

## 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 nor AIA 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 TR-3500 Windows
    - b. Project-Out Window
    - c. 3-1/4" (83 mm) frame depth
    - d. AW-PG65-AP

*EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.*

- B. Related Sections:
  - 1. 072700 "Air Barriers"
  - 2. 079200 "Joint Sealants"
  - 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. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

#### 1.4 Performance Requirements

- A. General Performance: Aluminum-framed window system shall withstand the effects of the following performance requirements without failure due to defective manufacture, fabrication, installation, or other defects in construction.
- B. Window Performance Requirements:

*EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS FOR WINDOW SYSTEMS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.*

- 1. Provide aluminum windows of performance indicated that comply with AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).
  - a. Performance Class and Grade: AW-PG65-AP.

*EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.*

- 2. Wind loads: Provide window system; include anchorage, capable of withstanding wind load design pressures of (\_\_\_\_) lbs./sq. ft. inward and (\_\_\_\_) lbs./sq. ft. outward. The design pressures are based on the (\_\_\_\_) Building Code; (\_\_\_\_) Edition.
- 3. Air Infiltration: The test specimen shall be tested in accordance with ASTM E283 at a minimum size of 60" x 36" (1524 x 914). Air infiltration rate shall not exceed 0.10 cfm/ft<sup>2</sup> at a static air pressure differential of 6.24 psf (300 Pa).
- 4. Water Resistance: The test specimen shall be tested in accordance with ASTM E547 and ASTM E331 at a minimum size of 60" x 36" (1524 x 914). There shall be no leakage as defined in the test method at a static air pressure differential of 13 psf (622 Pa).

5. Uniform Load Deflection: A minimum static air pressure difference of 65 psf (3112 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. There shall be no deflection in excess of L/175 of the span of any framing member.
6. Uniform Load Structural: A minimum static air pressure difference of 97.5 psf (4668 Pa) shall be applied in the positive and negative direction in accordance with ASTM E330. The unit shall be evaluated after each load.
7. Component Testing: Window components shall be tested in accordance with procedures described in AAMA/WDMA/CSA 101/I.S.2/A440 (NAFS).

**EDITOR NOTE: CHOOSE IMPACT RESISTANCE PERFORMANCE IF REQUIRED TO MEET PROJECT REQUIREMENTS.**

8. Windborne-Debris-Impact Resistance Performance: Shall be tested in accordance with ASTM E1886, information in ASTM E1996, and TAS 201/203.
  - a. Large-Missile Impact: For aluminum-framed systems located within 30 feet (9.1m) of grade.
  - b. Small-Missile Impact: For aluminum-framed systems located above 30 feet (9.1 m) of grade.
9. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria.
 

To meet UFC 04-010.01, b-3.1 Standard 10 for Windows and Skylights, the following options are available:

  - a. Section B-3.1.1 Dynamic analysis
  - b. Section B-3.1.2 Testing
  - c. Section B-3.1.3 ASTM F2248 Design Approach
10. Forced Entry Resistance: All windows shall conform to ASTM F588, Grade 10.
11. Thermal Barrier Test: Thermal break shall be designed in accordance with AAMA TIR-A8 and tested in accordance with AAMA 505.

### 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 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.

### 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 aluminum window openings by field measurements before fabrication and indicate 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 TR-3500 Windows - Project-Out
  3. 3-1/4" (83 mm) frame depth
  4. AP-AW65-AP

*EDITOR NOTE: PROVIDE INFORMATION BELOW INDICATING APPROVED ALTERNATIVES TO THE BASIS-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.

### 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 0.080" (2.03 mm) wall thickness at any location for the main frame and sash members.
- B. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim, hardware, anchors, and other components.
- D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- E. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B456 for Type SC3 severe service conditions, or zinc-coated steel or iron complying with ASTM B633 for SC3 severe service conditions; provide sufficient strength to withstand design pressure indicated.
- 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 System

- A. Series TR-3500 Windows - Project-Out

### 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 with 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. Project-Out Window Typical Hardware:

*EDITOR NOTE: SELECT FROM BELOW.*

1. Typical Hardware:
  - a. White Bronze Cam Handles with Strikes
  - b. (Optional) Pole-Operated White Bronze Cam Handles with Strikes
  - c. (Optional) Custodial Lock with Removable Handle
  - d. (Optional) Stainless Steel Limit Arm with Release Key
  - e. Concealed Stainless Steel Hinges

