
Oakhurst Dairy – New Milk Cooler**SECTION 05500 - METAL FABRICATIONS****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. Loose bearing and leveling plates.
 2. Loose steel lintels.
 3. Steel framing and supports for overhead doors.
 4. Steel framing and supports for mechanical and electrical equipment.
 5. Steel framing and supports for applications where framing and supports are not specified in other Sections.
 6. Loading-dock edge angles.
 7. Miscellaneous metal trim.
 8. Structural-steel door frames.
 9. Cast nosings.
 10. Pipe bollards.
 11. Metal Floor Plate
- B. Related Sections include the following:
1. Division 5 Section "Aluminum Fabrications" for metal gratings, stairs, and railings.
 2. Division 3 Section "Grout" for miscellaneous grouting requirements.
 3. Division 4 Sections "Unit Masonry Assemblies" and "Glass Unit Masonry Assemblies" for masonry.

1.3 SUBMITTALS

- A. Product Data: For the following:
1. Paint products.
- B. Shop Drawings: Detail fabrication and erection of each metal fabrication indicated. Include plans, elevations, sections, and details of metal fabrications and their connections. Show anchorage and accessory items.
1. Provide templates for anchors and bolts specified for installation under other Sections.
- C. Mill Certificates: Signed by manufacturers of stainless-steel sheet certifying that products furnished comply with requirements.
- D. Welding Certificates: Copies of certificates for welding procedures and personnel.

Oakhurst Dairy – New Milk Cooler

- E. Qualification Data: For firms and persons specified in "Quality Assurance" Article to demonstrate their capabilities and experience. Include lists of completed projects with project names and addresses, names and addresses of architects and owners, and other information specified.

1.4 QUALITY ASSURANCE

- A. Fabricator Qualifications: A firm experienced in producing metal fabrications similar to those indicated for this Project and with a record of successful in-service performance, as well as sufficient production capacity to produce required units.
- B. Welding: Qualify procedures and personnel according to the following:
 - 1. AWS D1.1, "Structural Welding Code--Steel."
 - 2. AWS D1.2, "Structural Welding Code--Aluminum."
 - 3. AWS D1.3, "Structural Welding Code--Sheet Steel."
 - 4. Certify that each welder has satisfactorily passed AWS qualification tests for welding processes involved and, if pertinent, has undergone re-certification.

1.5 PROJECT CONDITIONS

- A. Field Measurements: Where metal fabrications are indicated to fit walls and other construction, verify dimensions by field measurements before fabrication and indicate measurements on Shop Drawings. Coordinate fabrication schedule with construction progress to avoid delaying the Work.

1.6 COORDINATION

- A. Coordinate installation of anchorages for metal fabrications. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.

PART 2 - PRODUCTS**2.1 METALS, GENERAL**

- A. Metal Surfaces, General: For metal fabrications exposed to view in the completed Work, provide materials with smooth, flat surfaces without blemishes. Do not use materials with exposed pitting, seam marks, roller marks, rolled trade names, or roughness.

2.2 FERROUS METALS

- A. Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- B. Stainless-Steel Sheet, Strip, Plate, and Flat Bars: ASTM A 666, Type 304.
- C. Stainless-Steel Bars and Shapes: ASTM A 276, Type 304.
- D. Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.
- E. Rolled-Stainless-Steel Floor Plate: ASTM A 793.

Oakhurst Dairy – New Milk Cooler

- F. Steel Tubing: Cold-formed steel tubing complying with ASTM A 500.
- G. Steel Pipe: ASTM A 53, standard weight (Schedule 40), unless another weight is indicated or required by structural loads.
- H. Cast-in-Place Anchors in Concrete: Anchors of type indicated below, fabricated from corrosion-resistant materials capable of sustaining, without failure, the load imposed within a safety factor of 4, as determined by testing per ASTM E 488, conducted by a qualified independent testing agency.
 - 1. Threaded or wedge type; galvanized ferrous castings, either ASTM A 47 malleable iron or ASTM A 27/A 27M cast steel. Provide bolts, washers, and shims as needed, hot-dip galvanized per ASTM A 153/A 153M.
- I. Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.

