

SECTION 085110

ALUMINUM WINDOWS

(Part of Work of Section 080001 - METAL WINDOWS, Filed Sub-Bid Required)

PART 1 - GENERAL

1.1 GENERAL PROVISIONS

- A. Attention is directed to the CONTRACT AND GENERAL CONDITIONS and all Sections within DIVISION 01 - GENERAL REQUIREMENTS which are hereby made a part of this Section of the Specifications.

1.2 DESCRIPTION OF WORK

- A. Work Included: Provide labor, materials and equipment necessary to complete the work of this Section, including but not limited to the following:
 - 1. Fixed and operable aluminum-framed windows with factory-installed glass and glazing.
 - 2. Electric window operators.
- B. Sustainable Design Intent: Refer to Section 018113 - SUSTAINABLE DESIGN REQUIREMENTS for certification level and certification requirements
- C. Related Work: The following items are not included in this Section and are specified under the designated Sections:
 - 1. Section 084110 - Aluminum-Framed Entrances and Storefronts.
 - 2. Section 084410 - GLAZED ALUMINUM CURTAIN WALLS for curtain wall assemblies.
 - 3. Section 088000 – EXTERIOR GLAZING for requirements for glass and glazing.
 - 4. Division 26 - ELECTRICAL for electrical service and connections for powered operators and accessories.

1.3 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 test size indicated below:
 - 1. Minimum size required by AAMA/NWWDA 101/I.S.2.
- B. AAMA/NWWDA Performance Requirements: Provide aluminum windows of the performance class and grade indicated that comply with AAMA/NWWDA 101/I.S.2.
 - 1. Performance Class: Architectural Grade AW.
 - 2. Performance Grade: Minimum for performance class indicated.
 - 3. Exception to AAMA/NWWDA 101/I.S.2: In addition to requirements for performance class and performance grade, design glass framing system to limit lateral deflections of glass edges to less than 1/175 of glass-edge length or 3/4 inch whichever is less, at design pressure based on the following:

- C. Structural Performance: Provide aluminum windows capable of withstanding the following, including wind loads based on passing AAMA/NWWDA 101/I.S.2, Uniform Load Structural Test, at basic wind speed indicated and as required by Code:
 - 1. 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, whichever is less, at design pressure based on structural computations.
 - 2. Wind and Seismic Loads: As indicated on the Structural Drawings, but not less than that required by Code.
 - 3. Movements of supporting structure including, but not limited to, story drift and deflection from uniformly distributed and concentrated live loads as required by Code. Deflection may require special considerations including but not limited to head receptors.

 - D. Air Infiltration: Maximum rate not more than indicated when tested according to AAMA/NWWDA 101/I.S.2, Air Infiltration Test.
 - 1. Maximum Rate: As required by Code.

 - E. Water Resistance: No water leakage as defined in AAMA/NWWDA referenced test methods at a water test pressure equaling that indicated, when tested according to AAMA/NWWDA 101/I.S.2, Water Resistance Test.
 - 1. Test Pressure: 15 percent of positive design pressure, but not less than 2.86 lbf/sq. ft. or more than 12 lbf/sq. ft.

 - F. Condensation-Resistance Factor: Provide aluminum windows tested for thermal performance according to AAMA 1503, showing a CRF of 52 where windows are indicated to be "thermally improved."

 - G. Thermal Transmittance: Provide aluminum windows with a whole-window U-value maximum indicated at 15-mph exterior wind velocity and winter condition temperatures when tested according to AAMA 1503.
 - 1. U-Value: As required by Code. Submit proof of compliance with submittals as specified.

 - H. Solar Heat-Gain Coefficient: Provide aluminum windows with a whole-window SHGC maximum as required by Code, determined according to NFRC 200 procedures. Submit proof of compliance with submittals as specified.

 - I. Thermal Movements: Provide aluminum windows, including anchorage, that accommodate thermal movements of units resulting from the following maximum change (range) in ambient and surface temperatures without buckling, distortion, opening of joints, failure of joint sealants, damaging loads and stresses on glazing and connections, and other detrimental effects. Base engineering calculation on actual surface temperatures of materials due to solar heat gain and nighttime-sky heat loss.
 - 1. Temperature Change (Range): 120 deg F, ambient; 180 deg F material surfaces.
- 1.4 SUBMITTALS
- A. Product Data: For each type of product indicated.
 - 1. Include construction details, material descriptions, fabrication methods, dimensions of individual components and profiles, hardware, finishes, and operating instructions.

