

SECTION 08 51 13 - ALUMINUM WINDOWS

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section includes aluminum windows for exterior locations.
- B. Related Requirements:
 - 1. Section 05 40 00 "Cold-Formed Metal Framing" for exterior metal stud support for aluminum windows.
 - 2. Section 07 11 13 "Bituminous Dampproofing" for installation of air-water barriers and secondary flashing to aluminum windows.
 - 3. Section 07 92 00 "Joint Sealants".
 - 4. Section 08 41 13 "Aluminum-Framed Entrances and Storefronts" for coordinating finish among aluminum fenestration units.

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA 101/I.S.2/NAFS:
 - 1. AW: Architectural.
 - 2. HC: Heavy Commercial.
 - 3. C: Commercial.
 - 4. LC: Light Commercial.
 - 5. R: Residential.
- B. Performance grade number according to AAMA/WDMA 101/I.S.2/NAFS:
 - 1. Design pressure number in pounds force per square foot (pascals) used to determine the structural test pressure and water test pressure.
- C. Structural Test Pressure: For uniform load structural test, is equivalent to 150 percent of the design pressure.
- D. Minimum Test Size: Smallest size permitted for performance class (gateway test size). Products must be tested at minimum test size or at a size larger than minimum test size to comply with requirements for performance class.

1.4 PERFORMANCE REQUIREMENTS

- A. General: Provide aluminum windows capable of complying with performance requirements indicated, based on testing manufacturer's windows that are representative of those specified, and that are of minimum test size indicated below:

1. Size required by AAMA/WDMA 101/I.S.2/NAFS for optional performance grade gateway performance for both gateway performance and optional performance grade.
 2. Size indicated on Drawings.
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for Project that pass AAMA/WDMA 101/I.S.2/NAFS, Uniform Load Structural Test:
1. Design Wind Loads: Determine design wind loads applicable to Project from basic wind speed indicated in miles per hour (meters per second) at 33 feet (10 m) above grade, according to ASCE 7, Section 6.5, "Method 2-Analytical Procedure," based on mean roof heights above grade indicated on Drawings.
 - a. Basic Wind Speed: 100 mph.
 - b. Importance Factor: I.
 - c. Exposure Category: C.
 2. Deflection: Design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch (19 mm), whichever is less, at design pressure based on testing performed according to AAMA/WDMA 101/I.S.2/NAFS, Uniform Load Deflection Test or structural computations.
- C. **Thermal Movements:** Provide aluminum windows, including anchorage, that allow for thermal movements resulting from the following maximum change (range) in ambient and surface temperatures by preventing buckling, opening of joints, overstressing of components, failure of joint sealants, failure of connections, and other detrimental effects. 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.

1.5 SUBMITTALS

- A. Product Data: Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions for each type of aluminum window indicated.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances, installation details, and the following:
1. Mullion details, including reinforcement and stiffeners.
 2. Joinery details.
 3. Expansion provisions.
 4. Flashing and drainage details.
 5. Weather-stripping details.
 6. Thermal-break details.
 7. Glazing details.
 8. Window cleaning provisions.
 9. Window System Operators: Show locations, mounting, and details for installing operator components and controls.

10. Window System Operators: Show locations and details for installing operator components, switches, and controls. Indicate motor size, electrical characteristics, drive arrangement, mounting, and grounding provisions.
 11. Wiring Diagrams: Power, signal, and control wiring.
 12. For installed products indicated to comply with design loads, include structural analysis data prepared by or under the supervision of a qualified professional engineer detailing fabrication and assembly of aluminum windows and used to determine the following:
 - a. Structural test pressures and design pressures from wind loads indicated.
 - b. Deflection limitations of glass framing systems.
- C. **Product Schedule:** For aluminum windows. Use same designations indicated on Drawings.
- D. Maintenance Data: For operable window sash, operating hardware weather stripping, and finishes to include in maintenance manuals.
- E. Warranty: Special warranty specified in this Section.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer acceptable to aluminum window manufacturer for installation of units required for this Project.
1. Installer's responsibilities include providing professional engineering services needed to assume responsibility.
 2. Engineering Responsibility: Preparation of data for aluminum windows, including Shop Drawings, based on testing and engineering analysis of manufacturer's standard units in assemblies similar to those indicated for this Project.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion in lists and by labels, test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- D. Product Options: Information on Drawings and in Specifications establishes requirements for aluminum windows' 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.
- E. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 1 Section "Product Requirements." Do not modify size and dimensional requirements.
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.