2.3 PAINT

- A. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in steel, complying with SSPC-Paint 20.
- B. Bituminous Paint: Cold-applied asphalt mastic complying with SSPC-Paint 12, except containing no asbestos fibers, or cold-applied asphalt emulsion complying with ASTM D 1187.

2.4 FASTENERS

- A. General: Provide Type 304 or 316 stainless-steel fasteners and pipe sleeves for exterior use and zinc-plated fasteners with coating complying with ASTM B 633, Class Fe/Zn 5, where built into exterior walls. Select fasteners for type, grade, and class required.
- B. Bolts and Nuts: Regular hexagon-head bolts, ASTM A 307, Grade A; with hex nuts, ASTM A 563; and, where indicated, flat washers.
- C. Anchor Bolts: ASTM F 1554, Grade 36.
- D. Machine Screws: ASME B18.6.3.
- E. Expansion Anchors: Anchor bolt and sleeve assembly of material indicated below with capability to sustain, without failure, a load equal to six times the load imposed when installed in unit masonry and equal to four times the load imposed when installed in concrete, as determined by testing per ASTM E 488, conducted by a qualified independent testing agency.
 - 1. Material: Carbon-steel components zinc-plated to comply with ASTM B 633, Class Fe/Zn 5.
 - 2. Material: Alloy Group 1 or 2 stainless-steel bolts complying with ASTM F 593 and nuts complying with ASTM F 594.
- F. Toggle Bolts: FS FF-B-588, tumble-wing type, class and style as needed.

Oakhurst Dairy – New Milk Cooler**2.5 CONCRETE FILL**

- A. Concrete Materials and Properties: Comply with requirements in Division 3 Section "Cast-in-Place Concrete" for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 3000 psi, unless otherwise indicated.

2.6 FABRICATION, GENERAL

- A. Shop Assembly: Preassemble items in shop to greatest extent possible to minimize field splicing and assembly. Disassemble units only as necessary for shipping and handling limitations. Use connections that maintain structural value of joined pieces. Clearly mark units for reassembly and coordinated installation.
- B. Shear and punch metals cleanly and accurately. Remove burrs.
- C. Ease exposed edges to a radius of approximately 1/32 inch, unless otherwise indicated. Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- D. Weld corners and seams continuously to comply with the following:
1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 2. Obtain fusion without undercut or overlap.
 3. Remove welding flux immediately.
 4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- E. Provide for anchorage of type indicated; coordinate with supporting structure. Fabricate and space anchoring devices to secure metal fabrications rigidly in place and to support indicated loads.
- F. Cut, reinforce, drill, and tap metal fabrications as indicated to receive finish hardware, screws, and similar items.
- G. Fabricate joints that will be exposed to weather in a manner to exclude water, or provide weep holes where water may accumulate.
- H. Form exposed work true to line and level with accurate angles and surfaces and straight sharp edges.
- I. Remove sharp or rough areas on exposed traffic surfaces.
- J. Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Use exposed fasteners of type indicated or, if not indicated, Phillips flat-head (countersunk) screws or bolts. Locate joints where least conspicuous.

2.7 LOOSE BEARING AND LEVELING PLATES

- A. Provide loose bearing and leveling plates for steel items bearing on masonry or concrete construction. Drill plates to receive anchor bolts and for grouting.
- B. Galvanize plates after fabrication.

Oakhurst Dairy – New Milk Cooler**2.8 LOOSE STEEL LINTELS**

- A. Fabricate loose structural-steel lintels from steel angles and shapes of size indicated for openings and recesses in masonry walls and partitions at locations indicated.
- B. Weld adjoining members together to form a single unit where indicated.
- C. Galvanize loose steel lintels located in exterior walls.

