Preparing Activity: NAVFAC Superseding
UFGS-08 51 13 (May 2011)

UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated July 2023
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05/19

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USACE / NAVFAC / AFCEC / NASA	**UFGS-08 51 13 (May 2019)**

Preparing Activity: NAVFAC	**Superseding**
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UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated July 2023
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SECTION 08 51 13

ALUMINUM WINDOWS
05/19

****
NOTE: This guide specification covers the requirements for R, LC, CW and AW performance class aluminum windows.

Adhere to UFC 1-300-02 Unified Facilities Guide Specifications (UFGS) Format Standard when editing this guide specification or preparing new project specification sections. Edit this guide specification for project specific requirements by adding, deleting, or revising text. For bracketed items, choose applicable item(s) or insert appropriate information.

Use aluminum windows (fixed or operable) in humid locations or project locations with Environmental Severity Classifications (ESC) of C3 thru C5. Humid locations are those in ASHRAE climate zones 0A, 1A, 2A, 3A, 3C, 4C and 5C (as identified in ASHRAE 90.1). See UFC 1-200-01 for determination of ESC for project locations. Aluminum will oxidize and the specified finish should be anodic (clear or colored). Use stainless steel hardware for operable parts.

Remove information and requirements not required in respective project, whether or not brackets are present.

Comments, suggestions and recommended changes for this guide specification are welcome and should be submitted as a Criteria Change Request (CCR).
****

****
1. Windows requiring UL fire rating must be steel, and may occur in conjunction with aluminum windows which cannot be approved for this use. When steel windows are used in conjunction with aluminum, specify finish matching aluminum windows. Steel

windows should be specified in Section 08 51 23 STEEL WINDOWS.

2. Aluminum windows are not acceptable for use as security windows which should be steel, specified in Section 08 51 23 STEEL WINDOWS. Security steel windows are designed and constructed to give protection against unauthorized entrance and removal of materials from warehouses and other storage type areas; they are not designed for detention use. Guard windows for detention use are not included in this guide; where such windows are desired, consult Steel Window Institute Recommended Specifications and manufacturers' data, and specify in Section 08 51 23 STEEL WINDOWS.

3. Specify the following items of related work under other sections of the specifications:

a. Glass and glazing and the furnishing of glazing clips and gaskets.

b. Caulking and sealants.

c. Structural building supports at window mullions.

d. Wood subframes for windows in frame walls.

e. Drilling and tapping for attachment of window shades, drapery rods, and venetian blinds. The drilling and tapping of window frames to receive brackets for shades, venetian blinds, and curtain rods has been omitted from this specification. It is contemplated that this work will be done after erection of windows by the trade for the item to be installed. On projects where factory drilling for these items is required, revise this specification accordingly.

f. Brackets and supports for window shades, drapery rods, and venetian blinds.

g. Electrical requirements for motor driven operators.

****

****

NOTE: On the drawings, show:

1. Sizes and types of windows; metal and wood subframes, casings, or stools; and hardware.

2. Sizes, location, and swing of ventilators; direction of slide for sliding ventilators; location and details of fixed sash.

3. Typical window sections and details. Show glass thickness. Show special glazing.

4. Method of anchoring windows to adjoining construction; size and types of clips, anchors, screws, or other fasteners.

5. Details of nonstructural mullions and mullion covers; details of anchoring and reinforcing nonstructural mullions at windows to receive window cleaner anchors.

6. Number and locations of window cleaner anchors.

7. Locations of windows requiring special operators. Show method of operation and concealment of operators, cables and rods. Show wiring diagram for motor driven operators.

8. Locations of windows designated as forced entry resistant.

****

PART 1 GENERAL

1.1 REFERENCES

****

NOTE: This paragraph is used to list the publications cited in the text of the guide specification. The publications are referred to in the text by basic designation only and listed in this paragraph by organization, designation, date, and title.

Use the Reference Wizard's Check Reference feature when you add a Reference Identifier (RID) outside of the Section's Reference Article to automatically place the reference in the Reference Article. Also use the Reference Wizard's Check Reference feature to update the issue dates.

References not used in the text will automatically be deleted from this section of the project specification when you choose to reconcile references in the publish print process.

****

The publications listed below form a part of this specification to the extent referenced. The publications are referred to within the text by the basic designation only.

ALUMINUM ASSOCIATION (AA)

AA DAF45	(2003; Reaffirmed 2009) Designation System for Aluminum Finishes

AMERICAN ARCHITECTURAL MANUFACTURERS ASSOCIATION (AAMA)

AAMA 611	(2014) Voluntary Specification for Anodized Architectural Aluminum

AAMA 701/702	(2011) Voluntary Specification for Pile Weatherstripping and Replaceable Fenestration Weatherseals
AAMA 901	(2016) Voluntary Specification for Rotary & Linear Operators in Window Applications
AAMA 902	(2016) Voluntary Specification for Sash Balances
AAMA 907	(2015) Voluntary Specification for Corrosion Resistant Coatings on Carbon Steel Components Used in Windows, Doors and Skylights
AAMA 1302.4	(1973) Specifications for Forced-Entry Resistant Aluminum Prime Windows
AAMA 1503	(2009) Voluntary Test Method for Thermal Transmittance and Condensation Resistance of Windows, Doors and Glazed Wall Sections
AAMA 2603	(2020) Voluntary Specification, Performance Requirements and Test Procedures for Pigmented Organic Coatings on Aluminum Extrusions and Panels
AAMA 2604	(2017a) Voluntary Specification, Performance Requirements and Test Procedures for High Performance Organic Coatings on Aluminum Extrusions and Panels
AAMA 2605	(2020) Voluntary Specification, Performance Requirements and Test Procedures for Superior Performing Organic Coatings on Aluminum Extrusions and Panels
AAMA WSG.1	(1995) Window Selection Guide
AAMA/WDMA/CSA 101/I.S.2/A440	(2017) North American Fenestration Standard/Specification for Windows, Doors, and Skylights

AMERICAN SOCIETY OF HEATING, REFRIGERATING AND AIR-CONDITIONING ENGINEERS (ASHRAE)

ASHRAE 169	(2013) Climate Data for Building Design Standards

ASTM INTERNATIONAL (ASTM)

ASTM A276/A276M	(2017) Standard Specification for Stainless Steel Bars and Shapes
ASTM D3656/D3656M	(2013) Standard Specification for Insect Screening and Louver Cloth Woven from Vinyl-Coated Glass Yarns
ASTM E90	(2009; R2016) Standard Test Method for

	Laboratory Measurement of Airborne Sound Transmission Loss of Building Partitions and Elements
ASTM E413	(2022) Classification for Rating Sound Insulation
ASTM E1300	(2016) Standard Practice for Determining Load Resistance of Glass in Buildings
ASTM E1332	(2016) Standard Classification for Rating Outdoor-Indoor Sound Attenuation
ASTM E1886	(2019) Standard Test Method for Performance of Exterior Windows, Curtain Walls, Doors, and Impact Protective Systems Impacted by Missile(s) and Exposed to Cyclic Pressure Differentials
ASTM E1996	(2017) Standard Specification for Performance of Exterior Windows, Curtain Walls, Doors, and Impact Protective Systems Impacted by Windborne Debris in Hurricanes
ASTM F1642/F1642M	(2017) Standard Test Method for Glazing and Glazing Systems Subject to Airblast Loadings
ASTM F2248	(2012) Standard Practice for Specifying an Equivalent 3-Second Duration Design Loading for Blast Resistant Glazing Fabricated with Laminated Glass
ASTM F2912	(2017) Standard Specification for Glazing and Glazing Systems Subject to Airblast Loadings