2. Electric Window Operators: Include operating instructions.
 3. Motors: Show nameplate data, ratings, characteristics, and mounting arrangements.
- B. LEED Submittals:
1. Building Product Disclosure and Optimization, Material Ingredients:
 - a. Option 1, Material Ingredient Reporting: For factory-applied metal finishes, submit Declare product labels.
- C. Shop Drawings: Include plans, elevations, sections, details, hardware, attachments to other Work, operational clearances, 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. For installed products indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer responsible for their preparation and used to determine the following:
 - a. Structural test pressures and design pressures from basic wind speeds indicated.
 - b. Deflection limitations of glass framing systems.
 11. Electric Window Operators: Show locations and details for installing operator components, switches, and controls. Indicate motor size, electrical characteristics, drive arrangement, mounting, and grounding provisions.
 12. Wiring Diagrams: Power, system, and control wiring.
- D. Samples for Verification: Full-size operable window of each type of window.
- E. Qualification Data: For Installer, professional engineer and testing agency.
- F. Field Quality-Control Test Reports: From a qualified testing and inspecting agency engaged by Contractor.
- G. Product Test Reports: Based on evaluation of comprehensive tests performed within the last four years by a qualified testing agency, for each type, grade, and size of aluminum window. Test results based on use of downsized test units will not be accepted.
- H. Performance Reports: Based on systems, components and glazing methods proposed for use on this Project, proof that windows as glazed for this Project meet or exceed Code requirements for the following:
1. U-value.
 2. Solar heat-gain coefficient.
- I. Maintenance Data: For operable window sash, operating hardware, weather stripping, and

finishes to include in maintenance manuals.

1.5 QUALITY ASSURANCE

- A. Installer Qualifications: An installer acceptable to aluminum window manufacturer for installation of units required for this Project.
- B. Engineering Responsibility: Preparation of Shop Drawings, design calculations, and other structural data by a qualified professional engineer.
- C. Professional Engineer Qualifications: A professional engineer who is legally qualified to practice in the state the project is located, and who is experienced in providing engineering services of the kind indicated. Engineering services are defined as those performed for installations of windows that are similar to those indicated for this Project in material, design, and extent.
- D. Source Limitations: Obtain aluminum windows through one source from a single manufacturer.
- E. 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.
- F. Fenestration Standard: Comply with AAMA/NWWDA 101/I.S.2, "Voluntary Specifications for Aluminum, Vinyl (PVC) and Wood Windows and Glass Doors," for minimum standards of performance, materials, components, accessories, and fabrication unless more stringent requirements are indicated.
 - 1. Provide AAMA certified aluminum windows with an attached label.
- G. Glazing Publications: Comply with published recommendations of glass manufacturers and GANA's "Glazing Manual" unless more stringent requirements are indicated.
- H. Electrical Components, Devices, and Accessories: Listed and labeled as defined in NFPA 70, Article 100, by a testing agency acceptable to authorities having jurisdiction, and marked for intended use.
- I. 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 types of windows indicated, in locations shown on Drawings.
- J. Preinstallation Conference: Conduct conference at Project site to comply with requirements in Division 01. Review methods and procedures related to aluminum windows including, but not limited to, the following:
 - 1. Inspect and discuss condition of substrate and other preparatory work performed by other trades.
 - 2. Review and finalize construction schedule and verify availability of materials, Installer's personnel, equipment, and facilities needed to make progress and avoid delays.
 - 3. Review required testing and inspecting procedures.

1.6 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.

1.7 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. Failures include, but are not limited to, the following:
 - 1. Failure to meet performance requirements.
 - 2. Structural failures including excessive deflection.
 - 3. Water leakage, air infiltration, or condensation.
 - 4. Faulty operation of movable sash and hardware.
 - 5. Deterioration of metals, metal finishes, and other materials beyond normal weathering.
 - 6. Insulating glass failure.
- B. Warranty Period: Ten years from date of Substantial Completion.
- C. Warranty Period for Metal Finishes: Ten years from date of Substantial Completion.
- D. Warranty Period for Glass: Ten years from date of Substantial Completion.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
 - 1. EFCO, a Pella Company.
 - 2. Graham Architectural Products Corp.
 - 3. Kawneer North America.
 - 4. Peerless Products, Inc.
 - 5. Wausau Window and Wall Systems.
- B. Basis-of-Design:
 - 1. EFCO, Series 403X.
 - 2. EFCO, Series 325X / 325G Thermal.

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. Compression-Type Weather Stripping, typical: Provide compressible weather stripping designed for permanently resilient sealing under bumper or wiper action and for complete concealment when aluminum window is closed.
- F. Sliding-Type Weather Stripping for Double-Hung and Horizontal-Sliding Windows: 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 semirigid, polypropylene sheet or polypropylene-coated material. Comply with AAMA 701/702.
- G. Replaceable Weather Seals: Comply with AAMA 701/702.
- H. 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 GLAZING

- A. Insulating-Glass Units for Vertical Glazing: 1 inch thick (25.0 mm) insulating glass consisting of two lites of 1/4 inch (6 mm) glass, low e coating on the No. 2 surface and argon gas filled. Provide glazing as specified in Section 088000 – Exterior Glazing and as indicated on the drawings.
- B. Provide window films where indicated and as specified in Section 088000 – Exterior Glazing.