2.9 MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Provide steel framing and supports indicated and as necessary to complete the Work.
- B. Fabricate units from structural-steel shapes, plates, and bars of welded construction, unless otherwise indicated. Fabricate to sizes, shapes, and profiles indicated and as necessary to receive adjacent construction retained by framing and supports. Cut, drill, and tap units to receive hardware, hangers, and similar items.
 - 1. Where units are indicated to be cast into concrete or built into masonry, equip with integrally welded steel strap anchors 1-1/4 inches wide by 1/4 inch thick by 8 inches long at 24 inches o.c., unless otherwise indicated.
- C. Fabricate supports for overhead doors as required for proper track installation. Brace support framing as required to prevent movement of door track.
- D. Galvanize miscellaneous framing and supports.

2.10 MISCELLANEOUS STEEL TRIM

- A. Unless otherwise indicated, fabricate units from structural-steel shapes, plates, and bars of profiles shown with continuously welded joints, and smooth exposed edges. Miter corners and use concealed field splices where possible.
- B. Provide cutouts, fittings, and anchorages as needed to coordinate assembly and installation with other work. Provide anchors, welded to trim, for embedding in concrete or masonry construction spaced not more than 6 inches from each end, 6 inches from corners, and 24 inches o.c., unless otherwise indicated.
- C. Galvanize all miscellaneous steel trim.

2.11 STRUCTURAL-STEEL DOOR FRAMES

- A. Fabricate steel doorframes from structural shapes and bars of size and to dimensions indicated, fully welded together, with 5/8-by-1-1/2-inch steel channel stops, unless otherwise indicated. Plug-weld built-up members and continuously weld exposed joints. Secure removable stops to frame with countersunk machine screws, uniformly spaced at not more than 10 inches o.c. Reinforce frames and drill and tap as necessary to accept finish hardware.
- B. Provide steel strap anchors, 1/8 by 2 inches, with a minimum 6-inch embedment and 2-inch hook, unless otherwise indicated, for securing doorframes into adjoining concrete or masonry. Weld anchors to frame jambs no more than 12 inches from both bottom and head of frame, and space anchors not more than 30 inches apart.

Oakhurst Dairy – New Milk Cooler

- C. Galvanize all frames.

2.12 CAST NOSINGS

- A. Fabricate units of metal indicated below in sizes and configurations indicated and in lengths necessary to accurately fit openings or conditions. Provide units with an integral abrasive finish consisting of aluminum oxide, silicon carbide, or a combination of both.
 - 1. Metal: Cast aluminum.
- B. Configurations: Provide units in the following configurations, unless otherwise indicated:
 - 1. Nosings: Cross-hatched units, 4 inches wide with 1-inch lip, for casting into concrete steps.
- C. Provide anchors for embedding units in concrete, either integral or applied to units, as standard with manufacturer.
- D. Apply bituminous paint to concealed bottoms, sides, and edges of units set into concrete.
- E. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - 1. American Safety Tread Co., Inc.
 - 2. Amstep Products.
 - 3. Armstrong Products, Inc.
 - 4. Balco/Metalines, Inc.
 - 5. Granite State Casting Co.
 - 6. Safe-T-Metal Co.
 - 7. Wooster Products Inc.

2.13 PIPE BOLLARDS

- A. Fabricate pipe bollards from Schedule 40 steel pipe.
- B. Fabricate sleeves for bollard anchorage from steel pipe with 1/4-inch thick steel plate welded to bottom of sleeve.
- C. Fabricate internal sleeves for removable bollards from Schedule 40 steel pipe or 1/4-inch wall-thickness steel tubing with an OD 1/16 inch less than ID of bollards. Match drill sleeve and bollard for 1/2-inch steel machine bolt.
- D. Galvanize all pipe bollards.

2.14 METAL FLOOR PLATE

- A. Fabricate from rolled-steel floor, rolled-stainless-steel floor, and abrasive-surface floor plate of thickness indicated below:
 - 1. Thickness: 1/4 inch.
- B. Provide galvanized steel and stainless steel angle supports as indicated.

