

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. 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.

- 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.

1.3 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum-framed systems, including anchorage, capable of withstanding, without failure, the effects of the following:

- 1. Thermal movements.
- 2. Movements of supporting structure indicated on Drawings including, but not limited to, story drift and deflection from uniformly distributed and concentrated live loads.
- 3. Dimensional tolerances of building frame and other adjacent construction.
- 4. 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. Glazing-to-glazing contact.
 - e. Noise or vibration created by wind and thermal and structural movements.

- f. Loosening or weakening of fasteners, attachments, and other components.
 - g. Sealant failure.
 - h. Failure of operating units to function properly.
- B. Structural Sealant: Capable of withstanding tensile and shear stresses imposed by aluminum-framed systems without failing adhesively or cohesively. Provide sealant that fails cohesively before sealant releases from substrate when tested for adhesive compatibility with each substrate and joint condition required.
 - 1. Adhesive failure occurs when sealant pulls away from substrate cleanly, leaving no sealant material behind.
 - 2. Cohesive failure occurs when sealant breaks or tears within itself but does not separate from each substrate because sealant-to-substrate bond strength exceeds sealant's internal strength.
- C. Structural-Sealant Joints: Designed to produce tensile or shear stress in structural-sealant joints of less than **20 psi (138 kPa)**.
- D. Structural Loads:
 - 1. Wind Loads: As indicated on Drawings.
 - 2. Seismic Loads: As indicated on Drawings.
- E. 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 (4.1 m)** and to 1/240 of clear span plus **1/4 inch (6.35 mm)** for spans greater than **13 feet 6 inches (4.1 m)** 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 1/360 of clear span or **1/8 inch (3.2 mm)**, whichever is smaller.
- 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 (67 deg C)**, ambient; **180 deg F (100 deg C)**, material surfaces.
 - 2. 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.
 - a. Test High Exterior Ambient-Air Temperature: That which produces an exterior metal-surface temperature of **180 deg F (82 deg C)**.
 - b. Test Low Exterior Ambient-Air Temperature: **0 deg F (minus 18 deg C)**.
 - c. Test Interior Ambient-Air Temperature: **75 deg F (24 deg C)**.
- G. Air Infiltration: Provide aluminum-framed systems with maximum air leakage through fixed glazing and framing areas of **0.06 cfm/sq. ft. (0.03 L/s per sq. m)** of fixed wall area when

tested according to ASTM E 283 at a minimum static-air-pressure difference of **1.57 lbf/sq. ft. (75 Pa)**.

- 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. (300 Pa)**.
- I. Water Penetration Under Dynamic Pressure: Provide aluminum-framed systems that do not evidence water leakage through fixed glazing and framing areas when tested according to AAMA 501.1 under dynamic pressure equal to 20 percent of positive wind-load design pressure, but not less than **6.24 lbf/sq. ft. (300 Pa)**.
 - 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.
- J. 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.
- K. Average Thermal Conductance: Provide aluminum-framed systems with fixed glazing and framing areas having average U-factor of not more than **0.69 Btu/sq. ft. x h x deg F (3.92 W/sq. m x K)** when tested according to AAMA 1503.

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, details, and attachments to other work.
 - 1. Include details of provisions for system expansion and contraction and for draining moisture occurring within the system to the exterior.
 - 2. For entrances, include hardware schedule and indicate operating hardware types, functions, quantities, and locations.
- 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. Fabrication Sample: Of each vertical-to-horizontal intersection of systems, made from **12-inch (300-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.
- F. Welding certificates.
- G. Qualification Data: For Installer.
- H. Preconstruction Sealant Test Reports: For structural-sealant-glazed systems, compatibility and adhesion test reports from sealant manufacturer indicating that materials forming joint substrates and joint-sealant backings have been tested for compatibility and adhesion with sealants. Include sealant manufacturer's interpretation of test results for sealant performance and recommendations for primers and substrate preparation needed to obtain adhesion.
- I. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, for aluminum-framed systems.
- J. Field quality-control test and inspection reports.
- K. Maintenance Data: For aluminum-framed systems to include in maintenance manuals.
- L. 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.
- 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 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.
- C. Preconstruction Sealant Testing: For structural-sealant-glazed systems, perform sealant manufacturer's standard tests for compatibility and adhesion of sealants with each material that will come in contact with sealants and each condition required by aluminum-framed systems.
1. Test a minimum of five samples of each metal, glazing, and other material.
 2. Prepare samples using techniques and primers required for installed systems.
 3. For materials that fail tests, determine corrective measures required to prepare each material to ensure compatibility with and adhesion of sealants, including, but not limited to, specially formulated primers. After performing these corrective measures on the minimum number of samples required for each material, retest materials.