- F. Fenestration Standard: Comply with AAMA/WDMA 101/I.S.2/NAFS, "North American Fenestration Standard Voluntary Performance Specification for Windows, Skylights and Glass Doors," for definitions and minimum standards of performance, materials, components, accessories, and fabrication. Comply with more stringent requirements if indicated.
 - 1. Provide AAMA/WDMA-certified aluminum windows with an attached label.
- G. Glazing Publications: Comply with published recommendations of glass manufacturers and with GANA's "Glazing Manual" unless more stringent requirements are indicated.
- H. Preinstallation Conference: Conduct conference at Project site to comply with requirements in Division 1 Section "Project Management and Coordination." Review methods and procedures related to aluminum windows including, but not limited to, the following:
 - 1. Review and finalize construction schedule and verify availability of materials, Installer's personnel, equipment, and facilities needed to make progress and avoid delays.
 - 2. Review and discuss the finishing of aluminum windows that is required to be coordinated with the finishing of other aluminum work for color and finish matching.
 - 3. Review, discuss, and coordinate the interrelationship of aluminum windows with other exterior wall components. Include provisions for structural anchorage, glazing, flashing, weeping, sealants, and protection of finishes.
 - 4. Review and discuss the sequence of work required to construct a watertight and weathertight exterior building envelope.
 - 5. Inspect and discuss the condition of substrate and other preparatory work performed by other trades.

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify aluminum window openings 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 opening dimensions and proceed with fabricating aluminum windows without field measurements. Coordinate wall construction to ensure that actual opening dimensions correspond to established dimensions.

1.8 WARRANTY

- A. Special Warranty: Manufacturer's standard form in which manufacturer agrees to repair or replace aluminum windows that fail in materials or workmanship within specified warranty period.
 - 1. Failures include, but are not limited to, the following:
 - a. Failure to meet performance requirements.
 - b. Structural failures including excessive deflection, water leakage, air infiltration, or condensation.
 - c. Faulty operation of movable sash and hardware.
 - d. Deterioration of metals, other materials, and metal finishes beyond normal weathering.
 - e. Failure of insulating glass.

- f. Warranty Period:
- 2. Verify available warranties for units and components and retain or insert numbers in subparagraphs below.
 - a. Window: Two years from date of Substantial Completion.
 - b. Glazing: Five years from date of Substantial Completion.
 - c. Metal Finish: Five years from date of Substantial Completion.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis of Design Product: Subject to compliance with requirements, provide RAM Windows, Houston, Texas, thermally-broken, fixed and casement aluminum windows with low-e insulating glass, in sizes and configurations indicated on the Drawings, or equivalent approved by Architect.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish, but not less than 22,000-psi (150-MPa) ultimate tensile strength, not less than 16,000-psi (110-MPa) minimum yield strength, and not less than 0.062-inch (1.6-mm) thickness at any location for the main frame and sash members.
- B. Fasteners: Aluminum, nonmagnetic stainless steel, epoxy adhesive, or other materials warranted by manufacturer to be noncorrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
 - 1. Reinforcement: Where fasteners screw anchor into aluminum less than 0.125 inch (3.2 mm) thick, reinforce interior with aluminum or nonmagnetic stainless steel to receive screw threads, or provide standard, noncorrosive, pressed-in, splined grommet nuts.
 - 2. Exposed Fasteners: Unless unavoidable for applying hardware, do not use exposed fasteners. For application of hardware, use fasteners that match finish of member or hardware being fastened, as appropriate.
- C. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- D. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Bulb-Type Weather Stripping: Provide manufacturers standard bulb-type weather stripping of silicone, neoprene, or polyvinyl chloride. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, nonshrinking, and nonmigrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Fixed and Casement, in sizes and configurations indicated on Drawings.
- B. AAMA/WDMA Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA 101/I.S.2/NAFS.
 - 1. Performance Class and Grade: LC 35.
- C. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, showing a CRF of 45.
- D. Thermal Transmittance: Provide aluminum windows with a whole-window, U-factor maximum indicated at 15-mph (24-km/h) exterior wind velocity and winter condition temperatures when tested according to AAMA 1503 ASTM E 1423.
 - 1. U-Factor: 0.35 Btu/sq. ft. x h x deg F or less.
- E. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC maximum of 0.55, determined according to NFRC 200 procedures.
- F. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA 101/I.S.2/NAFS, Air Infiltration Test.
 - 1. Maximum Rate: 0.3 cfm/sq. ft. (5 cu. m/h x sq. m) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa).
- G. Water Resistance: No water leakage as defined in AAMA/WDMA referenced test methods at a water test pressure equaling that indicated, when tested according to AAMA/WDMA 101/I.S.2/NAFS, Water Resistance Test.
 - 1. Test Pressure: 20 percent of positive design pressure, but not more than 15 lbf/sq. ft. (720 Pa).
- H. Forced-Entry Resistance: Comply with Performance Grade 20 requirements when tested according to ASTM F 588.

