

SECTION 085113 ALUMINUM WINDOWS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) "Manual of Practice," including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI, AIA, USGBC nor ILFI endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the "Conditions of the Contract," published by the AIA.

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: Kawneer Architectural Aluminum Windows including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of window units.
1. Types of aluminum windows include:
 - a. Kawneer Series AA®5450 Ultra Thermal (Standard Face)
 - b. Kawneer Series AA®5450 Ultra Thermal (Beveled Face)
 - c. Side load double hung (AW-PG65-H)
- EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 2.07 SOURCE QUALITY CONTROL.*
- B. Related Sections:
1. 072700 "Air Barriers" for materials used to bridge between aluminum sliding glass door and building intersection
 2. 079200 "Joint Sealants" for joint sealants installed as part of the aluminum sliding door system
 3. 083213 "Sliding Aluminum-Framed Glass Doors"
 4. 084113 "Aluminum-Framed Entrances and Storefronts"
 5. 084313 "Aluminum-Framed Storefronts"
 6. 084329 "Sliding Storefronts"
 7. 084413 "Glazed Aluminum Curtain Walls"
 8. 084433 "Sloped Glazing Assemblies"
 9. 086300 "Metal-Framed Skylights"

1.3 DEFINITIONS

- A. Performance class designations according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
1. AW: Architectural Window
- B. Performance grade number according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS):
1. Design pressure number in pounds force per square foot 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. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).
- E. Minimum Test Size: Smallest gateway test size permitted for performance class. 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/CSA 101/I.S.2/A440 (NAFS) for minimum gateway performance.
 2. Test size: 60" x 99"
- B. Structural Performance: Provide aluminum windows capable of withstanding the effects of the following loads, based on testing units representative of those indicated for the Project that pass AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Uniform Load Structural Test:

EDITOR NOTE: PROVIDE THE INFORMATION BELOW TO DETERMINE THE REQUIRED PROJECT DESIGN LOAD (IN PSF).

1. Design Wind Loads: Determine design wind loads applicable to the Project from basic wind speed indicated in miles per hour, 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 (MPH): (_____)
 - b. Importance Factor (I, II, III): (_____)
 - c. Exposure Category (A,B,C,D): (_____)
 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/CSA 101/I.S.2/A440 (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 (____) 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.

EDITOR NOTE: SELECT (STANDARD FACE) OR (BEVELED FACE) FROM BELOW.

AA®5450 (Standard Face)

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1-1/2" TRIPLE GLAZED HIGH PERFORMANCE (HP) INSULATING GLASS UNITS WITH LOW-E ON #3 AND #5 SURFACES, ARGON FILLED, AND WARM EDGE SPACER. REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORS, SHGC AND VT. REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

- D. Condensation-Resistance Factor (CRF): Provide aluminum windows tested for thermal performance according to AAMA 1503, with a CRF not less than 71 (frame) and 76 (glass).
- E. Temperature Index (I): Provide aluminum windows tested for thermal performance according to CSA-A440 with a Temperature Index not less than 40 (frame), 74 (glass).
- F. Energy Efficiency:
 1. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 - a. 1" (25.4mm) insulating glass with exterior 3/16" (4.76 mm) annealed clear glass, aluminum spacer, and interior 3/16" (4.76 mm) annealed clear glass.
 - 1) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a 10 lb. Sill.
 - 2) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a 15 lb. Sill.
 - b. 1-1/2" (38.1 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - 1) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a 10 lb. Sill.
 - 2) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.39 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a 15 lb. Sill.
- G. Solar Heat-Gain Coefficient (SHGC): Provide aluminum windows with a whole-window SHGC as determined according to NFRC 200 and AAMA 507 procedures.
- H. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS), Air Infiltration Test.
 1. Maximum Rate: 0.3 cfm/sq. ft. (0.5 L/s•m²) of area at an inward test pressure of 6.24 lbf/sq. ft. (300 Pa) in accordance with ASTM E283.
- I. Water Resistance: No water leakage as defined in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) referenced test methods at a water test pressure equaling that indicated, when tested according to ASTM E547 and ASTM E331.
 1. Test Pressure: 20 percent of positive design pressure, but not more than 10 lbf/sq. ft. (478 Pa) with a **10 lb. sill** or 15 lbf/sq. ft. (720 Pa) with a **15 lb. sill**.
- J. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested to AAMA Specification 1801 and in accordance with ASTM E1425 and ASTM E90, the STC and OITC Rating shall not be less than:
 1. 1-1/2" triple insulating glass made with exterior 1/8" soft coat low E glass, thermoplastic butyl spacer, argon gas, center 1/8" soft coat low E glass thermoplastic butyl spacer, argon gas, and interior 1/8" clear glass: 32 (STC) and 25 (OITC)

Laws and building and safety codes governing the design and use of Kawneer products, such as glazed entrance, window, and curtain wall products, vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed Necessary for product improvement.
© 2014, Kawneer Company, Inc.