INTERNATIONAL WINDOW CLEANING ASSOCIATION (IWCA)

IWCA I-14.1	(2001) Window Cleaning Safety Standard

NATIONAL FENESTRATION RATING COUNCIL (NFRC)

NFRC 100	(2020) Procedure for Determining Fenestration Product U-Factors
NFRC 200	(2020) Procedure for Determining Fenestration Product Solar Heat Gain Coefficient and Visible Transmittance at Normal Incidence

NATIONAL FIRE PROTECTION ASSOCIATION (NFPA)

NFPA 101	(2021; TIA 21-1) Life Safety Code

PASSIVE HOUSE INSTITUTE - US (PHIUS)

PHIUS Certified	Certified Data Program for Window

	Performance

PASSIVE HOUSE INSTITUTE INTERNATIONAL (PHI)

Passivhaus Certified	(2012) Certification of Passive House Suitable Components
Passivhaus Criteria	(2012) Certification Criteria for Certified Passive House Glazings and Transparent Components

SCREEN MANUFACTURERS ASSOCIATION (SMA)

SMA 1004	(1987; R 1998) Aluminum Tubular Frame Screens for Windows
SMA 1201	(R 2013) Specifications for Insect Screens for Windows, Sliding Doors and Swinging Doors

U.S. DEPARTMENT OF DEFENSE (DOD)

UFC 4-010-01	(2018; with Change 2, 2022) DoD Minimum Antiterrorism Standards for Buildings

U.S. DEPARTMENT OF ENERGY (DOE)

Energy Star	(1992; R 2006) Energy Star Energy Efficiency Labeling System (FEMP)

1.2 SUBMITTALS

****

NOTE: Review Submittal Description (SD) definitions in Section 01 33 00 SUBMITTAL PROCEDURES and edit the following list, and corresponding submittal items in the text, to reflect only the submittals required for the project. The Guide Specification technical editors have classified those items that require Government approval, due to their complexity or criticality, with a "G." Generally, other submittal items can be reviewed by the Contractor's Quality Control System. Only add a "G" to an item if the submittal is sufficiently important or complex in context of the project.

For Army projects, fill in the empty brackets following the "G" classification, with a code of up to three characters to indicate the approving authority. Codes for Army projects using the Resident Management System (RMS) are: "AE" for Architect-Engineer; "DO" for District Office (Engineering Division or other organization in the District Office); "AO" for Area Office; "RO" for Resident Office; and "PO" for Project Office. Codes following the "G" typically are not used for Navy, Air Force, and NASA projects.

The "S" classification indicates submittals required

as proof of compliance for sustainability Guiding Principles Validation or Third Party Certification and as described in Section 01 33 00 SUBMITTAL PROCEDURES.

Choose the first bracketed item for Navy, Air Force, and NASA projects, or choose the second bracketed item for Army projects.

****

Government approval is required for submittals with a "G" or "S" classification. Submittals not having a "G" or "S" classification are [for Contractor Quality Control approval.][for information only. When used, a code following the "G" classification identifies the office that will review the submittal for the Government.] Submit the following in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

SD-02 Shop Drawings

Windows; G[, [_____]]

Fabrication Drawings

SD-03 Product Data

Windows; G[, [_____]]

[Recycled Content of Aluminum Windows; S

] Hardware; G[, [_____]]

Fasteners; G[, [_____]]

Window Performance; G[, [_____]]

Thermal-Barrier Windows; G[, [_____]]

Mullions; G[, [_____]]

Window Cleaners' Bolts; G[, [_____]]

Screens; G[, [_____]]

Weatherstripping; G[, [_____]]

Accessories; G[, [_____]]

Adhesives

Thermal Performance; G[, [_____]]

Energy Star Label For Residential Aluminum Window Products; S

SD-04 Samples

Finish Sample

Window Sample

[Window Mock-Ups; G[, [_____]]

] SD-05 Design Data

Structural Calculations for Deflection; G[, [_____]]

Design Analysis; G[, [_____]]

SD-06 Test Reports

Minimum Condensation Resistance Factor

[Resistance to Forced Entry

][Standard Airblast Test; G[, [_____]]

][Windborne-Debris-Impact Performance

] SD-07 Certificates

****
NOTE: Provide engineer's qualifications when required to show conformance to UFC 4-010-01, DoD Minimum Antiterrorism Requirements for Buildings.
****

[Engineer's Qualifications

] SD-10 Operation and Maintenance Data

Windows, Data Package 1; G[, [_____]]

Submit in accordance with Section 01 78 23 OPERATION AND MAINTENANCE DATA.

Plastic Identification

1.3 QUALITY ASSURANCE

1.3.1 Qualification of Manufacturer

Window manufacturer must specialize in designing and manufacturing the type of aluminum windows specified in this section, and have a minimum of [_____] years of documented successful experience. Manufacturer must have the facilities capable of meeting contract requirements, single-source responsibility and warranty.

1.3.2 Shop Drawing Requirements

Take field measurements prior to preparation of drawings and fabrications. Provide drawings that indicate elevations of windows, full-size sections, thickness and gages of metal, fastenings, proposed method of anchoring, size and spacing of anchors, details of construction, method of glazing, details of operating hardware, [mullion details,] [method and materials for weatherstripping,] [method of attaching screens,] [material and method of attaching subframes,] [stools,] [casings,] [sills,] [trim,] [window cleaner anchors,] installation details, and other related items.

[1.3.3 Engineer's Qualifications for Blast Design

****
NOTE: Provide engineer's qualifications when required to show conformance to UFC 4-010-01, DoD Minimum Antiterrorism Requirements for Buildings.
****

All blast design calculations must be performed by or under the direct supervision of a registered engineer with a minimum of 5 years experience performing blast design. The engineer performing the blast design must be able to demonstrate experience on similar size projects using similar design methods to meet the requirements outlined in this specification.

]1.3.4 Sample Requirements

1.3.4.1 Finish Sample Requirements

Submit color chart of standard factory color coatings when factory-finish color coating is to be provided.

1.3.4.2 Window Sample Requirements

****
NOTE: Choose one of the following options. Include the first choice for projects requiring a large number of windows. Include the second choice for projects requiring a limited number of windows.
****

[Submit one full-size window of each type proposed for use, complete with AAMA Label, glazing, hardware, anchors, and other accessories. Where screens or weatherstripping is required, fit sample windows with such items that are to be used. After approval, install each sample in work, clearly identified, and record its location.

][Submit one full-size corner of each window type proposed for use. Where screens or weatherstripping is required, fit sample with such items that are to be used.

