windows"
9. 086300 "Metal-Framed Skylights"
10. 088000 "Glazing"
11. 107113 "Exterior Sun Control Devices"
12. 122600 "Interior Daylighting Devices"

1.3 Definitions

- A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG)

1.4 Performance Requirements

- A. Storefront System Performance Requirements: Interior framing system.

1.5 Submittals

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, hardware, finishes, and installation instructions for each type of aluminum frames indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, and attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum frames and components required.
- E. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum frames, made from 12" (304.8 mm) lengths of full-size components and showing details of the following:
 1. Joinery, including concealed welds.
 2. Anchorage.
 3. Expansion provisions.
 4. Glazing.
 5. Flashing and drainage.

F. Other Action Submittals:

1. Entrance Door Hardware Schedule: Prepared by or under the supervision of supplier, detailing fabrication and assembly of entrance door hardware, as well as procedures and diagrams. Coordinate final entrance door hardware schedule with doors, frames, and related work to ensure proper size, thickness, hand, function, and finish of entrance door hardware.

1.6 Quality Assurance

- A. Installer Qualifications: An installer which has had successful experience with installation of the same or similar units required for the project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of providing aluminum frames that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum frames through one source from a single manufacturer.
- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum frames and are based on the specific system indicated. Refer to Division 01 Section "Product Requirements". Do not modify size and dimensional requirements.
 1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 1. Build mockup for type(s) of storefront elevation(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination".

1.7 Project Conditions

- A. Field Measurements: Verify actual dimensions of aluminum frame openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 Warranty

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
- B. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS**2.1 Manufacturers**

- A. Basis-of-design Product:
 1. Kawneer Company Inc.
 2. InFrame™ Interior Framing System (Non-Thermal)
 3. System Dimensions: 2" x 6" (50.8 x 152.4) nominal dimension
 4. Glass: Center Plane

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 1. Manufacturer: (_____)
 2. Series: (_____)
 3. Profile dimension: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid storefront installation and construction delays.
 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for storefront system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum storefront for a period of not less than ten (10) years. (Company Name)
 5. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

2.2 Materials

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum storefront manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8 mm) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum framing members, trim hardware, anchors, and other components.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
- E. Sealant: For sealants required within fabricated storefront system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.
- F. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of storefront members are nominal and in compliance with AA Aluminum Standards and Data.

2.3 Storefront Framing System

- A. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- B. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.
- C. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.
- D. Packing, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.
- E. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle storefront material and components to avoid damage. Protect storefront material against damage from elements, construction activities, and other hazards before, during and after storefront installation.

2.4 Glazing Systems

- A. Glazing: As specified in Division 08 Section "Glazing".
- B. Glazing Gaskets: Manufacturer's standard compression types; replaceable, extruded EPDM rubber.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.
- D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.
- E. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type, and as follows:
 - 1. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; single-component neutral-curing formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and aluminum-framed-system manufacturers for this use.

2.5 Entrance Door Systems

- A. Entrance Doors: As specified in Division 084113 Section "Aluminum-Framed Entrances and Storefronts".

2.6 Accessory Materials

- A. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 07 Section "Joint Sealants".
- B. Bituminous Paint: Cold-applied, asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos; formulated for 30 mil (0.762 mm) thickness per coat.

2.7 Fabrication

- A. Extrude aluminum shapes before finishing.
- B. Framing Members, General: Fabricate components that, when assembled, have the following characteristics:
 - 1. Profiles that are sharp, straight, and free of defects or deformations.
 - 2. Accurately fit joints; make joints flush, hairline and weatherproof.
 - 3. Physical and thermal isolation of glazing from framing members.
 - 4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.

5. Provisions for field replacement of glazing.
 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- C. Mechanically Glazed Framing Members: Fabricate for flush glazing without projecting stops.
- D. Storefront Framing: Fabricate components for assembly using manufacturer's standard installation instructions.
1. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes:

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing
1. Kawneer Permanodic™ AA-M10C21A44 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
 2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
 3. Kawneer Permanodic™ AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
 4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
 5. Kawneer Permادize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
 6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color _____)
 7. Other: Manufacturer _____ Type _____ Color _____.

PART 3 - EXECUTION

3.1 Examination

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weather tight aluminum frame installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 Installation

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing aluminum framed storefront system, accessories, and other components.
- B. Install aluminum framed storefront system level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 Field Quality Control

- A. Manufacturer's Field Services: Upon Owner's written request, provide periodic site visit by manufacturer's field service representative.

3.4 Adjusting, Cleaning, and Protection

- A. Clean aluminum surfaces immediately after installing aluminum framed storefronts. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- B. Clean glass immediately after installation. Comply with glass manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 081216

Laws and building and safety codes governing the design and use of glazed entrance, window, and curtain wall products vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
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