Oakhurst Dairy – New Milk Cooler

- C. Include galvanized steel and stainless steel angle stiffeners, and fixed and removable sections as indicated.

2.15 FINISHES, GENERAL

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Finish metal fabrications after assembly.

2.16 STEEL AND IRON FINISHES

- A. Galvanizing: Hot-dip galvanize items as indicated to comply with applicable standard listed below:
 - 1. ASTM A 123, for galvanizing steel and iron products.
 - 2. ASTM A 153/A 153M, for galvanizing steel and iron hardware.

2.17 STAINLESS-STEEL FINISHES

- A. Remove tool and die marks and stretch lines or blend into finish.
- B. Bright, Directional Polish: No. 4 finish.
- C. When polishing is completed, passivate and rinse surfaces. Remove embedded foreign matter and leave surfaces chemically clean.

PART 3 - EXECUTION**3.1 INSTALLATION, GENERAL**

- A. Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal fabrications to in-place construction. Include threaded fasteners for concrete and masonry inserts, toggle bolts, through-bolts, lag bolts, wood screws, and other connectors.
- B. Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal fabrications. Set metal fabrications accurately in location, alignment, and elevation; with edges and surfaces level, plumb, true, and free of rack; and measured from established lines and levels.
- C. Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- D. Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.
- E. Field Welding: Comply with the following requirements:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.

Oakhurst Dairy – New Milk Cooler

3. Remove welding flux immediately.
4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.

3.2 SETTING BEARING AND LEVELING PLATES

- A. Clean concrete and masonry bearing surfaces of bond-reducing materials, and roughen to improve bond to surfaces. Clean bottom surface of plates.
- B. Set bearing and leveling plates on wedges, shims, or leveling nuts. After bearing members have been positioned and plumbed, tighten anchor bolts. Do not remove wedges or shims but, if protruding, cut off flush with edge of bearing plate before packing with grout.
 1. Pack grout solidly between bearing surfaces and plates to ensure that no voids remain.

3.3 INSTALLING MISCELLANEOUS FRAMING AND SUPPORTS

- A. General: Install framing and supports to comply with requirements of items being supported, including manufacturers' written instructions and requirements indicated on Shop Drawings, if any.
- B. Anchor supports for overhead door tracks securely to and rigidly brace from building structure.
- C. Install pipe columns on concrete footings with grouted baseplates. Position and grout column baseplates as specified above for setting and grouting bearing and leveling plates.

3.4 INSTALLING NOSINGS

- A. Install with anchorage system indicated to comply with manufacturer's written instructions.
- B. Center nosings on tread widths.
- C. For nosings embedded in concrete steps or curbs, align nosings flush with riser faces and level with tread surfaces.

3.5 INSTALLING PIPE BOLLARDS

- A. Anchor bollards in concrete with pipe sleeves preset and anchored into concrete. After bollards have been inserted into sleeves, fill annular space between bollard and sleeve solidly with nonshrink, nonmetallic grout, mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately 1/8 inch toward bollard.
- B. Anchor bollards in concrete in formed or core-drilled holes not less than 8 inches deep and 3/4 inch greater than OD of bollard. After bollards have been inserted into holes, fill annular space surrounding bollard solidly with nonshrink, nonmetallic grout, mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately 1/8 inch toward bollard.

Oakhurst Dairy – New Milk Cooler

- C. Anchor internal sleeves for removable bollards in concrete by inserting into pipe sleeves preset into concrete. After internal sleeves have been inserted, fill annular space between sleeves solidly with nonshrink, nonmetallic grout, mixed and placed to comply with grout manufacturer's written instructions. Slope grout up approximately 1/8 inch toward internal sleeve.
 - 1. Place removable bollards over internal sleeves and secure with 1/2-inch machine bolts and nuts. After tightening nuts, drill holes in bolts for inserting padlocks. Owner will furnish padlocks.
- D. Fill bollards solidly with concrete, mounding top surface.
 - 1. Do not fill removable bollards with concrete.

3.6 ADJUSTING AND CLEANING

- A. Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

END OF SECTION 05500