][1.3.4.3 Mock-Ups

****
NOTE: Requesting mock-up samples of aluminum windows is not required for most projects. Size of project and scope of quality control should be carefully evaluated before requiring Contractor to provide a costly mock-up. Delete paragraph if mock-ups are not required.
****

Before fabrication, full-size mock-up of [each type of aluminum window] [one window unit] [_____] complete with glass and AAMA certification label for structural purposes and NFRC Temporary and Permanent Label for certification of thermal performance rating will be required for review of window construction and quality of hardware operation.

]1.3.5 Design Data Requirements

Submit calculations to substantiate compliance with deflection requirements[and Antiterrorism Performance Requirements]. A registered Professional Engineer must provide calculations.

Submit design analysis with calculations showing that the design of each different size and type of aluminum window unit and its anchorage to the structure[.] [meets the requirements of paragraph ANTITERRORISM PERFORMANCE REQUIREMENTS.] Calculations verifying the structural performance of each window proposed for use, under the given loads, must be prepared and signed by a registered professional engineer. Reflect the window components and anchorage devices to the structure, as determined by the design analysis, in the shop drawings.

1.3.6 Test Report Requirements

****
NOTE: Include bracketed wording when windows are required to resist blast loads all required by UFC 4-010-01, DoD Minimum Antiterrorism Requirements for Buildings.
****

Submit test reports for each type of window attesting that identical windows have been tested and meet the requirements specified herein for conformance to AAMA/WDMA/CSA 101/I.S.2/A440 including test size, [and] minimum condensation resistance factor (CRF)[, and resistance to forced entry][, and, for Antiterrorism windows, in lieu of a Design Analysis, results of a Standard Airblast Test].[For Antiterrorism windows, in lieu of a Design Analysis, results of airblast testing, whether by arena test or shock tube, must be included in a test report, providing information in accordance with ASTM F1642/F1642M, as prepared by the independent testing agency performing the test. The test results must demonstrate the ability of each window proposed for use to withstand the airblast loading parameters and achieve the hazard level rating specified in paragraph STANDARD AIRBLAST TEST METHOD.]

1.3.7 Certification

****
NOTE: Energy Star Certification is required for residential windows. FEMP Designation, Passivhaus, and PHIUS Certifications are methods to ensure compliance with thermal performance.
****

Ensure that construction is performed with products that meet or exceed [Energy Star criteria,] [FEMP Designated criteria,] [and Passivhaus Criteria] [Passivhaus Certified] [and be current in their certification].[Provide PHIUS Certified window performance.]

Each prime window unit must bear the AAMA Label warranting that the product complies with AAMA/WDMA/CSA 101/I.S.2/A440. Certified test reports attesting that the prime window units meet the requirements of AAMA/WDMA/CSA 101/I.S.2/A440, including test size, will be acceptable in lieu of product labeling.

1.4 DELIVERY AND STORAGE

Deliver windows to project site in an undamaged condition. Use care in handling and hoisting windows during transportation and at the jobsite. Store windows and components out of contact with the ground, under a weathertight covering, so as to prevent bending, warping, or otherwise damaging the windows. Repair damaged windows to an "as new" condition as approved. If windows can not be repaired, provide a new unit.

1.5 PLASTIC IDENTIFICATION

****

NOTE: The marking system indicated below is intended to provide assistance in identification of products for making subsequent decisions as to handling, recycling, or disposal.

****

Label plastic products provided to indicate their polymeric composition according to the following list. Where products are not labeled, provide product data indicating polymeric information in Operation and Maintenance Manual.

a. Type 1: Polyethylene Terephthalate (PET, PETE).

b. Type 2: High Density Polyethylene (HDPE).

c. Type 3: Vinyl (Polyvinyl Chloride or PVC).

d. Type 4: Low Density Polyethylene (LDPE).

e. Type 5: Polypropylene (PP).

f. Type 6: Polystyrene (PS).

g. Type 7: Other. Use of this code indicates that the package in question is made with a resin other than the six listed above, or is made of more than one resin listed above, and used in a multi-layer combination.

1.6 PERFORMANCE REQUIREMENTS

1.6.1 Wind Loading Design Pressure

Design window components, including mullions, hardware, and anchors, to withstand a wind-loading design pressure of at least [_____] pascal pounds per square foot (psf).

[1.6.2 Tests

Test windows proposed for use in accordance with AAMA/WDMA/CSA 101/I.S.2/A440 for the particular type and quality window specified.

Perform tests by a nationally recognized independent testing laboratory equipped and capable of performing the required tests. Submit the results of the tests as certified laboratory reports required herein.

Minimum design load for a uniform-load structural test must be 2400 pascal

50 psf.

[Test projected windows in accordance with the applicable portions of the AAMA WSG.1 for air infiltration, water resistance, uniform-load deflection, and uniform-load structural test.

][Test double-hung windows in accordance with the applicable portions of the AAMA WSG.1 for air infiltration, water resistance, uniform-load deflection, and uniform-load structural test.

]]1.7 DRAWINGS

Submit the Fabrication Drawings for aluminum window units showing complete window assembly including hardware, weatherstripping, and subframe assembly details.

1.8 WINDOW PERFORMANCE

****

NOTE: Structural performance, air infiltration and water penetration are standard performance requirements for all aluminum window types.

Design must meet the requirements of UFC 1-200-02, "High Performance and Sustainable Building Requirements" which invokes the requirements within UFC 3-101-01, "Architecture". UFC 1-00-02 and UFC 3-101-01 make references throughout to various ASHRAE documents governing energy efficiency and requirements for the components of building envelope design including fenestrations and glazing.

ANTITERRORISM PERFORMANCE REQUIREMENTS and SOUND ATTENUATION sections below are optional to designer, and must be omitted or revised as needed to meet project requirements.

Applicability of UFC 4-010-01 DoD Minimum Antiterrorism Standards for Buildings

The antiterrorism (AT) standards contained in UFC 4-010-01 DO NOT establish the Design Basis Threat (DBT) or the Level of Protection (LOP) for DoD buildings. Installation Antiterrorism Plans may define a DBT for the installation. Use UFC 4-020-01 (Security Engineering: Facilities Planning Manual) to establish and/or validate the DBT and LOP for individual projects. The process outlined in UFC 4-020-01 will determine if the minimum AT standards are adequate or if additional protective measures are required. Where a specific DBT and LOP are identified, additional guidance is included in Appendix B (Best Practices) of UFC 04-010-01. For buildings that are outside an installation perimeter, use UFC 4-020-01 to establish the DBT and LOP. The DBT and LOP will result in a representative standoff distance for the appropriate construction - window systems (glazing, frame, connections) in this instance.

A structural analysis will need to be performed to determine if the most stringent loading on window assembly is from antiterrorism blast loads or windborne debris in high wind regions.
****

Aluminum windows must meet the following performance requirements. Perform testing requirements by an independent testing laboratory or agency.

