

SECTION 08411 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 1 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. This Section includes the following:
 - 1. Aluminum-framed storefronts.
 - a. Glazing is retained mechanically with gaskets on four sides.
 - 2. Manual-swing aluminum doors.
 - 3. Aluminum door frames.
 - 4. Fixed windows fabricated from aluminum-framed storefronts.
- B. Curtain wall system, fixed windows, and framed entrances and storefronts to be supplied by the same manufacturer.
- C. Related Sections include the following:
 - 1. Division 7 Section "Building Insulation" for insulation materials field installed with aluminum-framed systems.
 - 2. Division 7 Section "Joint Sealants" for installation of joint sealants installed with aluminum-framed systems and for sealants to the extent not specified in this Section.
 - 3. Division 8 Section "Sliding Automatic Entrance Doors" for sliding entrance doors.
 - 4. Division 8 Section "Door Hardware" for hardware to the extent not specified in this Section.
 - 5. Division 8 Section "Glazing" for glazing requirements at interior and exterior entrance doors and storefront system.
 - 6. Division 8 Section "Glazed Aluminum Curtain Walls" for curtain-wall systems.

1.3 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum-framed systems, including anchorage, capable of withstanding, without failure, the effects of the following:
 - 1. Structural loads.
 - 2. Thermal movements.

3. Movements of supporting structure indicated on Drawings including, but not limited to, story drift and deflection from uniformly distributed and concentrated live loads.
 4. Dimensional tolerances of building frame and other adjacent construction.
 5. Failure includes the following:
 - a. Deflection exceeding specified limits.
 - b. Thermal stresses transferred to building structure.
 - c. Framing members transferring stresses, including those caused by thermal and structural movements, to glazing.
 - d. Noise or vibration created by wind and thermal and structural movements.
 - e. Loosening or weakening of fasteners, attachments, and other components.
 - f. Sealant failure.
 - g. Failure of operating units to function properly.
- B. Structural Loads:
1. Wind Loads: As indicated on Drawings.
 2. Seismic Loads: As indicated on Drawings.
- C. Deflection of Framing Members:
1. Deflection Normal to Wall Plane: Limited to 1/175 of clear span for all spans.
 2. Deflection Parallel to Glazing Plane: Limited to 1/360 of clear span or 1/8 inch, whichever is smaller.
- D. Structural-Test Performance: Provide aluminum-framed systems tested according to ASTM E 330 as follows:
1. When tested at positive and negative wind-load design pressures, systems do not evidence deflection exceeding specified limits.
 2. When tested at 150 percent of positive and negative wind-load design pressures, systems, including anchorage, do not evidence material failures, structural distress, and permanent deformation of main framing members exceeding 0.2 percent of span.
 3. Test Durations: As required by design wind velocity but not less than 10 seconds.
- E. Story Drift: Provide aluminum-framed systems that accommodate design displacement of adjacent stories indicated.
1. Design Displacement: As indicated on Drawings.
- F. Thermal Movements: Provide aluminum-framed systems that allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures. Base engineering calculation on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.
1. Temperature Change (Range): Ambient; 180 deg F, material surfaces.

- G. Air Infiltration: Provide aluminum-framed systems with maximum air leakage through fixed glazing and framing areas of 1.0 cfm/sq. ft. of fixed wall area when tested according to ASTM E 283 at a minimum static-air-pressure difference of 1.57 lbf/sq. ft..
- H. Water Penetration Under Static Pressure: Provide aluminum-framed systems that do not evidence water penetration through fixed glazing and framing areas when tested according to ASTM E 331 at a minimum static-air-pressure difference of 20 percent of positive wind-load design pressure, but not less than 6.24 lbf/sq. ft..
 - 1. Maximum Water Leakage: According to AAMA 501.1. Water controlled by flashing and gutters that is drained to exterior and cannot damage adjacent materials or finishes is not considered water leakage.
- I. Condensation Resistance: Provide aluminum-framed systems with fixed glazing and framing areas having condensation-resistance factor (CRF) of not less than 53 when tested according to AAMA 1503.
- J. Average Thermal Conductance: Provide aluminum-framed systems with fixed glazing and framing areas having average U-factor of not more than 0.48 Btu/sq. ft. x h x deg F when tested according to AAMA 1503.
- K. Sound Transmission: Provide aluminum-framed systems with fixed glazing and framing areas having minimum STC 38 according to ASTM E 413.

1.4 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, and finishes for each type of product indicated.
- B. Shop Drawings: For aluminum-framed systems. Include plans, elevations, sections, 150 metric details, and attachments to other work.
 - 1. Include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation.
 - 2. Include details of provisions for system expansion and contraction and for draining moisture occurring within the system to the exterior.
 - 3. For entrances, include hardware schedule and indicate operating hardware types, functions, quantities, and locations.
- C. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.
- D. Welding certificates.
- E. Qualification Data: For Installer.

- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, for aluminum-framed systems.
- G. Maintenance Data: For aluminum-framed systems to include in maintenance manuals.
- H. Warranties: Special warranties specified in this Section.