**2.6 Accessories**

- A. Spacers, Setting Blocks, Gaskets, and Bond Breakers: Manufacturer's standard permanent, non-migrating types in hardness recommended by manufacturer, compatible with sealants, and suitable for system performance requirements.
- B. Framing system gaskets, sealants, and joint fillers as recommended by manufacturer for joint type.
- C. Sealants and joint fillers for joints at perimeter of window system as specified in Division 7 Section "Joint Sealants".
- D. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

*EDITOR NOTE: BETWEEN THE GLASS MUNTIN FINISHES SHALL MATCH THE WINDOW UNLESS SPECIFIED OTHERWISE.*

- E. Optional Muntin Grids: Extruded aluminum profiles, 6063-T6 alloy and temper and as follows:
  1. True muntins.
  2. Between the glass muntins.

*EDITOR NOTE: PANNINGS AND TRIMS MAY BE STANDARD OR CUSTOM. FOR STANDARD PANNING AND TRIMS REFER TO KAWNEER.COM.*

- F. Optional Exterior Panning and Interior Trims: Extruded aluminum, 6063-T6 alloy and temper, extruded to profiles and details indicated. Seal exterior joints with manufacturer's standard sealant to assure water-tight joints.
  1. Exterior Panning and Trims: All panning profiles shall be a minimum thickness of 0.062" (1.57 mm) to match the profiles as shown the drawings. Any profile variations shall be submitted to the architect and/or owner for approval 10 days prior to bid date. All panning shall be factory fabricated for field assembly. All corner joinery shall be factory cut. Joinery at the sill shall be coped and butt-type construction. All preparations for assembly shall be completed by the window manufacturer. Upon assembly, panning frame joints shall be back-sealed to prevent moisture penetration.
  2. Interior Trims: The interior face trim minimum wall thickness shall be 0.062" (1.57 mm). The face trim shall snap-fit onto concealed mounting clip. Exposed fasteners shall not be accepted. The mounting clip shall be extruded aluminum of 6063-T6 alloy and temper. The minimum wall thickness shall be 0.062" (1.57 mm). The trim clips shall be provided in 3" (76.2 mm) lengths and spaced a maximum of 18" (457.2 mm) center to center.
- G. Coupling Mullions: Shall be extruded aluminum of 6063-T6 alloy and temper of profile and dimensions indicated on drawings. Mullions shall provide structural properties to resist wind pressure required by performance criteria and standards.
- H. Insect Screens: (Full Screen) Field-mounted on interior with swivel clips; handle-access wickets [Enter wicket color choice: White, Bronze or Black]; 3/4" x 1-1/8" x .050" extruded tubular aluminum frame with finish to match window in color and performance; corners mitered, gusset reinforced, and crimped; 18 x 16 dark fiberglass [Optional Aluminum] mesh; PVC splines.

**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. Window Frame Joinery: Mitered and Mechanically clipped and/or staked. Factory sealed frame and corner joints.
- C. Fabricate aluminum windows in sizes indicated. Include a complete system for assembling components and anchoring windows.
- D. Fabricate aluminum windows that are re-glazable without dismantling sash or framing.
- E. Thermally Broken Construction: Fabricate aluminum windows with an integral, concealed, low-conductance thermal barrier; in a manner that eliminates direct metal-to-metal contact. Thermal barriers shall be designed in accordance with AAMA TIR A8.
  1. Thermal Barrier: The thermal barrier shall consist of integral structural polyurethane thermal break installed by the window manufacturer in the frame members.
- F. 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.

- G. Sub frames: Provide sub frames with anchors for window units as shown, of profile and dimensions indicated but not less than 0.093" (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.
- H. 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).
- I. Glazing Stops: Provide snap-on glazing stops coordinated with Division 08 Section "Glazing" and glazing system indicated. Provide glazing stops to match frame.

## 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 / AA-M45C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color \_\_\_\_\_).
2. Kawneer Permanodic™ AA-M10C21A41 / AA-M45C22A41, 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 Permادize™ (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 (76.2 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 window 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 window system and components to drain condensation, water penetrating joints, and moisture migrating within system to the exterior.
- E. Separate aluminum from dissimilar materials to prevent corrosion or electrolytic action at points of contact.

### 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 E783 for Air Infiltration Test and ASTM E1105 for Water Penetration Test.
    - a. Air Infiltration Test: Conduct test in accordance with ASTM E783 at a minimum uniform static test pressure of 1.57 psf (75 Pa) for CW and 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 E1105 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.

**DISCLAIMER STATEMENT**

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

**END OF SECTION 085113**

Laws and building and safety codes governing the design and use of 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.

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