1.8.1 Structural Performance

Structural test pressures on window units must be for positive load (inward) and negative load (outward). After testing, there will be no glass breakage, permanent damage to fasteners, hardware parts, support arms or actuating mechanisms or any other damage which could cause window to be inoperable. There must be no permanent deformation of any main frame, sash or ventilator member in excess of the requirements established by AAMA/WDMA/CSA 101/I.S.2/A440 for the window types and classification specified in this section.

[1.8.2 Antiterrorism Performance Requirements

Windows must meet the antiterrorism performance criteria as specified in the paragraphs below in accordance with UFC 4-010-01. Conformance to the performance requirements must be validated by one of the following methods.

1.8.2.1 Computational Design Analysis Method

Design window assembly to the criteria listed herein. Include computational design analysis calculations verifying the structural performance of each window assembly proposed for use, under the given static equivalent loads.

Design window frames, mullions, sashes, and glazing to the criteria listed herein. Include computational design analysis calculations verifying the structural performance of each window system proposed for use, under the given static equivalent loads.

****
NOTE: The blanks in the following paragraph should be the value of the equivalent 3-second duration design loading obtained from Figure 1 of ASTM F2248 for the explosive weight and standoff distance combination (based on the established DBT/LOP) that is being designed for in this project. This section must be completed by an engineer experienced in blast-resistant design.
****

Glazing resistance must be greater than equivalent 3-second duration loading of [_____] Pascal pounds per square foot (psf) for type [_____] window[and [_____] Pascal psf for the remaining window types]. The glazing frame bite for the window frames must be in accordance with ASTM F2248.

Design Aluminum/Steel window framing members to restrict deflections of the edges of glazing they support to L/60 under two times (2X) the glazing

resistance per the requirements of ASTM F2248 and ASTM E1300.

****

NOTE: Connection Design: For mullion and framing members designed using dynamic analysis or shown to work through airblast testing, all connections between mullions and/or framing members and all connections of storefront systems to the supporting structure must be designed for the full dynamic capacity of the attached member or the maximum calculated dynamic reaction with a load factor equal to 1.0. Use ultimate capacity of fasteners as recommended by the fastener manufacturer with a capacity reduction factor of 0.75. Use Load and Resistance Factor Design (LRFD) with appropriate reduction (phi) factors per material specific code for design of connections components into supporting structure. All dynamic and static material strength increase factors for the connection components must be equal to 1.0. All connection designs must be performed checking all conventional failure mechanisms. See Engineering Technical Report (PDC TR-10-02) titled Blast Resistant Design Methodology for Window Systems Designed Statically and Dynamically at USACE Protective Design Center (Website link: https://pdc.usace.army.mil/library/tr/10-02) for additional information. Calculations/Design Analysis for the connection design as stated above must be completed by an engineer experienced in blast-resistant design.

****

****

NOTE: Use the first bracketed requirement below if the maximum air blast pressure is greater than one-half the magnitude of the load resistance of the blast resistant glazing.

Use the second bracketed requirement below if the maximum air blast pressure is less than one-half the magnitude of the load resistance of the blast resistant glazing.

****

[Anchor window frames to the supporting structure with anchors designed to resist [two times (2X)][one time (1X)] the glazing resistance in accordance with ASTM F2248 and ASTM E1300.

]1.8.2.2 Dynamic Design Analysis Method

****

NOTE: The blanks in the following paragraph should be the value of the peak positive pressure and impulse for the explosive weight and standoff distance combination (based on the established DBT/LOP) that is being designed for in this project. Choose the first bracketed items, low hazard rating/very low level of protection for

inhabited building occupancy as defined in UFC 4-010-01 (Table B-1). Choose the second bracketed items, very low hazard rating/low level of protection for primary gathering/billeting building occupancy as defined in UFC 4-010-01 (Table B-1). Dynamic analysis is preferred because it typically yields a more appropriate and economical / efficient design. The values for input into the blanks in the following paragraph related to 'ductility ratio' and 'maximum support rotation' (for the appropriate level of protection – very low, low) for steel and aluminum framing/mullions can be found in Engineering Technical Report (PDC TR-10-02) titled Blast Resistant Design Methodology for Window Systems Designed Statically and Dynamically at USACE Protective Design Center (Website link: https://pdc.usace.army.mil/library/tr/10-02). This section must be completed by an engineer experienced in blast-resistant design.

****

Design window assembly using a dynamic analysis to prove the system will provide performance equivalent to or better than a [low];[very low]; [_____] hazard rating in accordance with ASTM F2912 for the peak positive pressure of [_____] kilopascals (kPa) [_____]pounds per square inch (psi) and peak positive phase impulse of [_____] kilopascal-millisecond (kPa-msec) [_____] pounds per square inch - millisecond (psi-msec). Use a triangular blast load using the applicable pressure and impulse indicated above. The allowable response limits of [aluminum] [steel] frame elements are as follows: Maximum ductility ratio of [_____] and maximum support rotation of [_____] degrees.

1.8.2.3 Standard Airblast Test Method

****

NOTE: The blanks in the following paragraph should be the value of the peak positive pressure and impulse for the explosive weight and standoff distance combination (based on the established DBT/LOP) that is being designed for in this project. Choose the first bracketed items, low hazard rating/very low level of protection for inhabited building occupancy as defined in UFC 4-010-01. Choose the second bracketed items, very low hazard rating/low level of protection for primary gathering building occupancy as defined in UFC 4-010-01. This section must be completed by an engineer experienced in blast-resistant design.

****

As an alternative to the 'Computational Design Analysis Method' and 'Dynamic Design Analysis Method' indicated above, window [_____] assembly may be tested for evaluation of hazards generated from airblast loading in accordance with ASTM F1642/F1642M by an independent testing agency regularly engaged in blast testing. For proposed window systems that are of the same type as the tested system but of different size, the test results may be accepted provided the proposed window size is within the range from 25 percent smaller to 10 percent larger in area and aspect ratio of the original qualified tested glazing systems in accordance with

ASTM F2912. Proposed window system/assembly of a size outside this range will require testing to evaluate their hazard rating or are certified by the 'Dynamic Design Analysis Method' indicated above. Testing may be by shock tube or arena test. Perform the test on the entire proposed window system/assembly, including, the glazing, its framing/support system, operating devices, and all anchorage devices. Window support system replicate anchorage of the window support system with the method of installation to be used for the project. The minimum airblast loading parameters for the test will be as follows: peak positive pressure of [_____] kilopascals (kPa) [_____] pounds per square inch (psi) and peak positive phase impulse of [_____] kilopascal-millisecond (kPa-msec) [_____] pounds per square inch - millisecond (psi-msec). The hazard rating for the proposed window systems, as determined by the rating criteria of ASTM F2912, to provide performance equivalent to or better than a [low];[very low]; [_____] hazard rating (i.e. the "No Break", "No Hazard", "Minimal Hazard", "Very Low Hazard" and “Low Hazard” ratings are acceptable. "High Hazard" ratings are unacceptable. Results of window systems previously tested by test protocols other than ASTM F1642/F1642M may be accepted provided the required loading, hazard level rating, and size limitations stated herein are met.

]1.8.3 Air Infiltration

Air infiltration must not exceed the amount established by AAMA/WDMA/CSA 101/I.S.2/A440 for each window type.

