

**SECTION 08 41 13**  
**ALUMINUM-FRAMED ENTRANCES AND STOREFRONTS**

**PART 1 - GENERAL**

**1.1 DESCRIPTION:**

This section specifies aluminum entrance work including storefront construction exterior sliding doors and interior "ICU" type sliding doors, and other components to make a complete assembly.

**1.2 RELATED WORK:**

- A. Receiver for windows: Section 07 40 00 SIDING PANELS.
- B. Glass and Glazing: Section 08 80 00, GLAZING.
- C. Hardware: Section 08 71 00, DOOR HARDWARE.
- D. Automatic Door Operators: Section 08 71 13, AUTOMATIC DOOR OPERATORS.
- E. Texture and color of finish: Section 09 06 00, SCHEDULE FOR FINISHES.

**1.3 SUBMITTALS:**

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Shop Drawings: (1/2 full scale) showing construction, anchorage, reinforcement, and installation details.
- C. Manufacturer's Literature and Data:
  - 1. Doors, each type.
  - 2. Entrance and Storefront construction.
- D. Samples:
  - 1. Door corner section, 450 mm x 450 mm (18 x 18 inches), of each door type specified, showing vertical and top hinge edges, door closer reinforcement, and internal reinforcement.
  - 2. Two samples of anodized aluminum of each color showing finish and maximum shade range.
- E. Manufacturer's Certificates:
  - 1. Stating that aluminum has been given specified thickness of anodizing.
  - 2. Indicating manufacturer's qualifications specified.

**1.4 QUALITY ASSURANCE:**

- A. Approval by Contracting Officer is required of products of proposed manufacturer, or supplier, and will be based upon submission by Contractor certification.
- B. Certify manufacturer regularly and presently manufactures aluminum entrances and storefronts as one of their principal products.

**1.5 DELIVERY, STORAGE AND HANDLING:**

- A. Deliver aluminum entrance and storefront material to the site in packages or containers; labeled for identification with the manufacturer's name, brand and contents.
- B. Store aluminum entrance and storefront material in weather-tight and dry storage facility.
- C. Protect from damage from handling, weather and construction operations before, during and after installation.

**1.6 APPLICABLE PUBLICATIONS:**

- A. The publications listed below form a part of this specification to the extent referenced. The publications are referenced in the text by the basic designation only.
- B. American Society for Testing and Materials (ASTM):
  - B209-06.....Aluminum and Aluminum-Alloy Sheet and Plate
  - B221-05.....Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Shapes, and Tubes
  - E283-04.....Rate of Air Leakage Through Exterior Windows, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen
  - E331-00.....Water Penetration of Exterior Windows, Curtain Walls, and Doors by Uniform Static Air Pressure Difference
  - F468-06.....Nonferrous Bolts, Hex Cap Screws, and Studs for General Use
  - F593-04.....Stainless Steel Bolts, Hex Cap Screws, and Studs
- C. National Association of Architectural Metal Manufacturers (NAAMM):
  - AMP 500 Series.....Metal Finishes Manual
- D. American Architectural Manufacturer's Association (AAMA):
  - 2604-05.....High Performance Organic Coatings on Architectural Aluminum Extrusions and Panels
- E. American Welding Society (AWS):
  - D1.2-03.....Structural Welding Code Aluminum

**1.7 PERFORMANCE REQUIREMENTS:**

- A. Shapes and thickness of framing members shall be sufficient to withstand blast design requirements, as noted in the "Blast Resistance Analysis Results - Blast Narrative", dated March 28, 2012 and found in the Project Manual Appendix.

- B. Air Infiltration: When tested in accordance with ASTM E 283, air infiltration shall not exceed  $2.63 \times 10^{-5}$  cm per square meter (0.06 cubic feet per minute per square foot) of fixed area at a test pressure of 0.30 kPa (6.24 pounds per square foot) 80 kilometers (50 mile) per hour wind.
- C. Water Penetration: When tested in accordance with ASTM E 331, there shall be no water penetration at a pressure of 0.38 kPa (8 pounds per square foot) of fixed area.