1.5 QUALITY ASSURANCE

- A. Installer Qualifications: Capable of assuming engineering responsibility and performing work of this Section and who is acceptable to manufacturer.
 - 1. Engineering Responsibility: Preparation of data for aluminum-framed systems including Shop Drawings based on testing and engineering analysis of manufacturer's standard units in assemblies similar to those indicated for this Project and submission of reports of tests performed on manufacturer's standard assemblies.
- B. Testing Agency Qualifications: An independent agency qualified according to ASTM E 699 for testing indicated.
- C. Product Options: Information on Drawings and in Specifications establishes requirements for systems' aesthetic effects and performance characteristics. 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. Performance characteristics are indicated by criteria subject to verification by one or more methods including preconstruction testing, field testing, and in-service performance.
 - 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.
- D. Accessible Entrances: Comply with the U.S. Architectural & Transportation Barriers Compliance Board's "Americans with Disabilities Act (ADA), Accessibility Guidelines for Buildings and Facilities (ADAAG)." ICC/ANSI A117.1.
- E. Welding: Qualify procedures and personnel according to AWS D1.2, "Structural Welding Code--Aluminum."

1.6 PROJECT CONDITIONS

- A. Field Measurements: Verify actual locations of structural supports for aluminum-framed systems by field measurements before fabrication and indicate measurements on Shop Drawings.
 - 1. Established Dimensions: Where field measurements cannot be made without delaying the Work, establish dimensions and proceed with fabricating aluminum-framed systems

without field measurements. Coordinate construction to ensure that actual dimensions correspond to established dimensions.

1.7 WARRANTY

- A. Special Assembly Warranty: Manufacturer's standard form in which manufacturer agrees to repair or replace components of aluminum-framed systems that do not comply with requirements or that deteriorate as defined in this Section within specified warranty period.
1. Failures include, but are not limited to, the following:
 - a. Structural failures including, but not limited to, excessive deflection.
 - b. Noise or vibration caused by thermal movements.
 - c. Deterioration of metals, metal finishes, and other materials beyond normal weathering.
 - d. Adhesive or cohesive sealant failures.
 - e. Water leakage through fixed glazing and framing areas.
 - f. Failure of operating components to function properly.
 2. Warranty Period: Two years from date of Substantial Completion.
- B. Special Finish Warranty: Manufacturer's standard form in which manufacturer agrees to repair or replace components on which finishes fail within specified warranty period. Warranty does not include normal weathering.
1. Warranty Period: 20 years from date of Substantial Completion.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
- B. Basis-of-Design Product: The design for aluminum-framed systems is based on Model 350, heavy wall door with Trifab VG451T frames with heavy wall frame option exterior for entrances and TriFab VG 450, standard for interior storefront systems and fixed windows as manufactured by Kawneer. Subject to compliance with requirements, provide the named product or a comparable product by one of the following:
1. Arch Aluminum & Glass Co., Inc.
 2. EFCO Corporation.
 3. Kawneer.
 4. Tubelite Inc.
 5. United States Aluminum.

6. Vistawall Architectural Products.

2.2 MATERIALS

- A. Aluminum: Alloy and temper recommended by manufacturer for type of use and finish indicated.
 1. Sheet and Plate: ASTM B 209.
 2. Extruded Bars, Rods, Profiles, and Tubes: ASTM B 221.
 3. Extruded Structural Pipe and Tubes: ASTM B 429.
 4. Structural Profiles: ASTM B 308.
 5. Welding Rods and Bare Electrodes: AWS A5.10.
- B. Steel Reinforcement: With manufacturer's standard corrosion-resistant primer complying with SSPC-PS Guide No. 12.00 applied immediately after surface preparation and pretreatment. Select surface preparation methods according to recommendations in SSPC-SP COM and prepare surfaces according to applicable SSPC standard.
 1. Structural Shapes, Plates, and Bars: ASTM A 36.
 2. Cold-Rolled Sheet and Strip: ASTM A 1008.
 3. Hot-Rolled Sheet and Strip: ASTM A 1011.

2.3 FRAMING SYSTEMS

- A. Framing Members: Manufacturer's standard extruded-aluminum framing members of thickness required and reinforced as required to support imposed loads.
 1. Construction: Framing members are composite assemblies of two separate extruded-aluminum components permanently bonded by an elastomeric material of low thermal conductance.
- 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.
 1. Where fasteners are subject to loosening or turning out from thermal and structural movements, wind loads, or vibration, use self-locking devices.
 2. Reinforce members as required to receive fastener threads.
- D. Concrete and Masonry Inserts: Hot-dip galvanized cast-iron, malleable-iron, or steel inserts complying with ASTM A 123 or ASTM A 153 requirements.
- E. Flashing: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding flashing compatible with adjacent materials. Form exposed flashing from sheet aluminum finished to

match framing and of sufficient thickness to maintain a flat appearance without visible deflection.

- F. Framing System Gaskets and Sealants: Manufacturer's standard recommended by manufacturer for joint type.