1.8.4 Water Penetration

Water penetration must not exceed the amount established by AAMA/WDMA/CSA 101/I.S.2/A440 for each window type.

1.8.5 Thermal Performance

****

NOTE: Window properties are critical to energy performance and comfort. Specify low U value (rate of heat transfer) to reduce winter heat loss and summer heat gain.

Energy Star labeling is applicable to residential units only.

For nonresidential applications, refer to UFC 1-200-02, High Performance and Sustainable Building Requirements, for minimum requirements for energy efficiency and meeting minimum building envelope requirements of UFC 3-101-01 including fenestrations and glazing.

Coordinate with Section 08 81 00 GLAZING. Designer must verify availability and adequate competition for products meeting bracketed energy performance requirements before specifying and edit as needed.

****

Windows (including frames and glass) will be independently tested and certified with a Solar Heat Gain Coefficient (SHGC) determined according to NFRC 200 procedures and a whole window U-factor determined in accordance with NFRC 100 within the ranges as indicated below according to

the ASHRAE 169 Climate Zone of the project location.[Windows used solely within the interior of a conditioned envelope are exempted from meeting U-Factor and SHGC requirements, unless otherwise noted.] Provide visual Transmittance (VT) of 0.5 or greater. Submit documentation supporting compliance with Energy Star, FEMP designated, and Passive House qualifications as applicable. Provide proof of Energy Star label for residential aluminum window products.

[1.8.5.1 Southern Climate

Windows installed in Climate Zone [1] [2] will have a U-Factor of [1.3] [1.25] [_____] W/m^2·degrees C [0.40][_____] BTU/h·ft^2·degrees F or less and a SHGC of [0.25] [_____] or less.

][1.8.5.2 South-Central Climate

Windows installed within Climate Zone 3 will have a U-Factor of [0.85] [1.25] [_____] W/m^2·degrees C [0.30][_____] BTU/h·ft^2·degrees F or less and a SHGC of [0.25] [_____] or less.

][1.8.5.3 North-Central Climate

Windows installed within Climate Zone 4 will have a U-Factor of [0.85] [1.25] [_____] W/m^2·degrees C [0.30] [_____] BTU/h·ft^2·degrees F or less and a SHGC of [0.36] [_____] or less.

][1.8.5.4 Northern Climate

Windows installed within Climate Zone [5] [6] [7] will have a U-Factor of [0.65] [1.25][_____] W/m^2·degrees C [0.27] [_____] BTU/h·ft^2·degrees F or less and a SHGC of [0.36] [0.41] [_____] or less.

][1.8.5.5 Subarctic Climate

Windows installed within Climate Zone 8 will have a U-Factor of [0.45] [1.25] [_____] W/m^2·degrees C [0.08] [0.22] [_____] BTU/h·ft^2·degrees F or less. There is no SHGC limit for this climate zone.

][1.8.6 Life Safety Criteria

****

NOTE: Designer must indicate on the drawings which windows serve as rescue and/or secondary means of escape.

****

Provide windows that conform to NFPA 101 Life Safety Code when rescue and/or second means of escape are indicated.

][1.8.7 Sound Attenuation

****

NOTE: Aluminum environmental control windows have a "built-in" sound attenuation. This paragraph will be used only when sound attenuation is a design parameter. Use outside-indoor transmission class (OITC) when exterior source noise is a concern.

****

When tested in accordance with AAMA/WDMA/CSA 101/I.S.2/A440 or the following below, provide a minimum Sound Transmission Class (STC) of 35 in accordance with ASTM E90 and as determined by ASTM E413 or Outside-Indoor Transmission Class (OITC) of 25 in accordance with ASTM E1332 and as determined by ASTM E413 with the window glazed with 13 mm 1/2 inch air space between two pieces of 6 mm 1/4 inch.

][1.8.8 Windborne-Debris-Impact Performance

****
NOTE: Retain WINDBORNE-DEBRIS-IMPACT RESISTANCE Paragraph if required by Project. The UFC 1-200-01 DoD Building Code cited IBC defines windborne debris regions. Enhanced protection applies to essential facilities. Verify site specific requirements with the AHJ. Delete items not required.
****

Exterior window system including glazing must comply with indicated basis or enhanced protection testing requirements in ASTM E1996 for [Wind Zone 1] [Wind Zone 2] [Wind Zone 3] [Wind Zone 4] when tested according to ASTM E1886. Test specimens must be no smaller in width and length than glazing indicated for use on Project and must be installed in same manner as glazing indicated for use on Project.

a. Refer to drawings for classification of window requiring basic or enhanced protection.

[b. Large-Missile Test: For glazing located within 9.1 m 30 feet of grade.

][c. Small-Missile Test: For glazing located more than 9.1 m 30 feet above grade.

]]1.9 WARRANTY

Provide Manufacturer's standard performance guarantees or warranties that extend beyond a 1 year period.

PART 2 PRODUCTS

2.1 WINDOWS

****
NOTE: AAMA/WDMA/CSA 101/I.S.2/A440 includes a designation system with a four part code, which includes Product Type, Performance Class, Performance Grade (design pressure) and maximum size tested to achieve desired rating (example Double Hung or H, CW30 760 by 1520 (30 by 60)). Product Type is an abbreviation for window type (AP for awning, hopper, projected window, C for casement, H for hung, etc.). Performance classes represent the level of performance (R, LC, CW and AW). Performance Grade represents the design pressure to which the window is constructed.

AAMA/WDMA/CSA 101/I.S.2/A440 establishes minimum Performance Grade for each Performance Class: 15

for R (corresponding to a design pressure of 720 Pa 15 psf); 25 for LC (corresponding to a design pressure of 1200 Pa 25 psf); 30 for CW (corresponding to a design pressure of 1440 Pa 30 psf); and 40 for AW (corresponding to a design pressure of 1920 Pa 40 psf).

AAMA/WDMA/CSA 101/I.S.2/A440 also includes criteria for specifying windows required to meet higher design pressures if minimum pressure is inadequate. These windows are designated as Optional Performance Grade and should be specified in increments of 240 Pa 5 psf above the minimum Performance Grade.

****

****

NOTE: Consult AAMA 1503 "Voluntary Test Method for Transmittance and Condensation Resistance of Windows, Doors and Glazed Wall Sections" and select the minimum Condensation Resistance Factor (CRF) required for the particular project conditions.

****

****

NOTE: Consult AAMA/WDMA/CSA 101/I.S.2/A440 to calculate design pressure(s) applicable to the project. Adjust "design factors" because naval facilities are typically less than 100 miles from hurricane ocean line.

****

****

NOTE: Use materials with recycled content where appropriate for use. Verify suitability, availability within the region, cost effectiveness and adequate competition before specifying product recycled content requirements.