- 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)."
- 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: Five 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. Manufacturers: Subject to compliance with requirements, provide products by one of the following:

- B. Basis-of-Design Product: The design for aluminum-framed systems is based on. Subject to compliance with requirements, provide the named product or a comparable product by one of the following:
1. EFCO Corporation.
 2. Kawneer.
 3. Tubelite Inc.
 4. 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** (**ASTM B 209M**).
 2. Extruded Bars, Rods, Profiles, and Tubes: **ASTM B 221** (**ASTM B 221M**).
 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.

2.3 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: High-performance plastic connectors separate framing members exposed to the exterior from members exposed to the interior.
- 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. Use exposed fasteners with countersunk Phillips screw heads, finished to match framing system.

- 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. 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: As specified in Division 8 Section "Glazing."
- B. Glazing Gaskets: Manufacturer's standard compression types, replaceable, molded or extruded, that maintain uniform pressure and watertight seal.
- C. Spacers and Setting Blocks: Manufacturer's standard elastomeric types.
- D. Glazing Sealants: For structural-sealant-glazed systems, as recommended by manufacturer for joint type and as follows:
 - 1. Structural Sealant: ASTM C 1184, neutral-curing silicone formulation compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant, and approved by structural-sealant manufacturer for use in aluminum-framed systems indicated.
 - a. Color: As selected by Architect from manufacturer's full range of colors.
 - 2. Weatherseal Sealant: ASTM C 920 for Type S, Grade NS, Class 25, Uses NT, G, A, and O; neutral-curing silicone formulation compatible with structural sealant and other system components with which it comes in contact; and recommended by structural- and weatherseal-sealant and aluminum-framed system manufacturers for this use.
 - a. Color: Matching structural sealant.

2.5 DOORS

- A. Doors: Manufacturer's standard glazed doors, for manual swing operation.
 - 1. Door Construction: **1-3/4-inch (44.5-mm)** overall thickness, with minimum **0.125-inch (3.2-mm)** 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.
 - a. Thermal Construction: High-performance plastic connectors separate aluminum members exposed to the exterior from members exposed to the interior.
 - 2. Door Design: As indicated on drawings.

3. Glazing Stops and Gaskets: Square, snap-on, extruded-aluminum stops and preformed gaskets.
 - a. Provide nonremovable glazing stops on outside of door.

2.6 DOOR HARDWARE

- A. General: Provide heavy-duty units in sizes and types recommended by entrance system and hardware manufacturers for entrances and uses indicated.
 1. Opening-Force Requirements:
 - a. Egress Doors: Not more than 30 lbf (133 N) required to set door in motion and not more than 15 lbf (67 N) required to open door to minimum required width.
 - b. Accessible Interior Doors: Not more than 5 lbf (22.2 N).
 2. References to BHMA Standards: Provide products complying with standards referenced in this Article and with requirements for description, quality, type, and function listed in the Door Hardware Schedule at the end of Part 3.
- B. Ball-Bearing Butts:
 1. Standard: BHMA A156.1, Grade 1, radius corner.
 2. Provide nonremovable pins at hinges exposed to outside of door.
 3. Provide nonferrous hinges where hinges are exposed to weather.
 4. Quantities:
 - a. For doors with heights up to 87 inches 2210 mm, provide 3 hinges per leaf.
 - b. For doors with heights of greater than 87 and up to 120 inches (2210 and up to 3048 mm), provide 4 hinges per leaf.
- C. Balanced-Door Hinge Assembly: Manufacturer's standard mechanism with balancing guide roller and top- and bottom-sealed, self-aligning, antifriction bearings, arms, and pivots.
 1. Steel Hinge Tube: Concealed in jamb.
 2. Clear-Opening Width: Reduction of clear-opening width by hinge assembly limited to 3 inches (76 mm) plus door thickness.
- D. Locking Devices, General: Do not require use of key, tool, or special knowledge for operation.
 1. Opening-Force Requirements:
 - a. Delayed-Egress Locks: Lock releases within 15 seconds after applying a force of not more than 15 lbf (67 N) for not more than 3 seconds.
 - b. Latches and Exit Devices: Not more than 15 lbf (67 N) required to release latch.
- E. Mortise Auxiliary Locks: BHMA A156.5, Grade 1.
- F. Panic Exit Devices: Listed and labeled by a testing and inspecting agency acceptable to authorities having jurisdiction, for panic protection, based on testing according to UL 305.

