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USACE / NAVFAC / AFCEA / NASA UFGS-08 56 63 (April 2006)  
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Preparing Activity: NAVFAC Replacing without change  
UFGS-11191 (September 1999)

## UNIFIED FACILITIES GUIDE SPECIFICATIONS

References are in agreement with UMRL dated October 2010

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### SECTION 08 56 63

#### DETENTION AND SECURITY WINDOWS

04/06

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NOTE: This guide specification covers the requirements for detention steel cell windows.

Edit this guide specification for project specific requirements by adding, deleting, or revising text. For bracketed items, choose applicable items(s) or insert appropriate information.

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).

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NOTE: The following information shall be shown on the project drawings:

1. Jamb, head and sill sections.
2. Method of anchoring and spacing; type of anchor.
3. Window elevations and dimensions.
4. Type of glazing.
5. Elevations above finished floor.
6. Details of non-structural mullions and mullion covers.

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## PART 1 GENERAL

### 1.1 REFERENCES

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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 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.

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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.

ASME INTERNATIONAL (ASME)

ASME B18.6.3 (2003; R 2008) Machine Screws and Machine Screw Nuts

ASME B18.6.4 (1999; R 2005) Thread Forming and Threaded Cutting Tapping Screws and Metallic Drive Screws (Inch Series)

ASTM INTERNATIONAL (ASTM)

ASTM A 1011/A 1011M (2010) Standard Specification for Steel, Sheet, and Strip, Hot-Rolled, Carbon, Structural, High-Strength Low-Alloy and High-Strength Low-Alloy with Improved Formability and Ultra-High Strength

ASTM A 123/A 123M (2009) Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products

ASTM A 153/A 153M (2009) Standard Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware

ASTM A 167 (1999; R 2009) Standard Specification for Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip

ASTM A 239 (1995; R 2009e1) Standard Practice for Locating the Thinnest Spot in a Zinc (Galvanized) Coating on Iron or Steel Articles

ASTM A 627 (2003) Standard Specification for

Tool-Resisting Steel Bars, Flats, and  
Shapes for Detention and Correctional  
Facilities

ASTM A 653/A 653M

(2009a) Standard Specification for Steel  
Sheet, Zinc-Coated (Galvanized) or  
Zinc-Iron Alloy-Coated (Galvannealed) by  
the Hot-Dip Process

ASTM A 90/A 90M

(2009) Standard Test Method for Weight  
[Mass] of Coating on Iron and Steel  
Articles with Zinc or Zinc-Alloy Coatings

ASTM B 766

(1986; R 2008) Standard Specification for  
Electrodeposited Coatings of Cadmium

ASTM E 283

(2004) Determining the Rate of Air Leakage  
Through Exterior Windows, Curtain Walls,  
and Doors Under Specified Pressure  
Differences Across the Specimen

ASTM E 330

(2002; R 2010) Structural Performance of  
Exterior Windows, Doors, Skylights and  
Curtain Walls by Uniform Static Air  
Pressure Difference

ASTM E 331

(2000; R 2009) Water Penetration of  
Exterior Windows, Skylights, Doors, and  
Curtain Walls by Uniform Static Air  
Pressure Difference

STEEL WINDOW INSTITUTE (SWI)

SWI AGSW

(2002) Architect's Guide to Steel Windows

## 1.2 SUBMITTALS

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NOTE: Review submittal description (SD) definitions  
in Section 01 33 00 SUBMITTAL PROCEDURES and edit  
the following list to reflect only the submittals  
required for the project. Submittals should be kept  
to the minimum required for adequate quality control.

A "G" following a submittal item indicates that the  
submittal requires Government approval. Some  
submittals are already marked with a "G". Only  
delete an existing "G" if the submittal item is not  
complex and can be reviewed through the Contractor's  
Quality Control system. Only add a "G" if the  
submittal is sufficiently important or complex in  
context of the project.

For submittals requiring Government approval on Army  
projects, a code of up to three characters within  
the submittal tags may be used following the "G"  
designation 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.

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

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Government approval is required for submittals with a "G" designation; submittals not having a "G" designation are [for Contractor Quality Control approval.] [for information only. When used, a designation following the "G" designation identifies the office that will review the submittal for the Government.] The following shall be submitted in accordance with Section 01 33 00 SUBMITTAL PROCEDURES:

#### SD-02 Shop Drawings

##### Window units

Indicate the elevations of windows, half-size sections, thicknesses and gages of metal, fastenings, proposed method of anchoring, the size and spacing of anchors, details of construction, method of glazing, mullion details, casings, sills, trim, other related items, and installation details.

#### SD-03 Product Data

##### Window units

##### Fasteners

##### Accessories

Include finishes.

#### SD-06 Test Reports

##### Air infiltration

##### Water infiltration

##### Mullion and transom bar wind load

### 1.3 QUALITY ASSURANCE

The requirements specified in this section govern where there is a difference between this section and the referenced industry specifications.

#### 1.3.1 Test Reports

##### 1.3.1.1 Air and Water Infiltration Tests

ASTM E 283 and ASTM E 331. Air infiltration shall not exceed 0.8 L/s per meter one-half cubic foot per minute per foot of crack length when subjected to a static pressure of 75 Pa 1.56 pounds per square foot

(equivalent to a wind velocity of 40 km/hr 25 miles per hour). The amount of water infiltration shall be "zero" when tested in accordance with ASTM E 331.

