

SECTION 08411 - ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS

PART 1 - GENERAL

1.01 RELATED DOCUMENTS

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

1.02 SUMMARY

- A. This Section includes the following:
 - 1. Exterior aluminum-framed storefronts.
 - a. Glazing is retained mechanically with gaskets on four sides.
 - 2. Exterior manual-swing aluminum doors.
 - 3. Exterior aluminum door frames.
 - 4. Break metal in conjunction with frames.
 - 5. Door hardware.
 - 6. Sealant at exterior perimeter of storefront.
- B. Related Sections include the following:
 - 1. 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.
 - 2. Division 8 Section "Door Hardware" for hardware to the extent not specified in this Section.
 - 3. Division 8 Section "Glazing" for glazing requirements to the extent not specified in this Section.
- C. Products installed, but not furnished, under this Section include the following:
 - 1. Balance of door hardware furnished in Division 8 Section "Door Hardware".

1.03 PERFORMANCE REQUIREMENTS

- A. Carefully examine all of the Contract Documents for requirements which affect the work of this section. Other specifications sections which directly relate to the work of this section include, but are not limited to, 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.
 - 3. Code: IBC 2006.
- C. Deflection of Framing Members:
- 1. Deflection Normal to Wall Plane: Limited to 1/175 of clear span for spans up to **13-foot 6-inches** and to 1/240 of clear span plus **1/4-inch** for spans greater than **13-foot 6-inches** or an amount that restricts edge deflection of individual glazing lites to **3/4-inch**, whichever is less.
 - 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 Duration: As required by design wind velocity but not less than 10 seconds.
- E. Seismic Loads: Provide entrance and storefront systems, including anchorage, capable of withstanding the effects of earthquake motions calculated according to requirements of authorities having jurisdiction or ASCE 7-98, "Minimum Design Loads for Buildings and other Structures," Section 9, "Earthquake Loads," whichever are more stringent.
- 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 calculations on surface temperatures of materials due to both solar heat gain and nighttime-sky heat loss.
- 1. Temperature Change (Range): 120 deg F, ambient; 180 deg F, material surfaces.
- G. Air Infiltration: Provide aluminum-framed systems with maximum air leakage through fixed glazing and framing areas of **0.06 cfm/sq. ft.** of fixed wall area when tested according to ASTM E 283 at a minimum static-air-pressure difference of **6.24 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 283 at a minimum static-air-pressure difference of **6.24 lbf/sq. ft.**

- I. Condensation Resistance: Provide aluminum-framed systems with fixed glazing and framing areas having average U-factor of not more than 0.44 btu/sq. ft. x h x deg F when tested according to AAMA 1503.

1.04 SUBMITTALS

- A. General: Submit in accordance with Section 01330.
- B. Product Data: Include construction details, material descriptions, dimensions of individual components and profiles, and finishes for each type of product installed.
 - 1. Submit replacement parts lists, adjustments instructions, and maintenance requirements for all components and hardware.
- C. Shop Drawings: For aluminum-framed systems, include plans, elevations, sections, 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.
 - 4. Indicate fastener layout and size for transferring loads back to supporting structure.
- D. Samples:
 - 1. Factory-Applied Color Finishes: Submit manufacturers color charts in the form of prefinished aluminum samples, roughly 3- by 5-inches, showing full range of colors available for each type of exposed finish indicated.
 - 2. Sealants: Manufacturers color charts consisting of strips of cured sealants showing the full range of colors available for each product exposed to view.
- E. Welding Certificates.
- F. Qualification Data: For Installer signed by manufacturer certifying that Installers comply with requirements in "Quality Assurance" Article.
- G. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, for aluminum-framed systems.
- H. Inspection Reports: Manufacturers field service representative tests performed by a qualified testing agency, for aluminum-framed systems.
- I. Maintenance Data: For aluminum-framed systems to include in maintenance manuals.
 - 1. Include maintenance manuals for hardware provided in this Section.
- J. Warranties: Special warranties specified in this Section.

1.05 QUALITY ASSURANCE

- A. Installer Qualification: 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. 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 pre-construction 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.

- C. Source Limitations: Obtain each type of aluminum-framed entrance and storefront from one source and by a single manufacturer.

- D. Accessible Entrances: Comply with the US Architectural & Transportation Barriers Compliance Boards "Americans with Disabilities Act (ADA), Accessibility Guidelines for Buildings and Facilities (ADAAG)".

- E. Welding: Qualify procedures and personnel according to AWS D1.2, "Structural welding Code-Aluminum".

- F. Pre-installation Conference: Conduct conference at Project site. Comply with requirements in Division 1 Section "Project Meetings." Review methods and procedures related to glazed aluminum storefront and entrance systems including, but not limited to, the following:
 - 1. Inspect and discuss condition of substrate and other preparatory work performed by other trades.
 - 2. Review structural loading limitations.
 - 3. Review and finalize construction schedule and verify availability of materials
Installer's personnel, equipment, and facilities needed to make progress and avoid delays.
 - 4. Review required inspecting, testing, and certifying procedures.
 - 5. Review weather and forecasted weather conditions and procedures for coping with unfavorable conditions.
 - 6. Review temporary protection requirements for existing construction during and after installation.
 - 7. Document proceedings, including corrective measures and actions required, and furnished copy of record to each participant.
 - 8. Provide 72-hour minimum advance notice to participants prior to convening pre-installation conference.