2.4 GLAZING SYSTEMS

- A. Glazing Gaskets: Manufacturer's standard compression types, replaceable, molded or extruded, that maintain uniform pressure and watertight seal.

2.5 DOORS

- A. Doors: Manufacturer's standard glazed doors, for manual swing operation.
 - 1. Door Construction: 2-inch overall thickness, with minimum 0.188-inch thick, extruded-aluminum tubular rail and stile members. Mechanically fasten corners with reinforcing brackets that are deep penetration and fillet welded or that incorporate concealed tie rods.
 - 2. Door Design: Medium stile; 3-1/2-inch nominal width.
 - a. Accessible Doors: Smooth surfaced for width of door in area within 10 inches above floor or ground plane.
 - 3. Glazing Stops and Gaskets: Square, snap-on, extruded-aluminum stops and preformed gaskets.
 - a. Provide nonremovable glazing stops on outside of door.
- B. Door Hardware: As specified in Division 8 Section "Door Hardware."

2.6 ACCESSORY MATERIALS

- A. Insulating Materials: As specified in Division 7 Section "Building Insulation."
- B. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 7 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 thickness per coat.

2.7 FABRICATION

- A. Form aluminum shapes before finishing.

- B. Weld in concealed locations to greatest extent possible to minimize distortion or discoloration of finish. Remove weld spatter and welding oxides from exposed surfaces by descaling or grinding.
- C. 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 fitted joints with ends coped or mitered.
 - 3. Means to drain water passing joints, condensation occurring 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 from interior.
 - 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- D. Mechanically Glazed Framing Members: Fabricate for flush glazing (without projecting stops).
- E. Storefront Framing: Fabricate components for assembly using screw-spline system.
- F. Door Frames: Reinforce as required to support loads imposed by door operation and for installing hardware.
 - 1. At exterior doors, provide compression weather stripping at fixed stops.
 - 2. At interior doors, provide silencers at stops to prevent metal-to-metal contact. Install three silencers on strike jamb of single-door frames and two silencers on head of frames for pairs of doors.
- G. Doors: Reinforce doors as required for installing hardware.
 - 1. At pairs of exterior doors, provide sliding weather stripping retained in adjustable strip mortised into door edge.
 - 2. At exterior doors, provide weather sweeps applied to door bottoms.
- H. Hardware Installation: Factory install hardware to the greatest extent possible. Cut, drill, and tap for factory-installed hardware before applying finishes.
- I. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 ALUMINUM FINISHES

- A. General: Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.

- B. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- C. High-Performance Organic Finish (2-Coat Fluoropolymer): AA-C12C40R1x (Chemical Finish: cleaned with inhibited chemicals; Chemical Finish: conversion coating; Organic Coating: manufacturer's metallic 2-coat, thermocured system consisting of specially formulated inhibitive primer and fluoropolymer color topcoat containing not less than 50 percent polyvinylidene fluoride resin by weight). Prepare, pretreat, and apply coating to exposed metal surfaces to comply with AAMA 2604 and with coating and resin manufacturers' written instructions.
 - 1. Specified Design Product Finish: Kawneer's Permadize Finish (metallic).
 - 2. Color and Gloss: Match color of curtain wall system.

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 work.
 - 1. Proceed with installation only after unsatisfactory conditions have been corrected.

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 nonmovement joints.
 - 5. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration.
 - 6. 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 the system to exterior.

- D. Set continuous sill members and flashing in full sealant bed as specified in Division 7 Section "Joint Sealants" and to produce weathertight installation.
- E. Install components plumb and true in alignment with established lines and grades, without warp or rack.
- F. Entrances: Install to produce smooth operation and tight fit at contact points.
 - 1. Exterior Entrances: Install to produce tight fit at weather stripping and weathertight closure.
 - 2. Field-Installed Hardware: Install surface-mounted hardware according to hardware manufacturers' written instructions using concealed fasteners to greatest extent possible.
- G. Install perimeter joint sealants as specified in Division 7 Section "Joint Sealants" and to produce weathertight installation.
- H. Erection Tolerances: Install aluminum-framed systems to comply with the following maximum tolerances:
 - 1. Location and Plane: Limit variation from true location and plane to 1/8 inch in 12 feet; 1/4 inch over total length.
 - 2. Alignment:
 - a. Where surfaces abut in line, limit offset from true alignment to 1/16 inch.
 - b. Where surfaces meet at corners, limit offset from true alignment to 1/32 inch.
 - 3. Diagonal Measurements: Limit difference between diagonal measurement to 1/8 inch.

3.3 ADJUSTING

- A. Entrances: Adjust operating hardware for smooth operation according to hardware manufacturers' written instructions.
 - 1. For doors accessible to people with disabilities, adjust closers to provide a 3-second closer sweep period for doors to move from a 70-degree open position to 3 inches from the latch measured to the leading door edge.

3.4 FRAME SCHEDULE

- A. Exterior Type 1: Trifab VG451T door frame with heavy wall frame option as manufactured by Kawneer.
- B. Interior Type 2: Trifab VG450, standard, for interior storefront systems as manufactured by Kawneer.

END OF SECTION 08411