

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 Specification 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.
 - b. Subframe for exterior aluminum-framed storefronts.
 - 2. Exterior manual-swing aluminum doors.
 - 3. Exterior aluminum door frames.
 - 4. Break metal in conjunction with frames.
 - 5. Door hardware.
 - 6. Sealant at interior and 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.
 - 4. Division 8 Section "Glazed Aluminum Curtain Walls" for curtain-wall systems that mechanically retain glazing on four sides.

1.03 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 S60.1.
 2. Seismic Loads: As indicated on S60.1.
 3. Code: IBC 2003.
- C. Deflection of Framing Members:
1. Deflection Normal to Wall Plane: Limited to 1/175 of clear span for spans up to **13 feet 6 inches** and to 1/240 of clear span plus **1/4 inch** for spans greater than **13 feet 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 Durations: 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 calculation 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 **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.**
- I. Condensation Resistance: Provide aluminum-framed systems with fixed glazing and framing areas having condensation-resistance factor (CRF) of not less than 62 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 **0.44 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 indicated.
 - 1. Submit replacement parts lists, adjustment 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. Sealants: Manufacturer's 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. Manufacturer's Field Reports: Manufacturer's field service representative shall submit field inspection report of product installation to Architect.
- 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 Qualifications: Capable of assuming engineering responsibility and performing work of this Section, who is acceptable to manufacturer, and is able to obtain specified manufacturer's warranty.
 - 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. Professional Engineer Qualifications: A professional engineer who is legally qualified to practice in jurisdiction where Project is located and who is experienced in providing engineering services of the kind indicated. Engineering services are defined as those performed

for installations of glazed storefront systems that are similar to those indicated for this Project in material, design, and extent.

- 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. **Source Limitations:** Obtain each type of aluminum-framed entrance and storefront from one source and by a single manufacturer.
 - 1. Aluminum-framed entrances and storefront systems specified in this Section and curtain wall system specified in Division 8 Section "Glazed Aluminum Curtain Wall" shall be from same manufacturer.
- E. **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)."
- F. **Welding:** Qualify procedures and personnel according to AWS D1.2, "Structural Welding Code--Aluminum."
- G. **Preinstallation Conference:** Conduct conference at Project site. Comply with requirements in Division 1 Section "Project Management and Coordination." 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 furnish copy of record to each participant.
 - 8. Provide 72-hour minimum advance notice to participants prior to convening preinstallation conference.
- H. **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, masonry 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 other 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 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 Medium Entrances and Frames.
 - 2. Vistawall Architectural Products: Series 3000 poured and debridged Thermal Storefront System with 375 Medium Entrances and Frames.
 - 3. Aluminum-framed entrances and storefront systems specified in this Section and curtain wall system specified in Division 8 Section "Glazed Aluminum Curtain Wall" shall be from same manufacturer.

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 308M**.
 - 5. Welding Rods and Bare Electrodes: **AWS A5.10/A5.10M**.

- 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/A 36M.
 - 2. Cold-Rolled Sheet and Strip: ASTM A 1008/A 1008M.
 - 3. Hot-Rolled Sheet and Strip: ASTM A 1011/A 1011M.

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. Glazing: Fixed, center-plane system.
 - 3. Provide thermally broken extruded aluminum sill flashing with end dams for storefronts.
 - 4. Provide thermally broken extruded aluminum subframes for exterior storefronts and entrance frames.
 - 5. Provide doors manufactured by storefront system manufacturer.
 - 6. Provide components having face width indicated on Drawings.
- 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.
 - 3. Do not use exposed fasteners, except for hardware application. For hardware application, 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 123M or ASTM A 153/A 153M requirements.
- E. Concealed Flashing: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding flashing compatible with adjacent materials.
- F. Aluminum Break Metal: Form exposed flashing from sheet aluminum finished to match framing and of sufficient thickness, not less than 0.125-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.

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, nonmigrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- D. Provide framing system gaskets, sealants, and joint fillers 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: **1-3/4-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; **3-1/2-inch** nominal width, 10-inch high bottom rail, and 6-inch cross rail.
 - 3. Glazing Stops and Gaskets: Manufacturer's heavy weight removable mullion with weatherstripping, finish to match frame.
 - a. Provide nonremovable 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 manufacturers 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. Ball-Bearing Hinges: Stainless steel with nonremovable pins (NRP) at hinges exposed to outside of exterior doors and to nonsecured side of interior doors.
 - 1. Quantities:
 - a. For doors with heights up to **87** inches, provide 3 hinges per leaf.
 - b. For doors with heights of greater than **87 and up to 120 inches**, provide 4 hinges per leaf.
- C. Removable Mullion Meeting Stile: Provide at exterior doors with weather stripping.
 - 1. Standard: BHMA A156.3.
- D. Weather Stripping: Manufacturer's standard replaceable components.
- 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 **1/2 inch**. Coordinate cutouts for operating hardware with anchors and jamb clips.
 - 1. Material: Aluminum, mill finish.

- G. Balance of Hardware: See Division 8 Section "Finish 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 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 shear-block 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 exterior doors, provide weather sweeps applied to door bottoms and compression weather stripping at fixed stops.

- H. Hardware Installation: Factory install hardware to the greatest extent possible. Cut, drill, and tap for factory-installed and field-installed 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 designating aluminum finishes.
- C. Class II, Clear Anodic Finish: AA-M12C22A31 (Mechanical Finish: nonspecular as fabricated; Chemical Finish: etched, medium matte; Anodic Coating: Architectural Class II, clear coating 0.010 mm or thicker) complying with AAMA 611.

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 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. 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. Secure subframes to opening framing. Caulk exterior perimeter with backer rod and sealant. Caulk around interior perimeter between frame and the air/vapor barrier with backer rod and sealant.
- F. Install components plumb and true in alignment with established lines and grades, without warp or rack.
- G. Install glazing as specified in Division 8 Section "Glazing."
- H. 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.
 - 3. Install hardware furnished in Division 8 Section "Door Hardware."
- I. Install perimeter joint sealants as specified in Division 7 Section "Joint Sealants" and to produce weathertight installation. Color of sealant to match aluminum finish.
- J. 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**.

3.03 ADJUSTING AND CLEANING

- A. Entrances: Adjust operating hardware for smooth operation according to hardware manufacturers' written instructions.
 - 1. Provide tight fit at contact points and weather stripping. Provide smooth operation and weathertight closure. Frame shall be free from distortion.
- B. Remove excess sealant and glazing compounds and dirt from surfaces. Remove nonpermanent labels and clean surfaces.

3.04 PROTECTION

- 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 08411