****

Provide prime windows that comply with AAMA/WDMA/CSA 101/I.S.2/A440 and the requirements specified herein. In addition to compliance with AAMA/WDMA/CSA 101/I.S.2/A440, window framing members for each individual light of glass must not deflect to the extent that deflection perpendicular to the glass light exceeds L/175 of the glass edge length when subjected to uniform loads at specified design pressures. Provide Structural calculations for deflection to substantiate compliance with deflection requirements. Provide windows of types, performance classes, performance grades, combinations, and sizes indicated or specified.[Provide aluminum window frames with a minimum recycled content of 20 percent. Provide data identifying percentage of recycled content of aluminum windows.] Design windows to accommodate hardware, glass, weatherstripping, screens, and accessories to be furnished. Each window must be a complete factory assembled unit with or without glass installed. Dimensions shown are minimum. Provide windows with insulating glass and thermal break necessary to achieve a minimum Condensation Resistance Factor (CRF) of [_____] when tested in accordance with AAMA 1503. Provide manufacturer's standard hardware fabricated from aluminum, stainless steel, carbon steel complying with AAMA 907, or other corrosion-resistant material compatible with adjacent materials; designed

to smoothly operate, tightly close, and securely lock windows, and sized to accommodate sash weight and dimensions.

****

NOTE: Performance Grades represent design pressure values for which products have been tested. Specify an Optional Performance Grade where a higher than minimum Performance Grade is desired due to severe weather conditions and wind loadings. Optional Performance Grade windows must be tested in compliance with AAMA/WDMA/CSA 101/I.S.2/A440. Testing must substantiate requirements for uniform loading (structural), water resistance, and air infiltration.

****

2.1.1 Awning Windows (AP)

Type AP-[R15] [LC25] [CW30] [AW40] [[R] [LC] [CW] [AW]- [_____] (Optional Performance Grade)]. Conceal operating mechanism within the frame members or enclose within a metal casing not less than 1.59 mm 0.0625 inch thick sheet aluminum.

2.1.2 Casement Windows (C)

Type C-[R15] [LC25] [CW30] [AW40] [[R] [LC] [CW] [AW]- [_____] (Optional Performance Grade)]. Ventilators must be[rotary crank][handle] operated. Provide ventilators over 1650 millimeters 65 inches high with two separate locking devices or a two-point locking device operated by rods from a single lever handle. Conceal rods where possible.[Provide casement windows in combination with [fixed][projected] windows specified below.]

2.1.3 Hung Windows (H)

****

NOTE: Tilt-in windows most likely will not meet ATFP pressure requirements and should not be specified if force protection is required.

****

[Double][_____] Hung, Type H-[R15] [LC25] [CW30][AW40] [[R] [LC] [CW] [AW]- [_____] (Optional Performance Grade)]. Test and rate sash balance to conform with AAMA 902.

Design windows, mullions, hardware, and anchors to withstand the wind loading specified.

2.1.4 Horizontal Sliding Windows (HS)

Type HS-[R15] [LC25] [CW30] [AW40] [[R] [LC] [CW] [AW]- [_____] (Optional Performance Grade)].

2.1.5 Projected Windows (AP)

Type AP-[R15] [LC25] [CW30] [AW40] [[R] [LC] [CW] [AW]- [_____] (Optional Performance Grade)]. Provide projected windows with concealed four bar friction hinges only. Gear-type rotary hardware to comply with AAMA 901. Provide operators that function without requiring the removal of interior

screens.

2.1.6 Top-Hinged Windows (TH)

Type TH-[CW30] [AW40] [[CW] [AW]- [_____] (Optional Performance Grade)]. Top-hinged windows must be [inswinging][outswinging].

2.1.7 Vertically Pivoted Windows (VP)

****

NOTE: Pivoting windows most likely will not meet ATFP pressure requirements and should not be specified if force protection is required.

****

Type VP-[R15] [LC25] [CW30] [AW40] [[R] [LC] [CW] [AW]-[_____] (Optional Performance Grade)].[Provide window with remotely operated venetian blind mounted between an access sash and the main sash.]

2.1.8 Fixed Windows (F)

Type F-[R15] [LC25] [CW30] [AW40] [[R] [LC] [CW] [AW]- [_____] (Optional Performance Grade)].

2.1.9 Forced Entry Resistant Windows

****

NOTE: Conventional aluminum windows offer nominal resistance to forced entry by unskilled or opportunistic intruders. While there is no way to make a window absolutely "burglar proof," windows complying with AAMA 1302 can provide reasonable assurance that entry, or attempted entry, will leave ample evidence of "forced entry." It establishes only a pass/fail condition when specific concentrated loads are applied to sash or ventilator in attempt to open or remove sash or ventilator from window frame and specifies no measured time delay. It provides moderate degree of security against unskilled or opportunistic intruder at little or no additional cost. When forced entry resistant windows are specified, coordinate glazing requirements and specify impact resistant glass and glazing materials in Section 08 81 00 GLAZING.

For projects requiring security windows, specify steel security windows in Section 08 51 23 STEEL WINDOWS. Protection in high crime areas against skilled professional intruders requires a more sophisticated approach to physical security. Consult Design Manual 13.1 "Physical Security" for recommendations.

****

In addition to meeting the requirements of AAMA/WDMA/CSA 101/I.S.2/A440, windows designated for resistance to forced entry must conform to the requirements of AAMA 1302.4.

2.1.10 Glass and Glazing

Materials are specified in Section 08 81 00 GLAZING.

2.1.11 Caulking and Sealing

Are specified in Section 07 92 00 JOINT SEALANTS.

2.1.12 Weatherstripping

AAMA/WDMA/CSA 101/I.S.2/A440. Provide for all ventilating (operable) sash for all windows. Provide woven wool pile weatherstripping 5.3 millimeter 0.210 inch thick, conforming to AAMA 701/702, or polypropylene multifilament fiber weatherstripping installed in an integral weatherstripping groove in the sash or frame, and flexible polyvinylchloride weatherstripping installed in the sill member.

2.1.13 Sash Poles

Seamless aluminum tube, 1.59 mm 0.0625 inch minimum wall thickness, 25 mm one inch diameter, [_____] m feet long, with cast aluminum hook and protective cover or tip on the lower end. Finish must match windows.

2.2 FABRICATION

Fabrication of window units must comply with AAMA/WDMA/CSA 101/I.S.2/A440.

2.2.1 Provisions for Glazing

****
NOTE: Specify glass thickness and vinyl gaskets in Section 08 81 00 GLAZING. Inside glazing is preferred, especially for windows above first floor and other locations where access is difficult. Windows designed for inside glazing may not be available in double-hung type; check manufacturers' literature. Where project requires insulating glass, show sash members, glazing beads, and hardware of sufficient size and weight to receive and support glass of thickness specified. Allow 3 mm 1/8 inch minimum between each side of insulating glass and metal frame and between edges of glass and frame for glazing compound and expansion. Drawings must clearly indicate method for securing insulating glass in place.
****

****
NOTE: Include the bracket option for minimum glazing frame bite requirements when personnel density is greater than one person per 40 square meters 430 square feet and minimum ATFP standoff distances are met. This does not include guard type facilities, single and duplex detached family housing. These requirements are specified in Department of Defense Antiterrorism Standards for Buildings.
****

Design windows and rabbets suitable for glass thickness shown [or specified].[For minimum antiterrorism windows, attach glazing to its supporting frame using structural silicone sealant or adhesive glazing tape in accordance with ASTM F2248.] Design sash for[inside][outside][single][double] glazing and for securing glass with[metal beads,][glazing clips,][glazing channels,] or glazing compound.