## **PART 2 - PRODUCTS**

### **2.1 MATERIALS:**

- A. Aluminum, ASTM B209 and B221:
  - 1. Alloy 6063 temper T5 for doors, door frames, fixed glass sidelights, storefronts, and transoms.
  - 2. Alloy 6061 temper T6 for guide tracks for sliding doors and other extruded structural members.
  - 3. For color anodized finish, use aluminum alloy as required to produce specified color.
- B. Thermal Break: Manufacturer standard low conductive material retarding heat flow in the framework, where insulating glass is scheduled.
- C. Fasteners:
  - 1. Aluminum: ASTM F468, Alloy 2024.
  - 2. Stainless Steel: ASTM F593, Alloy Groups 1, 2 and 3.

### **2.2 FABRICATION:**

- A. Fabricate doors, of extruded aluminum sections not less than 3 mm (0.125 inch) thick. Fabricate glazing beads of aluminum not less than 1.0 mm (0.050 inch) thick.
- B. Accurately form metal parts and accurately fit and rigidly assemble joints, except those joints designed to accommodate movement. Seal joints to prevent leakage of both air and water.
- C. Make welds in aluminum in accordance with the recommended practice AWA D1.2. Use electrodes and methods recommended by the manufacturers of the metals and alloys being welded. Make welds behind finished surfaces so as to cause no distortion or discoloration of the exposed side. Clean welded joints of welding flux and dress exposed and contact surfaces.

- D. Make provisions in doors and frames to receive the specified hardware and accessories. Coordinate schedule and template for hardware specified under Section 08 71 00, DOOR HARDWARE. Where concealed closers or other mechanisms are required, provide the necessary space, cutouts, and reinforcement for secure fastening.
- E. Fit and assemble the work at the manufacturer's plant. Mark work that cannot be permanently plant-assembled to assure proper assembly in the field.

### **2.3 PROTECTION OF ALUMINUM:**

- A. Isolate aluminum from contact with dissimilar metals other than stainless steel, white bronze, or zinc by any of the following:
  - 1. Coat the dissimilar metal with two coats of heavy-bodied alkali resistant bituminous paint.
  - 2. Place caulking compound, or non-absorptive tape, or gasket between the aluminum and the dissimilar metal.
  - 3. Paint aluminum in contact with mortar, concrete and plaster, with a coat of aluminum paint primer.

### **2.4 FRAMES:**

- A. Fabricate doors, frames, mullions, transoms, frames for fixed glass and similar members from extruded aluminum not less than 3 mm (0.125 inch) thick.
- B. Provide integral stops and glass rebates and applied snap-on type trim.
- C. Use concealed screws, bolts and other fasteners. Secure cover boxes to frames in back of all lock strike cutouts.
- D. Fabricate framework with thermal breaks in frames where insulating glass is scheduled and specified under Section 08 80 00, GLAZING.

### **2.5 STILE AND RAIL DOORS:**

- A. Nominal 45 mm (1-3/4 inch) thick, with stile and head rail 90 mm (3-1/2 inches) wide, and bottom rail 250 mm (10 inches) wide.
- B. Construct doors with a system of welded joints or interlocking dovetail joints between stiles and rails. Clamp door together through top and bottom rails with 9 mm (3/8 inch) primed steel rod extending into the stiles, and having a self-locking nut and washer at each end. Reinforce stiles and rails to prevent door distortion when tie rods are tightened. Provide a compensating spring-type washer under each nut to take up any stresses that may develop. Construct joints between rails and stiles to remain rigid and tight when door is operated.

- C. Weather-stripping: For exterior sliding doors and as noted on drawings. Provide removable, woven pile type (silicone-treated) weather-stripping attached to aluminum or vinyl holder. Make slots for applying weather-stripping integral with doors and door frame stops. Apply continuous weather-stripping to heads, jambs, bottom, and meeting stiles of doors and frames. Install weather-stripping so doors can slide freely and close positively.
- D. Threshold:  $\frac{1}{2}$ " high x 4  $\frac{1}{2}$ " wide with square edge on interior and tapered edge on exterior.