AA®5450 (Beveled Face)

K. Energy Efficiency:

1. Thermal Transmittance Test (U-Factor): When tested to AAMA specification 1503, AAMA specification 507 or NFRC 100 the thermal transmittance (U-Factor) shall not be more than:
 - a. 1" (25.4mm) insulating glass with exterior 1/8" (4.76 mm) annealed clear glass, aluminum spacer, and interior 1/8" (4.76 mm) annealed clear glass.
 - 1) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a 10 lb. Sill.
 - 2) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.28 to 0.53 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.48) with a 15 lb. Sill.
 - b. 1-1/4" (31.7 mm) insulating glass with exterior 1/8" (3.17 mm) annealed low E glass, aluminum spacer, argon gas, center 1/8" (3.17 mm) low E tempered glass, aluminum spacer, argon gas, and interior 1/8" (3.17 mm) annealed clear glass.
 - 1) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.25 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a 10 lb. Sill.
 - 2) Provide aluminum windows simulated for thermal performance according to AAMA 507 and NFRC 100 with a thermal transmittance (U-Factor) of 0.26 to 0.40 BTU/hr/sf/°F. (Based on center of glass U-Factor range 0.10 to 0.32) with a 15 lb. Sill.

AA®5450 (Standard Face) and AA®5450 (Beveled Face)

- L. Forced-Entry Resistance: Comply with Performance Grade 10 requirements when tested according to ASTM F 588.
- M. Life-Cycle Testing: Test according to AAMA 910 and comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- N. Operating Force and Auxiliary (Durability) Tests: Comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS) for operating window types indicated.
- O. Environmental Product Declarations (EPD): Shall have a Type III Product-Specific EPD created from a Product Category Rule.

1.5 SUBMITTALS

EDITOR NOTE: ADD RECYCLED CONTENT SECTION IF REQUIRED TO MEET PROJECT REQUIREMENTS AND/OR GREEN BUILDING CERTIFICATIONS SUCH AS LEED, LIVING BUILDING CHALLENGE (LBC), ETC. ARE REQUIRED.

*** IF RECYCLED CONTENT REQUIREMENTS ARE NOT SPECIFIED - PRIME (ZERO RECYCLED CONTENT) ALUMINUM COULD BE SUPPLIED.**

- 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.
 1. Recycled Content:
 - a. Provide documentation that aluminum has a minimum of 50% mixed pre- and post-consumer recycled content with a sample document illustrating project specific information that will be provided after product shipment.
 - b. Once product has shipped, provide project specific recycled content information, including:
 - 1) Indicate recycled content; indicate percentage of pre- and post-consumer recycled content per unit of product.
 - 2) Indicate relative dollar value of recycled content product to total dollar value of product included in project.
 - 3) Indicate location recovery of recycled content.
 - 4) Indicate location of manufacturing facility.
 2. Environmental Product Declaration (EPD).
 - a. Include a Type III Product-Specific EPD created from a Product Category Rule.
- B. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other work, operational clearances and installation details.
- C. Samples for Initial Selection: For units with factory-applied color finishes including samples of hardware and accessories involving color selection.
- D. Samples for Verification: For aluminum windows and components required.
- E. Product Schedule: For aluminum windows. Use same designations indicated on Drawings.
- F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency for each type, class, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- G. Maintenance Data: For operable sash, operating hardware and finishes to be include in maintenance manuals.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: An installer which has had successful experiences with installation of the same or similar units required for this project and other projects of similar size and scope.
- B. Manufacturer Qualifications: A manufacturer capable of fabricating aluminum windows that meet or exceed performance requirements indicated and of documenting this performance by inclusion of test reports, and calculations.
- C. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.

- D. Product Options: Drawings indicate size, profiles, and dimensional requirements of aluminum windows and are based on the specific system indicated. Refer to Division 01 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.
- E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
 - 1. Build mockup for type(s) of window(s) indicated, in location(s) shown on Drawings.
- F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section "Project Management and Coordination."

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify actual dimensions of aluminum framed window openings by field measurements before fabrication and indicate field measurements on Shop Drawings.

1.8 WARRANTY

- A. Manufacturer's Warranty: Submit, for Owner's acceptance, manufacturer's standard warranty.
 - 1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Basis-of-Design Product:
 - 1. Kawneer Company Inc.
 - 2. Series AA®5450 Ultra Thermal Double Hung (Standard Face)
 - 3. Series AA®5450 Ultra Thermal Double Hung (Beveled Face)
 - 4. 4 5/8" (117.48 mm) frame depth
 - 5. AW-PG65-H

EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASE-OF-DESIGN PRODUCT.