2.2.2 Fasteners

Use window manufacturer's standard for windows, trim, and accessories. Self-tapping sheet-metal screws are not acceptable for material more than 2 mm 1/16 inch thick.

2.2.3 Adhesives

Provide joint sealants as specified in Section 07 92 00 JOINT SEALANTS. For interior application of joint sealants, comply with applicable regulations regarding reduced VOC's, and as specified in Section 07 92 00 JOINT SEALANTS.

2.2.4 Drips and Weep Holes

Provide continuous drips over heads of top ventilators. Where fixed windows adjoin ventilators, drips must be continuous across tops of fixed windows. Provide drips and weep holes as required to return water to the outside.

2.2.5 Combination Windows

Windows used in combination must be factory assembled of the same class and grade. Where factory assembly of individual windows into larger units is limited by transportation considerations, prefabricate, match mark, transport, and field assemble.

2.2.6 Mullions and Transom Bars

****
NOTE: Specify the design pressure used to specify the Performance Grade or the Optional Performance Grade for the adjoining windows.
****

****
NOTE: Include the bracketed paragraph included under the "WINDOWS" heading for static loads when minimum measures of antiterrorism/force protection (ATFP) are required and delete the first bracketed sentence in the following paragraph.
****

[Provide mullions between multiple window units to resist two times (2X) glazing resistance in accordance with ASTM F2248 and ASTM E1300.]Provide mullions with a thermal break. Secure mullions and transom bars to adjoining construction and window units in such a manner as to permit expansion and contraction and to form a weathertight joint.[Where window cleaner anchors are required, reinforce mullions and anchor to adjoining construction so as to provide safe and adequate support.] Provide mullion covers on the interior and exterior to completely close exposed joints and recesses between window units and to present a neat appearance.[Provide

special covers over structural support at mullions as indicated.]

2.2.7 Accessories

Provide windows complete with necessary hardware, fastenings, clips, fins, anchors, glazing beads, and other appurtenances necessary for complete installation and proper operation.[Furnish extruded aluminum subframe receptors[and subsill] with each window unit.]

2.2.7.1 Hardware

****
NOTE: Use stainless steel hardware in humid locations or project locations with Environmental Severity Classifications (ESC) of C3 thru C5. Humid locations are those in ASHRAE climate zones 0A, 1A, 2A, 3A, 3C, 4C and 5C (as identified in ASHRAE 90.1). See UFC 1-200-01 for determination of ESC for project locations.
****

AAMA/WDMA/CSA 101/I.S.2/A440. The item, type, and functional characteristics must be the manufacturer's standard for the particular window type. Provide [stainless steel]hardware of suitable design and of sufficient strength to perform the function for which it is used. Equip all operating ventilators with a lock or latching device which can be secured from the inside.

2.2.7.2 Fasteners

Provide concealed anchors of the type recommended by the window manufacturer for the specific type of construction. Anchors and fasteners must be compatible with the window and the adjoining construction. Provide a minimum of three anchors for each jamb located approximately 150 mm 6 inches from each end and at midpoint.

2.2.7.3 Window-Cleaner Anchors

****
NOTE: Window-cleaner anchors should be shown and specified for windows having sills more than 1800 mm 6 feet above grade, adjoining balconies, or adjoining roofs, unless window cleaning methods at activity make use of anchors unnecessary. Coordinate window cleaning procedures and requirements with using activity. When requested by using activity, removable or tilting-type sash may be provided instead of anchors. Removable or tilting-type sash may be specified as Contractor option when these units are desired by using activity and are economically competitive with double-hung sash equipped with anchors. When appropriate, add the following at end of paragraph WINDOW-CLEANER ANCHORS:

"Removable or tilting-type sash may be provided in lieu of double-hung windows equipped with window cleaner anchors. Design sash so that both sides of glass can be readily cleaned from interior without

dismantling any part of window or screens. Provide removable and tilting-type sash with tamper-proof hardware to prevent sash removal by unauthorized personnel."

****

Provide double head anchors for windows[indicated][specified]. Anchors must be stainless steel of size and design required for the window type and application, conforming to ASTM A276/A276M. Provide two anchors for each single window[and each adjacent fixed glass window unit]. Fasten anchors 1120 mm 44 inches above the window sill utilizing appropriate methods for the window type and application in accordance with industry safety standards.

2.2.7.4 Window Anchors

Anchoring devices for installing windows must be made of aluminum, cadmium-plated steel, stainless steel, or zinc-plated steel conforming to AAMA/WDMA/CSA 101/I.S.2/A440.

2.2.8 Finishes

****

NOTE: Specify anodic and organic coatings as Contractor's option when these finishes are determined to be economically competitive in the project area, unless the project requires use of one or the other to match an existing condition.

****

Comply with NAAMM's "Metal Finishes Manual" for applying and designating finishes. Exposed aluminum surfaces must be factory finished with an[anodic coating][or][organic coating].[Color must be [_____][as indicated].] All windows[for each building] must have the same finish.

2.2.8.1 Anodic Coating

****

NOTE: Specify Architectural Class I in locations with an Environmental Severity Classification (ESC) of C3 through C5, locations where microenvironments may create a locally corrosive environment regardless of ESC (e.g., prevailing winds, ventilation, waterfront environments, and penetrations of the building envelope), high humidity interior areas (bathrooms, locker rooms, pools, trainers), areas open to the exterior (mechanical rooms and hangars), and spaces that are not conditioned by design or may not be conditioned during prolonged periods due to deployment or non-occupancy. See UFC 1-200-01 for determination of ESC for project locations. Specify Architectural Class II for all atmospheric conditions not requiring Class I.

****

Clean exposed aluminum surfaces and provide an anodized finish conforming to AA DAF45 and AAMA 611. Finish must be:

[a. Architectural Class II (0.01 to 0.0175 mm 0.4 mil to 0.7 mil), designation AA-M10-C22-[A31, clear (natural)] [A32, integral color] [A34, electrolytically deposited color] anodized.

][b. Architectural Class I (0.0175 mm 0.7 mil or thicker), designation AA-M10-C22-[A41, clear (natural)] [A42, integral color] [A44, electrolytically deposited color] anodized.

]2.2.8.2 Organic Coating

****

NOTE: When anodic and organic coatings are determined to be economically competitive in the project area, specify baked enamel finish (AAMA 2603) as an option to Architectural Class II, anodic coating or high-performance finish (AAMA 2604 or AAMA 2605) as an option to Architectural Class I, anodic coating.

****

Clean and prime exposed aluminum surfaces. Provide a[baked enamel finish in accordance with AAMA 2603 with total dry film thickness not less than 0.02 mm 0.8 mil][high-performance finish in accordance with [AAMA 2604][AAMA 2605] with total dry film thickness of not less than 0.03 mm 1.2 mils].