#### 1.3.1.2 Mullion and Transom Bar Wind Load Tests

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NOTE: Specify wind loading requirements in areas subject to high wind velocities in excess of 110 km/hr 70 MPH; otherwise delete. The wind loading of 960 Pa 20 psf is based on a 145 km/hr 90 mph wind velocity at 61 m 200 feet above grade.

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NOTE: Delete when not applicable.

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ASTM E 330. Members shall withstand a uniform wind load of 960 Pa 20 pounds per square foot of window area without deflecting more than 1/175 of the span.

#### 1.4 DELIVERY, STORAGE, AND HANDLING

Deliver windows to project site in an undamaged condition. Store windows and components at the site on edge, out of contact with the ground, and under a weathertight covering.

### PART 2 PRODUCTS

#### 2.1 MATERIALS

##### 2.1.1 Steel Bars

SWI AGSW.

##### 2.1.2 Sheet Steel

ASTM A 1011/A 1011M.

##### 2.1.3 Zinc-Coated Sheet Steel

ASTM A 653/A 653M.

##### 2.1.4 Zinc-Coated Steel

ASTM A 90/A 90M, ASTM A 123/A 123M or ASTM A 153/A 153M.

##### 2.1.5 Corrosion Resisting Sheet Steel

ASTM A 167.

##### 2.1.6 Screws and Bolts

ASTM B 766, ASME B18.6.3, or ASME B18.6.4, as applicable.

#### 2.2 WINDOW UNITS

Units shall conform to the SWI AGSW, except as modified herein.

## 2.3 FABRICATION

Form permanent joints by welding or by mechanically fastening as specified [for each type window]. Use joints of strength required to maintain the structural value of members connected. Weld joints solid, remove excess metal, and dress smooth on exposed and contact surfaces. Closely fit joints formed with mechanical fastenings and make permanently watertight. Assemble frames at the plant, and ship as a unit with hardware unattached.

### 2.3.1 Window Sections

Where fixed window sections adjoin, provide a fixed sash, fabricated from similar frame members and of the manufacturer's standard type suitable for the purpose. [Roll weathering surfaces integrally to provide two-point, parallel-surface contact with an overlap at both inside and outside points of closure.]

### 2.3.2 Drainage Holes

Provide drips and weep holes, as required, to return water to outside, minimum of two per window.

### 2.3.3 Fasteners

Use flat or oval head spanner, twist-off or safety head screws and bolts with standard threads on windows, trim and accessories. Self tapping sheet-metal screws are not acceptable.

### 2.3.4 Fastener Finish

Fabricate windows with hot-dipped galvanized finish, using stainless steel or hot-spun galvanized steel fasteners. Use heavily cadmium plated steel fasteners for windows with painted finish or electrogalvanized in accordance with [ASTM A 239](#). Finish exposed heads of fasteners to match finish of windows.

### 2.3.5 Frames

Form frames from low carbon steel not less than 12 U.S. gage. Frames shall be one piece, channel shaped sections, at each jamb and between jamb at head and sill. Cope or miter and weld frame members at corners full depth of the frame for maximum strength and weathertightness; dress exposed welds smooth. Provide frame members with dimensions and profiles indicated. Provide [20 by 57 mm 3/8 by 2 1/4 inch](#), tool resistant steel flats conforming to [ASTM A 627](#), penetrated by [22 mm 7/8 inch](#) tool-resistant steel rounds conforming to [ASTM A 627](#) in frame members.

## 2.4 PROVISIONS FOR GLAZING

Design for outside single glazing and for securing glass with metal beads and glazing compound. Glazing specified in Section [08 88 53](#) DETENTION AND SECURITY GLAZING.

## 2.5 SCREENS

Provide manufacturer's standard screens for window units with movable sash, galvanized frame.

## 2.6 ACCESSORIES

Provide windows complete with necessary hardware, fastenings, clips, fins, anchors, glazing beads, and other appurtenances necessary for complete installation of windows.

## 2.7 ANCHORS

Use hot-dip, zinc-coated steel anchors of the type indicated or specified. Use cadmium or zinc-coated nuts, bolts, and other fasteners for ferrous material.

## 2.8 SHOP PRIMED FINISH

After fabrication, clean surfaces of windows, fins, mullions, cover plates [and screen frames], provide a hot-dip galvanized, phosphate-treated and shop primed finish. The methods of cleaning, chemical treating, galvanizing, and painting shall conform to SWI AGSW. Windows shall receive finish paint coats as specified in Section 09 90 00 PAINTS AND COATINGS.

# PART 3 EXECUTION

## 3.1 INSTALLATION

Install windows in accordance with the manufacturer's printed instructions and details, except as specified otherwise in this section. Build in windows as the work progresses. Set windows at indicated elevation, location, and reveal. Set plumb, square, level, and in alignment. Brace, strut, and stay to prevent distortion and misalignment.

## 3.2 ANCHORS AND FASTENINGS

Place anchorage as wall construction progresses. Build in anchors or bolt anchors and fastenings to the jambs of openings and weld securely to the windows or frames and to the adjoining construction. Space anchors not more than 400 mm 16 inches apart on jambs, and install a minimum of four anchors on each side of each opening. Anchors and fastenings shall have sufficient strength to hold the member firmly in position.

## 3.3 SEALANTS

Section 07 92 00 JOINT SEALANTS.

## 3.4 CLEANING

Clean metal surfaces of windows, inside and outside, of mortar, plaster, paint, and other foreign matter to present a neat appearance and to prevent fouling of weathering surfaces. Clean and touch-up abraded surfaces of steel windows. Replace stained, discolored, or abraded windows that cannot be restored to their original condition with new windows.

-- End of Section --