2.4 GLAZING

- A. Glazing System: Manufacturer's standard factory-glazing system that produces weathertight seal and complies with the requirements of the window performance classification specified.

2.5 FABRICATION

- A. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- B. Fabricate aluminum windows that are reglazable without dismantling sash or ventilator framing.

- C. Provide thermal-break construction that has been in use for not less than three years and has been tested to demonstrate resistance to thermal conductance and condensation and to show adequate strength and security of glass retention.
- D. Provide thermal barriers tested according to AAMA 505; determine the allowable design shear flow per the appendix in AAMA 505.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash and ventilator.
- F. Weep Holes: Provide weep holes and internal passages to conduct infiltrating water to exterior.
- G. Provide water-shed members above side-hinged ventilators and similar lines of natural water penetration.
- H. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 8 Section "Glazing" and with AAMA/WDMA 101/I.S.2/NAFS.

2.6 FINISHES, GENERAL

- A. Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.

2.7 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- B. Organic Coating Aluminum Finish: All aluminum exposed to view shall be given manufacturer's standard baked-on acrylic paint, minimum 0.8 mil dry film thickness, color to match approved sample; complying with "Performance Requirements and Test Procedure for Pigmented Organic Coatings on Extruded Aluminum", AAMA 603.7.
 - 1. Color: As selected by Architect from manufacturers full range of available colors.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine openings, substrates, structural support, anchorage, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of work. Verify rough opening dimensions, levelness of sill plate, and operational clearances. Examine wall flashings, vapor retarders, water and weather barriers, and other built-in components to ensure a coordinated, weathertight window installation.
- B. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
- C. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. Comply with Drawings, Shop Drawings, and manufacturer's written instructions for installing windows, hardware, accessories, and other components.
- B. Install windows level, plumb, square, true to line, without distortion or impeding thermal movement, anchored securely in place to structural support, and in proper relation to wall flashing and other adjacent construction.
- C. Set sill members in bed of sealant or with gaskets, as indicated, for weathertight construction.
- D. Install windows and components to drain condensation, water penetrating joints, and moisture migrating within windows to the exterior.
- E. Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials.

3.3 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes and ventilators, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weathertight closure. Lubricate hardware and moving parts.
- B. Clean aluminum surfaces immediately after installing windows. Avoid damaging protective coatings and finishes. Remove excess sealants, glazing materials, dirt, and other substances.
- C. Clean factory-glazed glass immediately after installing windows. Comply with manufacturer's written recommendations for final cleaning and maintenance. Remove nonpermanent labels, and clean surfaces.
- D. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.
- E. Protect window surfaces from contact with contaminating substances resulting from construction operations. In addition, monitor window surfaces adjacent to and below exterior concrete and masonry surfaces during construction for presence of dirt, scum, alkaline deposits, stains, or other contaminants. If contaminating substances do contact window surfaces, remove contaminants immediately according to manufacturer's written recommendations.

END OF SECTION 08 51 13