2.2.9 Screens

AAMA/WDMA/CSA 101/I.S.2/A440. Provide one insect screen for each operable exterior sash or ventilator. Design screens to be rewirable, easily removable from inside the building, and to permit easy access to operating hardware. Manufacturers standard aluminum frame complying with SMA 1004 or SMA 1201. Fabricate frames with mitered or coped joints or corner extrusion, concealed fasteners and removable PVC spline/anchors concealing edge of frame.

2.2.9.1 Insect Screen

Insect screen mesh to be[Glass-fiber mesh, 18x16 of PVC-coated glass-fiber threads; woven and fused to form a fabric mesh in accordance with ASTM D3656/D3656M][Aluminum wire fabric, 18x16 mesh of 0.2794 mm 0.011 inch diameter coated aluminum wire].

2.3 SPECIAL OPERATORS

****

NOTE: Remote and group operated windows will require special operators. Identify these windows on the drawings and show method of operation.

****

For windows having operating hardware or locking or latching devices located more than 1800 mm 6 feet above the floor, provide suitably designed operators or locking or latching devices necessary for convenient and proper window operation.

2.3.1 Pole Operators

Poles must be of proper length to permit window operation from 1500 mm 5

feet above the floor. Provide one pole operator for each room, and one pole hanger for each pole. Locate hangers where directed.

2.3.2 Extension Crank Operators

Provide removable handles for crank-operated rotary-type operators located more than 1800 mm 6 feet above the floor. Provide one removable handle for each room.

2.3.3 Mechanical Operators

****
NOTE: When motor driven operators are specified, specify electrical characteristics in Section 26 20 00, INTERIOR DISTRIBUTION SYSTEM.
****

Provide [manual] [electric motor driven] operators for group operation of continuous rows of windows [located [_____] mm feet above the floor]. Operators must be capable of opening and closing windows without appreciable deflection, vibration or rattle. Provide means of adjustment for transmission lines. Provide operators to control window units in groups [as recommended by the window manufacturer] [or] [as indicated].

2.4 THERMAL-BARRIER WINDOWS

Provide thermal-barrier windows, complete with accessories and fittings, where indicated.

Specify material and construction except as follows:

a. Aluminum alloy must be 6063-T6.

b. Frame construction, including operable sash, must be factory-assembled and factory-sealed inner and outer aluminum completely separated from metal-to-metal contact. Join assembly by a continuous, concealed, low conductance divider housed in an interlocking extrusion of the inner frame. Metal fasteners, straps, or anchors must not bridge the connection between the inner and outer frame.

c. Operating hardware for each sash must consist of spring-loaded nylon cushion blocks and pin locks designed to lock in predetermined locations.

d. Sash must be completely separated from metal-to-metal contact by means of woven-pile weatherstripping, plastic, or elastomeric separation members.

e. Operating and storm sash must be factory-glazed with the type of glass indicated and of the quality specified in Section 08 81 00 GLAZING.

2.5 MULLIONS

****
NOTE: Drawings must indicate the profile and dimensions of mullions, anchorage and reinforcing members as required for wind loading, and the type, profile, and fastening system for the mullion cover (screw-fastened or snap-on).

****

Provide mullions between multiple-window units where indicated.

Provide profiles for mullions and mullion covers, reinforced as required for the specified wind loading, and securely anchored to the adjoining construction. Mullion extrusion will include serrations or pockets to receive weatherstripping, sealant, or tape at the point of contact with each window flange.

Mullion assembly must include aluminum window clamps or brackets screwed or bolted to the mullion and the mullion cover.

Mullion cover must be screw-fastened to the mullion unless otherwise indicated.

Mullion reinforcing members must be fabricated of the materials specified in AAMA/WDMA/CSA 101/I.S.2/A440 and meet the specified design loading.

2.6 WINDOW CLEANERS' BOLTS

Provide window cleaners' bolts for all windows 2100 millimeter 7 feet or higher above finished grade, except for windows that can be removed and cleaned from the ground or from a lower roof level without the use of an extension ladder. Provide two bolts for each single window unit and each fixed glass unit. Locate bolts 1120 millimeter 44 inches above the window sill.

Window cleaners' bolts must be double-head type, AISI Series 300 corrosion-resistant steel, size and design complying with IWCA I-14.1. Contact side of the bolts must be ground to fit flat against window jambs. Bolts must be factory- or field-attached before windows are set. Reinforce backs of frames to receive bolts with 6 by 150 millimeter 1/4 by 6-inch corrosion-resistant steel or aluminum plates bolted or welded to the frames at the factory. Special wall anchors must be provided on frames at the point of bolt attachment.

PART 3 EXECUTION

3.1 SCHEDULE

Some metric measurements in this section are based on mathematical conversion of inch-pound measurements, and not on metric measurement commonly agreed to by the manufacturers or other parties. The inch-pound and metric measurements are as follows:

PRODUCTS	INCH-POUND	METRIC
Metal Casing	0.0625 inch	1.59 mm
Aluminum Tube (Diameter)	0.0625 inch	1.59 mm
	1 inch	25 mm

3.2 INSTALLATION

3.2.1 Method of Installation

Install in accordance with the window manufacturer's printed instructions and details. Build in windows as the work progresses or install without forcing into prepared window openings. Set windows at proper elevation, location, and reveal; plumb, square, level, and in alignment; and brace, strut, and stay properly to prevent distortion and misalignment. Protect ventilators and operating parts against accumulation of dirt and building materials by keeping ventilators tightly closed and locked to frame. Bed screws or bolts in sill members, joints at mullions, contacts of windows with sills, built-in fins, and subframes in mastic sealant of a type recommended by the window manufacturer. Install and caulk windows in a manner that will prevent entrance of water and wind. Fasten insect screens securely in place.

Any materials that show visual evidence of biological growth due to the presence of moisture must not be installed on the building project.

3.2.2 Dissimilar Materials

Where aluminum surfaces are in contact with, or fastened to masonry, concrete, wood, or dissimilar metals, except stainless steel or zinc, protect the aluminum surface from dissimilar materials as recommended in the Appendix to AAMA/WDMA/CSA 101/I.S.2/A440. Do not coat surfaces in contact with sealants after installation with any type of protective material. Do not apply coatings or lacquers to surfaces to which caulking and glazing components must adhere.

3.2.3 Anchors and Fastenings

Make provision for securing units to each other, to masonry, and to other adjoining construction. Windows installed in masonry walls must have head and jamb members designed to recess into masonry wall not less than 11 mm 7/16 inch.

3.2.4 Adjustments After Installation

After installation of windows and completion of glazing and field painting, adjust all ventilators and hardware to operate smoothly and to provide weathertight sealing when ventilators are closed and locked. Lubricate hardware and operating parts as necessary.[Adjust double hung windows to operate with maximum applied force of 25 pounds in either direction, not including breakaway friction force.] Verify that products are properly installed, connected, and adjusted.

3.3 CLEANING

Clean interior and exterior surfaces of window units of mortar, plaster, paint spattering spots, and other foreign matter to present a neat appearance, to prevent fouling of weathering surfaces and weather-stripping, and to prevent interference with the operation of hardware. Replace all stained, discolored, or abraded windows that cannot be restored to their original condition with new windows.

-- End of Section --