- B. Subject to compliance with requirements, provide a comparable product by the following:
 - 1. Manufacturer:
 - 2. Series: (_____)
 - 3. Profile dimension: (_____)
 - 4. Performance Grade: (_____)
- C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.
 - 1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.
 - 2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window installation and construction delays.
 - 3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.
 - 4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum windows for a period of not less than ten (10) years. (Company Name)
 - 5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.
 - 6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.
- D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

Laws and building and safety codes governing the design and use of Kawneer products, such as glazed entrance, window, and curtain wall products, vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed Necessary for product improvement.
© 2014, Kawneer Company, Inc.

2.2 MATERIALS

- A. Aluminum Extrusions: Alloy and temper recommended by aluminum window manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" wall thickness at any location for the main frame and sash members.

EDITOR NOTE: ADD RECYCLED CONTENT SECTION IF REQUIRED TO MEET PROJECT REQUIREMENTS AND/OR GREEN BUILDING CERTIFICATIONS SUCH AS LEED, LIVING BUILDING CHALLENGE (LBC), ETC. ARE REQUIRED.

** IF RECYCLED CONTENT REQUIREMENTS ARE NOT SPECIFIED - PRIME (ZERO RECYCLED CONTENT) ALUMINUM COULD BE SUPPLIED.*

1. Recycled Content: Shall have a minimum of 50% mixed pre- and post-consumer recycled content.
 - a. Indicate recycled content; indicate percentage of pre-consumer and post-consumer recycled content per unit of product.
 - b. Indicate relative dollar value of recycled content product to total dollar value of product included in project.
 - c. Indicate location recovery of recycled content.
 - d. Indicate location of manufacturing facility.
- B. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- 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. Sliding-Type Weather Stripping: Provide woven-pile weather stripping of wool, polypropylene, or nylon pile and resin-impregnated backing fabric. Comply with AAMA 701/702.
 1. Weather Seals: Provide weather stripping with integral barrier fin or fins of semi-rigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- F. Sealant: For sealants required within fabricated windows, provide window manufacturer's standard, permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

2.3 WINDOW

- A. Window Type: Double Hung Window
- B. Performance Requirements: Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS)
1. Performance Class and Grade: AW-PG65-H

2.4 GLAZING

- A. Glass and Glazing Materials: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum window units.
- B. Glazing System: Glazing method shall be a wet/dry type in accordance with manufacturer's standards. Exterior glazing shall be silicone back bedding sealant. Interior glazing shall be snap-in type glazing beads and an interior gasket in accordance with AAMA 702 or ASTM C864.

2.5 HARDWARE

- A. General: Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, or other corrosion-resistant material compatible with aluminum; designed to smoothly operate, tightly close, and securely lock aluminum windows, and sized to accommodate sash weight and dimensions.
- B. Double Hung Windows: Provide the following operating hardware:
1. Sash Balances: A Class 5 adjustable spiral balance with stainless steel or other corrosion-resistant components. Two per sash.
 2. Handle: Continuous, integral, bottom and top sash lift handle.
 3. Sash Lock: White bronze sweep lock and keeper on meeting rails. One or two per sash as required by size. Brushed nickel finish.
 4. Aluminum autolock at top sash lift handle.

EDITOR NOTE: INCLUDE OPTIONAL SASH LOCK BASED ON PROJECT REQUIREMENTS.

5. Optional Sash Lock: Spring-loaded, snap-type lock on bottom rail of lower sash.
6. Upper Sash Lock: Spring-loaded, snap-type lock on top rail of upper sash.
7. Limit Device: Sash stop limit device; for bottom and top sash located at jamb; two per sash.

2.6 INSECT SCREENS

- A. General: Design windows and hardware to accommodate screens in a tight-fitting, removable arrangement, with a minimum of exposed fasteners and latches. Fabricate insect screens to fully integrate with window frame. Locate screens on outside of window and provide for each operable exterior sash.

1. Comply with SMA 1004, "Specifications for Aluminum Tubular Frame Screens for Windows," for minimum standards of appearance, fabrication, attachment of screen fabric, hardware, and accessories unless more stringent requirements are indicated.
- B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints or corner extrusions, concealed fasteners and removable PVC spline.
 1. Extruded-Aluminum or Aluminum Tubular Framing Sections and Cross Braces: Not less than 0.050-inch (1.3-mm) wall thickness.
 2. Finish: Manufacturer's standard.

EDITOR NOTE: CHOOSE SCREEN FABRIC FROM BELOW BASED ON PROJECT REQUIREMENTS.

- C. Aluminum Wire Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of 0.011-inch (0.28-mm) diameter, coated aluminum wire.
 1. Wire-Fabric Finish: Charcoal Grey or Natural Brite-Kote.
- D. Glass-Fiber Mesh Fabric: 18-by-16 mesh/inch (18-by-16 mesh/25.4mm) of PVC-coated, glass-fiber threads; woven and fused to form a fabric mesh resistant to corrosion, shrinkage, stretch, impact damage, and weather deterioration; in the following color. Comply with ASTM D 3656.
 1. Mesh Color: Charcoal or Silver Grey.

