



Heavy Commercial Horizontally Sliding Aluminum Window
Series L500T
HS-HC65/AW65

GUIDE SPECIFICATION

Section 08520...Aluminum Windows

PART 1: WORK INCLUDED

- A. The conditions of the contract and applicable sections of Division 1 are hereby made a part of this section.
- B. Material, labor, tools and equipment necessary to furnish and install aluminum windows as shown on drawings and specified herein, shall be provided. Details indicate the required depth and profile.
- C. Glass and Glazing.
- D. Existing sash, stops, and other items indicated on the drawings and required by the proposal replacement system shall be removed and properly discarded.
- E. Perimeter Sealing.

1.02 RELATED WORK (Optional)

- A. Section 08800...Glass & Glazing
- B. Section 07920...Perimeter Sealant
- C. Other...[Louvers, panels, hollow metal, steel, insulation, etc.]

1.03 SYSTEM DESCRIPTION

Units shall be horizontally sliding aluminum window conforming to HS-HC65/AW65 specifications in ANSI/AAMA 101-93 and ANSI/AAMA Publication GS-001

1.04 PERFORMANCE REQUIREMENTS

- A. Air infiltration: When tested in accordance with ASTM E 283-91 on a test size of 8'-0" x 6'-7", the air infiltration rate shall not exceed .03 cfm/ft of sash perimeter under a static pressure difference of 1.57 PSF. Additionally, at 6.24 PSF the air infiltration shall not exceed .09 cfm/ft.
- B. Water Resistance: When tested in accordance with ASTM E 331-86 on a test size of 8'-0" x 6'-7", there shall be no leakage under static pressure of 12.00 PSF.
- C. Uniform Load Structural Test:
 - 1. With window sash closed and locked, the unit shall be tested in accordance with ASTM E 330-90 on a test size of 8'-0" x 6'-7", at a static test pressure difference of 100.00 PSF with the first exterior [positive] pressure applied, and then the interior [negative] pressure applied.
 - 2. At conclusion of test, there shall be no glass breakage, permanent damage to fasteners, hardware parts, or actuating mechanisms, nor any other damage that would cause the window to be inoperable. Permanent deformation of any frame or sash member shall not exceed 0.4% of its span.
- D. Condensation Resistance Factor (CRF): When tested in accordance with AAMA 1502.81 on a test size of 6'-0" x 4'-0", the CRF shall not be less than 55.
- E. Thermal Transmittance [U Value]: When tested in accordance with AAMA 1503.1-88 on a test size of 6'-0" x 4'-0", the thermal transmittance due to conduction [Uc] shall not exceed 0.58 BTU/HR.FT².F.
- F. Life Cycle Test: The movable panel and locking hardware will be cycled 1250 total cycles without failure. After the Life Cycle Test the window will be retested for air infiltration, water penetration and uniform structural load deflection without failure.
- G. Forced Entry Resistance: The window shall have a level 20 Forced Entry Resistance Rating as per ASTM F588.

1.05 QUALITY ASSURANCE

- A. Pre-Bid Qualifications:
 - 1. All horizontally sliding windows shall be L500T as manufactured by Litex Incorporated, 1675 W. Hamlin Rd., Rochester Hills, MI 48309, phone 248-852-0661, fax 248-852-0095, online www.Litex.com, or approved equal.
 - 2. Other manufacturers desiring approval shall furnish a full size sample and valid test reports indicating full compliance with all requirements of this specification at least ten days prior to bid.

3. Other manufacturers shall have been engaged in fabrication of aluminum windows for five years, and shall submit for review a list of completed projects.
4. Approval of "equal" product shall be in the form of a written addendum.