1. Standard: BHMA A156.3, Grade 1.
- G. Cylinders: As specified in Division 8 Section "Door Hardware."
- H. Strikes: Provide strike with black-plastic dust box for each latch or lock bolt; fabricated for aluminum framing.
- I. Operating Trim: BHMA A156.6.
- J. Closers: With accessories required for a complete installation, sized as required by door size, exposure to weather, and anticipated frequency of use, and adjustable to meet field conditions and requirements for opening force.
 1. Standard: BHMA A156.4, Grade 1.
- K. Door Stops: BHMA A156.16, Grade 1, floor or wall mounted, as appropriate for door location indicated, with integral rubber bumper.
- L. Weather Stripping: Manufacturer's standard replaceable components.
 1. Compression Type: Made of ASTM D 2000, molded neoprene, or ASTM D 2287, molded PVC.
- M. Weather Sweeps: Manufacturer's standard exterior-door bottom sweep with concealed fasteners on mounting strip.
- N. Thresholds: Raised thresholds beveled with a slope of not more than 1:2, with maximum height of 1/2 inch (13 mm).
 1. Standard: BHMA A156.21.
- O. Finger Guards: Manufacturer's standard collapsible neoprene or PVC gasket anchored to frame hinge-jamb at center-pivoted doors.

2.7 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 (0.762-mm) thickness per coat.

2.8 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 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.

2.9 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 (3-Coat Fluoropolymer): AA-C12C40R1x (Chemical Finish: cleaned with inhibited chemicals; Chemical Finish: conversion coating; Organic Coating: manufacturer's standard 3-coat, thermocured system consisting of specially formulated inhibitive primer, fluoropolymer color coat, and clear fluoropolymer topcoat, with both color coat and clear 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 manufacturers' written instructions.

1. Color and Gloss: Match Architect's sample.

2.10 SOURCE QUALITY CONTROL

- A. Structural-Sealant-Glazed Systems: Perform quality-control procedures complying with ASTM C 1401 recommendations including, but not limited to, system material qualification procedures, sealant testing, and system fabrication reviews and checks.

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. Install glazing as specified in Division 8 Section "Glazing."
- G. 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.
- H. Install perimeter joint sealants as specified in Division 7 Section "Joint Sealants" and to produce weathertight installation.
- I. 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 (3 mm in 3.7 m)**; **1/4 inch (6 mm)** over total length.
 - 2. Alignment:
 - a. Where surfaces abut in line, limit offset from true alignment to **1/16 inch (1.5 mm)**.
 - b. Where surfaces meet at corners, limit offset from true alignment to **1/32 inch (0.8 mm)**.
 - 3. Diagonal Measurements: Limit difference between diagonal measurement to **1/8 inch (3 mm)**.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified independent testing and inspecting agency to perform field tests and inspections and prepare test reports.
- B. Testing Services: Testing and inspecting of representative areas to determine compliance of installed systems with specified requirements shall take place as follows and in successive stages as indicated on Drawings. Do not proceed with installation of the next area until test results for previously completed areas show compliance with requirements.
 - 1. Air Infiltration: Areas shall be tested for air leakage of 1.5 times the rate specified for laboratory testing under Part 1 "Performance Requirements" Article, but not more than **0.09 cfm/sq. ft. (0.03 L/s per sq. m)**, of fixed wall area when tested according to ASTM E 783 at a minimum static-air-pressure difference of **1.57 lbf/sq. ft. (75 Pa)**.
 - 2. Water Penetration: Areas shall be tested according to ASTM E 1105 at a minimum uniform and cyclic static-air-pressure difference of 0.67 times the static-air-pressure difference specified for laboratory testing under Part 1 "Performance Requirements"

Article, but not less than **4.18 lbf/sq. ft. (200 Pa)**, and shall not evidence water penetration.

3. Water Spray Test: Before installation of interior finishes has begun, a minimum area of **75 feet (23 m)** by 1 story of aluminum-framed systems designated by Architect shall be tested according to AAMA 501.2 and shall not evidence water penetration.
- C. Repair or remove work where test results and inspections indicate that it does not comply with specified requirements.
- D. Additional testing and inspecting, at Contractor's expense, will be performed to determine compliance of replaced or additional work with specified requirements.

3.4 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 3second closer sweep period for doors to move from a 70-degree open position to **3 inches (75 mm)** from the latch measured to the leading door edge.

END OF SECTION 08411