- G. Field Quality Control: Provide manufacturer's field services consisting of product use recommendations and periodic site visits for inspection of product installation in accordance with manufacturer's instruction. Upon completion of installation, manufacturer's field representative shall prepare written report on installation of systems.

1.06 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. Coordinate rough opening and wood blocking requirements.

1.07 WARRANTY

- A. General: Special warranties specified in this Section shall not deprive Owner of other rights Owner may have under provisions of Contract Documents and will be in addition to and run concurrent with other warranties made by Contractor under requirements of Contract Documents.
- B. 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. Failure of system to meet performance requirements.
 - c. Noise or vibration caused by thermal movements.
 - d. Deterioration of metals, metal finishes, and other materials beyond normal weathering.
 - e. Adhesive or cohesive sealant failures.
 - f. Water leakage through fixed glazing and framing areas.
 - g. Failure of operating components to function properly.
 - h. Glazing breakage.
 - 2. Warranty Period: Two (2) years from date of Substantial Completion.
- C. 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: Ten (10) years from date of Substantial Completion.

PART 2 - PRODUCTS

2.01 MANUFACTURERS

- A. Products: Subject to compliance with requirements, provide one of the following:

1. Kawneer Company, Inc.; 451T frames with 350 Standard Entrances and Frames.
2. Tubelite; 1400 Series poured and debridged Thermal Storefront Systems with Medium Stile Standard Entrances and Frames.
3. YKK AP America, Inc.; YES 45 TU with 35D Wide Stile Swing Entrances and Frames.

2.02 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/B 308/M.
 5. Welding Rods and Bare Elements: AWS A5.10/A5.10M.
 6. Finish: Clear anodized.
- 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-COM and prepare surfaces according to applicable SSPC standard.
1. Structural Shapes, Plates and Bars: ASTM A 36/A 36M.
 2. Cold-Rolled Sheet and Strip: ASTM A 1008/A 1008/M.
 3. Hot-Rolled Sheet and Strip: ASTM A 1011/A 1011/M.

2.03 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.
 2. Provide thermally broken extruded aluminum still flashing with end dams for windows.
 3. Provide non-thermally broken frames for interior units as noted on the drawings.
 4. Provide operable units (doors and windows) manufactured by storefront system manufacturer.
 5. Provide components having face width indicated on Drawings.
- B. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with non-staining, non ferrous shims for aligning system components.
1. Provide extra-heavy reinforcement for hinges and closers at doors over 7-ft in height.
- C. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, non-staining, non-bleeding 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.
 3. Do not use exposed fasteners, except for hardware application. For hardware applications, use exposed fasteners with countersunk Phillips screw heads, finished to match framing system or hardware being fastened, unless otherwise noted. Exposed fasteners shall be stainless steel.
- D. Concrete and Masonry Inserts: Hot-dip galvanized cast-iron, malleable-iron, or steel inserts complying with ASTM A 123/A 123/M or ASTM A 153/A 153/M requirements.
- E. Concealed Flashing: Manufacturer's standard corrosion-resistant, non-staining, non-bleeding flashing compatible with adjacent materials.
1. Provide vertical expansion joint flashing as detailed. Form flashing from sheet aluminum finished to match framing and of sufficient thickness to maintain a flat appearance without visible deflection.
- F. Aluminum Break Metal: Form exposed flashing from sheet aluminum finished to match framing and of sufficient thickness, not less than **0.060-inch** thick, to maintain a flat appearance without visible deflection.
- G. Framing System Gaskets and Sealants: Manufacturer's standard recommended by manufacturer for joint type.
1. Provide sealants and sealant primers for use inside of the weatherproofing system that comply with the following limits for VOC content when calculated according to South Coast Air Quality Management District Rule No. 1168.
 - a. Sealant:
 - 1) Architectural 250 g/L.
 - 2) Other 420 g/L.
 - b. Sealant Primer:
 - 1) Architectural, Non porous 250 g/L.
 - 2) Architectural, Porous 775 g/L.
 - 3) Other 750 g/L.

2.04 GLAZING SYSTEMS

- A. Glazing: As specified in Division 8 Section "Glazing."
- B. Glazing Gaskets: Manufacturer's standard pressure-glazing system of black, extruded EPDM rubber gaskets, fabricated to comply with system performance requirements. Provide gasket assemblies that have corners sealed with sealant recommended by gasket manufacturer.

- C. Spacers and Setting Blocks: 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: Provide for joints at perimeter of entrance and storefront systems as specified in Division 7 Section "Joint Sealants."