1.06 SUBMITTAL

- A. Product Data: Manufacturers specifications, test reports, and standard aluminum window details shall be submitted.
- B. Shop Drawings: Location plans showing window openings, unit elevations, full size sections of typical members, anchors and glazing details shall be shown.
- C. Samples:
 1. Specified aluminum finish shall be submitted on 6" sections of aluminum as required.
 2. Additional samples shall be submitted as directed by the architect, to show fabrication techniques, workmanship of component parts, and design of hardware
- D. Written approval by the architect shall be required prior to shop fabrication

1.07 WRITTEN PROJECT WARRANTIES

- A. Windows shall be warranted against defects in material or workmanship under normal use for a period of 10 years from the date of installation.
- B. Insulating glass shall be warranted against visual obstruction resulting from film formation or moisture collection between the interior glass surfaces [excluding glass breakage] for a period of 10 years from date of manufacture.

PART 2: PRODUCTS

2.01 MATERIALS

- A. Aluminum Extrusions:
 1. All frame and sash sections shall be extruded shapes produced from commercial quality 6063-T5 or 6063-T6 alloy and shall be free from defects impairing strength and/or durability.
 2. The frame depth shall be a nominal 3 ¾"

3. All frame and sash members shall have a nominal wall thickness of .062". The frame sill shall have a nominal wall thickness of .093".
4. No extruded plastics shall be allowed in the frame or sash members.

B. Hardware:

1. Each operating sash shall operate on two (2) height adjustable ball bearing rollers capable of supporting a load of 100 lbs. Each under continuous operation.
2. Operating sash shall have an all-metal spring-loaded lock that automatically engages a whit bronze keeper at meeting rails. Lock shall be easily serviceable in the field without disassembling the sash.
3. [Optional] Operating sash to have anti-take out [dormitory] hardware for sash removal by authorized personnel only.
4. [Optional] Frame head to be fitted with a removable extruded vinyl stop that would limit sash travel to the architect's specifications.

C. Weatherstrip:

1. All sashes shall be double weaterstripped using silicone-treated pile with a polypropylene center fin conforming to AAMA 701.2
2. All weathersrtipping shall be held in extruded ports and secured to prevent loss when operating sash.

D. Screens:

1. Half screens shall consist of 18 x 16 charcoal anodized aluminum mesh secured by vinyl spline to a nominal 5/16" x 1 1/4" x .050" extruded tubular aluminum frame.
2. They shall be remeshable, removable from the interior and held in place with spring-loaded plungers.

E. Glazing:

1. All windows to be factory glazed with either 1" sealed insulated glass or a "Dual Glazed" system with removable interior glass or exterior and interior polycarbonate glazing.

2. Glass shall be set in glazing tape 1/8" thick at the exterior glazing leg and held in place with interior snap-in stops.
3. All glass to be set on 1/4" setting blocks.
4. Gasket type glazing requiring sash disassembly to reglaze is not acceptable.
5. All glass or panels glazed into fixed framing to receive a perimeter cap bead of silicone sealant between the glazing leg and the glass surface.
6. [Optional] All glass glazed into sliding or hung windows to receive a perimeter cap bead of silicone sealant between the glazing leg and glass surface.
7. [Optional] Window to have integral mechanically operated between the glass venetian blinds. Finish to be selected by the architect from the manufacturers standard colors.

2.02 FABRICATION

A. Construction

1. Frame and sash members to be extruded as a single section. The frame members will have two (2) channels and the sash members will have (1) channel that is then filled with polyurethane that becomes a rigid structural element. Connecting aluminum "bridge" of at least .250" wide is removed to establish interior and exterior sections separated by the polyurethane to prevent thermal transmittance. Windows having a single thermal break in the frame are not acceptable.
2. The thermal barrier shall be a structural and integral part of the aluminum extrusion, have strength exceeding the basic shapes. The thermal barrier shall be permanently bonded to the aluminum extrusion and there shall be no bridging of the thermal barrier at any corner or connection of anchorage.
3. All Frame and sash members to be continuous extrusions. The window head is to be miter cut and fastened to jambs with 1/8" corner keys and (4) cadmium plated or stainless steel screws into integral screw ports. Frame jambs are to be angle cut to match the sill slope and fastened with (4) cadmium plated or stainless steel screws into integral screw ports.
4. All vertical sash rails to be of tubular construction containing a hollow section of not less than (1) square inch. Sash corners shall be

telescoped for maximum strength and fastened with stainless steel screws into integral screw ports.

