

# GUIDE SPECIFICATION

Boyd Aluminum Manufacturing Company  
P.O. Box 1565  
3248 E. Division Street  
Springfield, MO 65801-1565  
800-737-2800  
417-862-1232 fax  
boydaluminum.com

## **CASEMENT SERIES 3250XTC**

AAMA/WDMA/CSA 101/I.S.2/A440-08

Rating:	AW-PG100
Air Infiltration:	0.06 cfm/ft at 6.2 psf
Water Resistance:	No Leakage at 12.11 <or> 15.04 psf
Structural Performance:	150.00 psf
Thermal Break:	6/6 Polyamide Strut
Main Frame Depth:	3 1/4"
Glazing Thickness:	1" - 1 3/4" - Maximum

---

Boyd Manufacturing Company has prepared this guide specification in printed and electronic media, as an aid to specifiers in preparing written construction documents for commercial casement aluminum windows. For specification assistance on specific product applications, please contact our offices. Boyd Aluminum Manufacturing Company reserves the right to modify these specifications and details at any time. Updates to these guide specifications and details will be posted to our web site and/or in printed matter as they occur. Boyd Aluminum Manufacturing Company makes no expressed or implied warranties regarding content, errors, or omissions in the information presented.

104-11-22

## SECTION 08520 – ALUMINUM WINDOWS

### PART 1 – GENERAL

#### 1.1 RELATED SECTIONS

- A. Glass and glazing – Section 08800
- B. Sealants and caulking – Section 07900

#### 1.2 SUMMARY

- A. Section includes:
  - 1. Operable Heavy Commercial Grade and Architectural Window Grade aluminum windows.
    - a. Casement COS (Casement Outswing) windows.
    - b. Casement CIS (Casement inswing) windows.

#### 1.3 REFERENCES

- A. American Architectural Manufacturers Association (AAMA).
- B. American Society for Testing Materials (ASTM).
- C. American National Standards Institute (ANSI)

#### 1.4 TEST AND PERFORMANCE REQUIREMENTS

- A. Provide aluminum window system designed to accommodate expansion and contraction due to normal thermal movement and wind loading per manufacturer's window test reports. Establish basic dimension of units, sight lines, and profiles of members according to the performance requirements.
  - 1. In order to designate quality of materials and workmanship required, these specifications are based upon products from Boyd Aluminum Manufacturing Co., Inc. Springfield, MO (800) 737-2800.
  - 2. Products of other manufacturers equal to or exceeding those specified herein will be considered upon written authorization by the Architect. Information, including window sample (size and configuration per Architect's requirements) must be submitted for consideration a minimum of 10 days before project bid date.
- B. Test Criteria: Testing shall be performed by an AAMA qualified independent testing agency and be based on the following criteria:
  - 1. Current test reports must be submitted and be AAMA certified to be accepted.

- C. Performance Requirements: Test reports must show compliance with AAMA/WDMA/CSA 101/I.S.2/A440-08 for AW-PG100.
1. Air-Infiltration: Shall not exceed 0.10 cfm/ft<sup>2</sup> per ASTM E283 at a differential static pressure of 6.2 psf.
  2. Water Infiltration: No uncontrolled leakage per ASTM E331 at a test pressure of 12.00 psf. <or> 15.00 psf.
  3. Structural Requirements: Maximum permanent deformation of any component shall not exceed 0.4 percent at a test pressure of 150.00 psf as defined per ASTM E330.
  4. Forced-entry Resistance: Comply with requirements when tested according to ASTM F 588, Type D, Grade 10.
  6. Condensation Resistance Factor (CRF).
    - a. Test unit in accordance with AAMA 1503.
    - b. Condensation Resistance Factor (CRF) shall not be less than \_\_\_\_\_ when glazed with \_\_\_\_\_ center of glass U-factor.
  7. Thermal transmittance test (Conductive U-Factor).
    - a. Test unit in accordance with NFRC 100.
    - b. Conductive thermal Transmittance (U-Factor) shall not be more than U @ \_\_\_\_\_ at Center of glass U @ \_\_\_\_\_.

## 1.5 SUBMITTALS

- A. General: Submit in accordance with Division 1.
- B. Product Data: Submit for windows
1. Include information for factory finishes, glass, glazing components, accessories, and other required components.
  2. Include information on hardware and operators.
  3. Submit certified test reports from AAMA accredited laboratories verifying all performance requirements specified herein.
- C. Shop Drawings: Indicate elevations, detailed design, dimensions, member profiles, joint locations, arrangement of units, and member connections.
1. Anchorage system.
  2. Interfacing with building constructions.
  3. Full-size details of special and typical shapes.
  4. Indicate glazing details and sealant requirements.
  5. Show finishes indicating compliance with the specifications.
  6. Indicate recorded field measurements on final drawings as available.
- D. Samples: Indicate quality of finish on alloys used, 12 inches long for extrusions and 6 inches square for sheet materials.
1. Where normal texture or color variations are expected, include additional samples illustrating range of variation.
- E. Samples of Verification: Submit samples of anchors, fasteners, hardware, assembled corner sections, and other materials and components if requested by the architect.