## **2.6 FLUSH PANELS:**

- A. Nominal 45 mm (1-3/4 inches) thick. Form from aluminum face sheets not less than 1.5 mm (0.060 inch) thick with internal impact reinforcement, laminated to the edges and the core.
- B. Provide extruded aluminum tubular members to form the perimeter of the panel. Reinforce internally with extruded tubular members welded in place, and extending full width of door at top, bottom, and intermediate points.
- C. Fill voids between tubular members with noncombustible mineral insulation.

## **2.7 ICU SLIDERS:**

- A. Door to operate without use of bottom track.
- B. Breakout Feature: Slide-swing panels must swing out 90° after positive latching and flush bolts are released. Door must be in full open position before panels can swing out and require no more than 50 lbf. (222 N) of force applied at the strike stile to open.
  - 1. Breakout mechanism shall provide support across full width of the door, in normal operating mode. In breakout mode, torsion assembly shall support weight of the door to minimize drop.
  - 2. Slide-swing panels shall include intermediate horizontal rail.
- C. Smoke Limiting Air Infiltration Rating: Units tested and certified to be in compliance with UL 1784. Maximum leakage rate at ambient temperature shall be less than 1 CFM/ft<sup>2</sup> of opening at 0.3 in. of water. At 400°F the rate of leakage shall be less than 1 CFM/ft<sup>2</sup> of opening at 0.3 in. of water.
- D. Self-Closing Mechanism: Provide self-closing mechanism and smoke limiting seals where indicated on the drawings. Mechanism shall be mechanical requiring no electrical power and shall be fully concealed within header. Coiled spring under tension attached to sliding door

shall work with hydraulic damper to provide adjustable 6-8 lbs of closing force. Manual opening force shall not exceed 12 lbs.

1. Standard Hold-Open:

- a. Shall be engaged when 8-12 lbs. of force is applied to door panel in full open position.
  - b. Shall be disengaged when 6-8 lbs. of force is applied to door panel.
- E. Provide positive latch option for all doors located within smoke limiting partitions. Partition locations are noted on the drawings.

**2.8 REINFORCEMENT FOR BUILDERS HARDWARE:**

- A. Fabricate from stainless steel plates.
- B. Hinge and pivot reinforcing: 4.55 mm (0.1793 inch) thick.
- C. Reinforcing for lock face, flush bolts, concealed holders, concealed or surface mounted closers: 2.66 mm (0.1046 inch) thick.
- D. Reinforcing for all other surface mounted hardware: 1.5 mm (0.0598 inch) thick.

**2.9 EMERGENCY EGRESS:**

- A. Slide-Swing panels to swing out 90° and require no more than 50lb (222N) of force applied at strike stile to open.

**2.10 FINISH**

- A. In accordance with NAAMM AMP 500 series.
- B. Anodized Aluminum:
  - 1. Clear Finish: Chemically etched medium matte, with clear anodic coating, Class I Architectural, 7 mils thick.

**PART 3 - EXECUTION**

**3.1 INSTALLATION:**

- A. Allowable Installation Tolerances: Install work plumb and true, in alignment and in relation to lines and grades shown. Variation of 3 mm (1/8 inch) in 2400 mm (eight feet), non-accumulative, is maximum permissible for plumb, level, warp, bow and alignment.
- B. Anchor aluminum frames to adjoining construction at heads, jams and bottom and to steel supports, and bracing. Anchor frames with stainless steel or aluminum countersunk flathead, expansion bolts or machine screws, as applicable. Use aluminum clips for internal connections of adjoining frame sections.

- C. Where work is installed within masonry or concrete openings, place no parts other than built-in anchors and provision for operating devices located in the floor, until after the masonry or concrete work is completed.
- D. Install hardware specified under Section 08 71 00, DOOR HARDWARE.
- E. Install door operators specified under Section 08 71 13, AUTOMATIC DOOR OPERATORS.

### **3.2 ADJUSTING:**

After installation of entrance and storefront work is completed, adjust and lubricate operating mechanisms to insure proper performance.

### **3.3 PROTECTION, CLEANING AND REPAIRING:**

Remove all mastic smears and other unsightly marks, and repair any damaged or disfiguration of the work. Protect the installed work against damage or abuse.

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