5. The frame sill shall slope 10 degrees to the exterior and contain integral offset weep holes that allow gravity water drainage and resistance to wind driven water and/or air.
 6. Each operating sash shall be removable from the interior for cleaning by raising the sash 1" and pulling lower portion to the interior.
 7. All frame joints shall be hairline and be factory sealed with a sealant conforming to AAMA 803.3-85
- B. Mullions or other Structural Members: When units occur that are joined by independent mullions, the resulting member shall be capable of withstanding the design pressure. Evidence of compliance may be by mathematical calculations.
- C. Finish: The exposed surfaces of all aluminum members shall be clean and free from surface blemishes, scratches or tool marks. The finish shall be one of the following:
1. Organic finish applied over a 5-Stage aluminum pre-treatment. Finish shall be a one coat, one bake [Baked Enamel] system with a .8 mil minimum thickness and shall conform to AAMA 603.8-85. Color to be chosen by the architect.
 2. Organic finish applied over a 5-Stage aluminum pre-treatment. Finish shall be based on a "Kynar 500" resin and applied as a two coat; two bake system with a 1.2 mil minimum thickness and shall conform to AAMA 605.2-85. Color to be chosen by the architect.
 3. Organic finish applied over a 5-Stage aluminum pre-treatment. Finish shall be based on a "Kynar 500" resin and applied as a three coat; three bake system with a 1.6 mil minimum thickness and shall conform to AAMA 605.2-85. The third coat shall be clear lacquer. Color to be chosen by the architect.
 4. Clear Anodized Finish – Class II (204-R1) – AAM10C22A31. Thickness shall be a .4 mil and shall conform to AAMA 607.1-77
 5. Clear Anodized Finish – Class I (215-R1) – AAM10C22A41. Thickness shall be a .7 mil and shall conform to AAMA 607.1-77

6. Color Anodized Finish – Class I – AAM10C22A44. Thickness shall be .7 mil and conform to AAMA 608.1-77. Color to be chosen by the architect.

PART 3: EXECUTION

3.01 PREPARATION

- A. Openings shall be verified by contractor and/or general contractor to be within allowable tolerances, plumb, level, clean, providing a solid anchoring surface and in accordance with approved shop drawings. Unsatisfactory conditions shall be corrected prior to installation.
- B. Existing windows shall not be removed until new replacement window is available and ready for immediate installation. Openings shall not be left uncovered at the end of the working day, during wind driven precipitation, or very cold weather.

3.02 WINDOW INSTALLATION

- A. Windows shall be erected by skilled craftsman in prepared openings in accordance with manufacturers recommendations and approved shop drawings. Frames shall be securely supported, fastened and set plumb, square, and level without twist or bow.
- B. All sashes shall be glazed using manufacturer glazing instructions in the factory or if conditions dictate in the field, depending upon job scope and field conditions.
- C. Fiberglass insulation shall be compressed between new window frame and existing construction, or between frame and new blocking as applicable.
- D. Aluminum shall be insulated from direct contact with steel, masonry, concrete or non-compatible materials by bituminous paint, zinc chromate primer or other suitable insulating material.
- E. Exterior joints between windows and surrounding construction shall be sealed per specifications and approved drawings.
- F. Joints and surfaces to receive sealants shall be dry, clean, and free from loose material, efflorescence or mortar leaching. Sealants shall not be applied when temperature is below sealant manufacturer recommendations.

3.03 AJUSTING AND CLEANING

- A. Frames and sash shall be adjusted, if necessary, after installation to insure smooth and weather tight operation.
- B. The general contractor shall be responsible for protection of the work from damage by other trades and for final cleaning.