2.7 FABRICATION

- A. 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 fit joints; make joints flush, hairline and weatherproof.
 3. Means to drain water passing joints, condensation 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.
 7. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
- B. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- C. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- D. Thermally Improved Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; located between exterior materials and window members exposed on interior side; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
 1. Frame thermal barrier shall be polyamide with a minimum of 1" (25.4 mm) separation, installed continuously and mechanically bonded to the aluminum.
 2. Sash thermal barrier shall be polyamide with a minimum of 1/2" (12 mm) separation, installed continuously and mechanically bonded to the aluminum.
- E. Weather Stripping: Provide full-perimeter weather stripping for each operable sash.
- F. Weep Holes: Provide weep holes and internal passages in window frames to conduct infiltrating water to exterior.
- G. Provide water-shed members as required above lines of natural water penetration.
- H. Mullions: Provide mullions and cover plates as shown, matching window units, complete with anchors for support to structure and installation of window units. Allow for erection tolerances and provide for movement of window units due to thermal expansion and building deflections, as indicated. Provide mullions and cover plates capable of withstanding design loads of window units.
- I. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093-inch (2.4-mm) thick extruded aluminum. Miter or cope corners, and join with concealed mechanical joint fasteners. Finish to match window units. Provide sub frames capable of withstanding design loads of window units.
- J. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with requirements in Division 08 Section "Glazing" and with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
- K. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match sash.

Laws and building and safety codes governing the design and use of Kawneer products, such as glazed entrance, window, and curtain wall products, vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
© 2014, Kawneer Company, Inc.

2.8 ALUMINUM FINISHES

- A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

EDITOR NOTE: CHOOSE THE APPROPRIATE FINISH BELOW BASED ON PROJECT REQUIREMENTS.

- B. Factory Finishing:

1. Kawneer Permanodic® AA-M10C21A44, AAMA 611, Architectural Class I Color Anodic Coating (Color _____).
2. Kawneer Permanodic® AA-M10C21A41, AAMA 611, Architectural Class I Clear Anodic Coating (Color #14 Clear) (Optional).
3. Kawneer Permanodic® AA-M10C21A31, AAMA 611, Architectural Class II Clear Anodic Coating (Color #17 Clear) (Standard).
4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color _____).
5. Kawneer Permadize® (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color _____).
6. Kawneer Permacoat™ AAMA 2604. Powder Coating (Color _____).
7. Other: Manufacturer _____ Type _____ Color _____.

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, weather tight window installation.
1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 2. Wood Frame Walls: Dry, clean, sound, well nailed, free of voids, and without offsets at joints. Ensure that nail heads are driven flush with surfaces in opening and within 3 inches (76 mm) of opening.
 3. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
 4. 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 aluminum framed storefront system 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 weather tight construction.
- D. Install aluminum framed storefront system 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 FIELD QUALITY CONTROL

- A. Testing Agency: Engage a qualified testing agency to perform tests and inspections and prepare test reports.
1. Testing and inspecting agency will interpret tests and state in each report whether tested work complies with or deviates from requirements.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
1. Testing Methodology: Testing Standard shall be per AAMA 502 including reference to ASTM E 783 for Air Infiltration Test and ASTM E 1105 for Water Penetration Test.
 - a. Air Infiltration Test: Conduct test in accordance with ASTM E 783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW or 6.24 psf (300 Pa) for AW. The maximum allowable rates of air leakage for field testing shall not exceed 1.5 times the project specifications.
 - b. Water Infiltration Test: Water penetration resistance tests shall be conducted in accordance with ASTM E 1105 at a static test pressure equal to 2/3 the specified water test pressure.
 2. Testing Extent: Architect shall select window units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer's representative present.
 3. Test Reports: Shall be prepared according to AAMA 502.

3.4 ADJUSTING, CLEANING, AND PROTECTION

- A. Adjust operating sashes, screens, hardware, and accessories for a tight fit at contact points and weather stripping for smooth operation and weather tight 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 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.

3.5 DEMONSTRATION

- A. Engage a factory-authorized service representative to train Owner's maintenance personnel to adjust, operate, and maintain window operating system. Refer to Division 01 Section "Demonstration and Training."

END OF SECTION 085113

Laws and building and safety codes governing the design and use of Kawneer products, such as glazed entrance, window, and curtain wall products, vary widely. Kawneer does not control the selection of product configurations, operating hardware, or glazing materials, and assumes no responsibility therefor.

Kawneer reserves the right to change configuration without prior notice when deemed necessary for product improvement.
© 2014, Kawneer Company, Inc.