2.4 HARDWARE

- A. Hardware Requirements: Provide hardware that complies with AAMA/NWWDA 101/I.S.2.
 - 1. Hardware Finishes: To be selected by Architect from manufacturer's full range.
- B. Electric Window Operators: Provide motorized control systems for inaccessible windows as follows:

1. Basis of Design: Clearline Inc. Window Control Systems; 120 VDC Motorized Actuator System.
2. Color: To match Section 084410 - GLAZED ALUMINUM CURTAIN WALLS.
3. Wiring: Concealed.
4. Switching: Manufacturer's standard 3-position switch.
5. Accessories and attachment devices.
6. Comply with NFPA 70.

2.5 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. Provide for each operable exterior sash or ventilator.
- B. Aluminum Insect Screen Frames: Manufacturer's standard aluminum alloy complying with SMA 1004. Fabricate frames with mitered or coped joints, concealed fasteners, and removable PVC spline/anchor concealing edge of frame.
 1. Aluminum Tubular Framing Sections and Cross Braces: Roll formed from aluminum sheet with minimum wall thickness as required for class indicated.
 2. Finish: Match aluminum window members.
- C. Stainless-Steel Wire Fabric: 18-by-16 mesh of 0.009-inch-diameter, nonmagnetic stainless-steel wire, Type 304 or 316, complying with FS RR-W-365, Type VI.
- D. Wickets: Not permitted.

2.6 ACCESSORIES

- A. Window Cleaner Anchor Bolts: Provide window cleaner anchor bolts of standard design, complying with requirements of authorities having jurisdiction. Fabricate bolts of nonmagnetic stainless steel.
 1. Reinforce window units or mullions to receive bolts and provide additional anchorage of units at bolt locations.

2.7 FABRICATION

- A. General: Fabricate aluminum windows, in sizes indicated, that comply with AAMA/NWWDA 101/I.S.2 for performance class and performance grade indicated. Include a complete system for assembling components and anchoring windows.
- B. 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.
- C. Weather Stripping: Provide full-perimeter weather stripping for each operable sash and ventilator.
- D. Weep Holes: Provide concealed weep holes and internal passages to conduct infiltrating water to exterior.
- E. 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.

- F. Factory-Glazed Fabrication: Glaze aluminum windows in the factory where practical and possible for applications indicated. Comply with AAMA/NWWDA 101/I.S.2.

2.8 FINISHES

- A. General: Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.
- C. Class I, Clear Anodic Finish: AA-M12C22A41 (Mechanical Finish: nonspecular as fabricated; Chemical Finish: etched, medium matte; Anodic Coating: Architectural Class I, clear coating 0.018 mm or thicker) complying with AAMA 611.

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; rough opening dimensions; levelness of sill plate; coordination with wall flashings, vapor retarders, and other built-in components; operational clearances; and other conditions affecting performance of work.
 - 1. Masonry Surfaces: Visibly dry and free of excess mortar, sand, and other construction debris.
 - 2. Metal Surfaces: Dry; clean; free of grease, oil, dirt, rust, corrosion, and welding slag; without sharp edges or offsets at joints.
- B. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 INSTALLATION

- A. General: Comply with manufacturer's written instructions for installing windows, hardware, accessories, and other components; Drawings; and Shop Drawings.
- 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. Metal Protection: Separate aluminum and other corrodible surfaces from sources of corrosion or electrolytic action at points of contact with other materials by complying with requirements specified in "Dissimilar Materials" Paragraph in Appendix B in AAMA/NWWDA 101/I.S.2.
- F. Connections: Connect electric window operators to building electrical system.

3.3 FIELD QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified independent testing and inspecting agency to perform field tests and inspections and to prepare test reports.
- B. Testing Services: Testing and inspecting of installed windows shall take place as follows:
 - 1. Testing Methodology: Testing of windows for air infiltration and water resistance shall be performed according to AAMA 502.
 - 2. Air-Infiltration Testing:
 - a. Test Pressure: That required to determine compliance with AAMA/WDMA/CSA 101/I.S.2/A440 performance class indicated.
 - b. Allowable Air-Leakage Rate: 1.5 times the applicable AAMA/WDMA/CSA 101/I.S.2/A440 rate for product type and performance class rounded down to one decimal place.
 - 3. Water-Resistance Testing:
 - a. Test Pressure: Two-thirds times test pressure required to determine compliance with AAMA/WDMA/CSA 101/I.S.2/A440 performance grade indicated.
 - b. Allowable Water Infiltration: No water penetration.
 - 4. Testing Extent: Three windows of each type as selected by Architect and a qualified independent testing and inspecting agency. Windows shall be tested after perimeter sealants have cured.
 - 5. Test Reports: Prepared according to AAMA 502.
- C. Remove and replace windows where test results indicate that they do 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. Adjust operating sashes and ventilators, screens, hardware, operators, and accessories for a tight fit at contact points and weather stripping for smooth operation and weathertight closure. Lubricate hardware and moving parts.

3.5 PROTECTION AND CLEANING

- A. 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.
- 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.

END OF SECTION