2.05 DOORS

- A. Doors: Manufacturer's standard glazed doors, for manual and power-assisted swing operation.
 - 1. Door Construction: **1¾-inch** overall thickness, with minimum **0.125-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; **3½-inch** nominal width, **10-inch** high bottom rail, and **6-inch** cross-rail.
 - 3. Door Frame: Minimum **0.188-inch** thick extruded aluminum; **2-inch by 4½-inch** profile, stop with weather-stripping; run heavy weight jambs full height of opening.
 - 4. Glazing Stops and Gaskets: Manufacturer's heavy weight removable mullion with weather-stripping, finish to match frame.
 - a. Provide non-removable glazing stops on outside of exterior doors.

2.06 DOOR HARDWARE

- A. General: Provide heavy-duty units in sizes, numbers, and types recommended by entrance system and hardware manufacturer for entrances and uses indicated. Finish exposed parts to match door finish, unless otherwise indicated. Provide specified manufacturers without substitution.
 - 1. Opening-Force Requirements:
 - a. Egress Doors: Not more than **30 lbf** required to set door in motion and not more than **15 lbf** required to open door to minimum required width.
 - b. Accessible Interior Doors: Not more than **5 lbf**.
- B. Ball-Bearing Hinges:
 - 1. Material: Stainless Steel.
 - 2. Provide non-removable pins (NRP) at hinges exposed to outside of exterior doors and to non-secured side of interior doors.
 - 3. Quantities:
 - a. For doors with heights up to **87-inches**, provide 3 hinges per leaf.
 - b. For doors with heights greater than 87-inches and up to **120-inches**, provide 4 hinges per leaf.

- C. Removable Hardware Mullion Meeting Stile: BHMA A156.3; steel painted to match storefront. Provide at exterior doors with weather-stripping.
 - 1. When used with panic exit devices, provide removable mullions listed and labeled by a testing and inspecting agency acceptable to authorities having jurisdiction, for panic protection, based on testing according to UL 305. Use only mullions that have been tested with exit devices to be used.
- D. Weather-stripping: Manufacturer's standard exterior door bottom sweep with concealed fasteners on mounting strip.
- E. Weather Sweeps: Manufacturer's standard exterior door bottom sweep with concealed fasteners on mounting strip.
- F. Thresholds: Raised thresholds beveled with a slope of not more than 1:2, with maximum height of $\frac{1}{2}$ -inch. Coordinate cutouts for operating hardware with anchors and jamb clips. Provide with a maximum slope of not more than 1:2.
 - 1. Material: Aluminum, mill finish.
- G. Balance of Hardware: See Division 8 "Door Hardware".

2.07 ACCESSORY MATERIALS

- A. Joint Sealants: For installation at perimeter of aluminum-framed systems, as specified in Division 7 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 thickness per coat.

2.08 FABRICATION

- A. Form aluminum shapes before finishing.
- B. Weld in concealed locations to greatest extent possible to minimize distortion or discoloration of finish. Remove welding spatter and welding oxides from exposed surfaces by de-scaling 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 of clearances.

6. Provisions for field replacement of glazing from exterior.
 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 project stops).
- E. Entrance 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 3 silencers on strike jamb of single-door frames and 2 silencers on head of frames for pairs of doors.
- F. Entrance Doors: Reinforce doors as required for installing hardware.
1. At exterior doors, provide weather sweeps applied to door bottoms and compression weather-stripping at fixed stops.
- G. Windows: 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. Fabricate units that are re-glazable without dismantling sash or ventilator framing.
1. Provide hardware with low conductivity or non-metallic material for hardware bridging thermal breaks at frame.
- H. Entrance Door Hardware Installation: Factory-install entrance door hardware to the greatest extent possible. Cut, drill, and tap for factory-installed and field-installed entrance door hardware before applying finishes.
- I. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.09 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 designing 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 standard 2-coat, thermocured system consisting of specially formulated inhibitive primer and Fluoropolymer color topcoat containing not less than 70 percent polyvinylidene fluoride resin by weight). Prepare, pretreat, and apply coating to exposed metal surfaces to comply with AAMA 2605 and with coating and resin

manufacturer's written instructions.

1. Color and Gloss: As selected by Architect from manufacturer's full range.

PART 3 - EXECUTION

3.01 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.

3.02 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.
 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 non-conductive 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. Install sills in one piece, full width of opening except where opening exceeds available manufactured lengths. Provide sealed metal end dams at ends of sills. Sills shall turn up on backside to form pan, directing water to the exterior.
- E. Install components plumb and true in alignment with established lines and grades, without warp or rack.
- F. Install glazing as specified in Division 8 Section "Glazing".
- G. Entrance Doors and Windows: Install to produce smooth operation and tight fit at

contact points.

1. Exterior Entrances and Windows: 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.
 3. Install hardware furnished in Division 8 Section "Door Hardware".
- H. Install perimeter joint sealants as specified in Division 7 Section "Joint Sealants" and to product weathertight installation. Color of sealant to match aluminum finish.
- I. Erection Tolerances: Install aluminum-framed systems to comply with 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. Alignments:
 - 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 alignments to **1/32-inch**.
 3. Diagonal Measurements: Limit difference between diagonal measurement to **1/8-inch**.

3.03 ADJUSTING AND CLEANING

- A. Provide final protection and maintain conditions in a manner acceptable to manufacturer and installer that ensures entrances and storefront systems are without damage or deterioration at time of Substantial Completion.

END OF SECTION