1.6 QUALITY ASSURANCE

- A. Installer Qualifications: Certified in writing that the installer has experience of at least five projects of similar nature in the past five years. The installer shall warrant the satisfactory performance of the window installation which includes, but is not limited to, installation accessories (glazing, perimeter sealing), and anchorage as called for by the specifications and approved shop drawings
- B. Single Source Responsibility: Provide window units manufactured by one manufacturer
  - 1. Glass and glazing for window units are required as work of this section for single source responsibility. Factory glaze units.

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Deliver units pre-glazed with manufacturer's labels intact on interior side of glass.
- B. Protect glass and glazing to prevent chipping, cracking, and other similar damages.
- C. Store windows in an upright position, off ground.
- D. Protect finished surfaces to prevent damage.
- E. Do not use adhesive paper or sprayed coatings which become firmly bonded when exposed to sun.
- F. Do not leave coating residue on surfaces.
- G. Protect the window units from lime, mortar, runoff from concrete and copper, careless handling of tools, weld platter, acids, roofing tar, solvents, abrasive cleaners, and other items that could damage the window units.

1.8 WARRANTY

- A. Warranty: The window manufacturer shall provide a written warranty that window units are free from defective materials or workmanship within a specified period. Failures include the following:
  - 1. Materials defect in manufacture.
  - 2. Faulty operation of sash and hardware.
- B. Warranty Period: 2-year after delivery of product
- C. Warranty Period for Glass: 5-years after delivery of product

## PART 2 – PRODUCTS

### 2.1 MANUFACTURERS

- A. Acceptable Manufacturer: Boyd Aluminum Manufacturing Co. Inc., Springfield, MO (800) 737-2800.
  - 1. Series 3250XTC COS (Casement Outswing) Window
  - 2. Series 3250XTC CIS (Casement Inswing) Window
- B. Subject to compliance with Section 1.4 manufacturers offering equal products may be incorporated in the work.

### 2.2 MATERIALS

- A. Aluminum extrusions shall comply with ASTM B 221 and tolerances shall be in accordance with the Aluminum Association's "Drafting Standards for Aluminum Extruded and Tubular Products". Extrusions shall not be less than a nominal .125 inch thick at any location for main frame and sash members, and a minimum of .050 inch at glazing stops. Sheet shall comply with ASTM B 209, alloy and temper recommended by manufacturer appropriate for specified finish.
- B. Fasteners: Provide stainless steel fasteners, corrosion resistant and compatible with aluminum.
  - 1. Reinforcement: When fasteners screw into aluminum less than a nominal .125 inch thick, utilize nuts or washers of design having means to reinforce interior aluminum surfaces and prevent disengagement.
  - 2. Exposed Fasteners: Provide concealed fasteners wherever possible.
- C. Shims: Non-staining and non-ferrous type.
- D. Glazing tape: Blend of polyisobutylene and butylpolymer complying with AAMA 807.3-92
- E. Sealants: The color of the sealant exposed with the window in the closed position shall be chosen from the manufacturer's standards. If unspecified, the sealant color shall be compatible with the window framing materials.
  - 1. Non-working joints: Sealant shall comply with AAMA 800.
  - 2. Window Components: Sealant shall be suitable for application specified and approved by the window manufacturer.
  - 3. Perimeter: Sealant shall comply with AAMA 800 and Section 0900.
- F. Insect Screen: Provide 18 by 16 mesh of 0.013 inch diameter, coated aluminum wire, complying with FS RR-W-365.
- G. Compression Type Gaskets: Provide compressible TPE stripping for glazing and weather stripping complying with ASTM D 1921, ASTM D 792, ASTM D 2240, ASTM D 412, ASTM D 590, and ASTM D 3835 molded TPE gaskets.

## 2.3 ACCESSORIES

- A. Insect Screens: Provide insect screens for each operable sash. Screens shall be tight-fitting, removable and have no exposed fasteners.
1. Screen Frames: Frames shall be of extruded tubular shaped aluminum, with a minimum wall thickness of .050 inch, have mitered joints, and corners secured by concealed corner keys. Finish frames to match windows.
  2. Screen frames must rest into integral extruded channels on main frame, at both jambs and sill. Screens attached by means of exposed fasteners are not acceptable. No part of screen may protrude past the face of main frame with the exception of screens utilizing wickets.
    - a. Provide removable extruded vinyl spline at edge of screening.
  3. Wickets: Provide hinged-type wickets, when required to accommodate hardware, framed and trimmed for a tight fit.
- B. Muntins: Provide muntins in each designated sash to replicate the desired divided lite configuration. Muntins shall be of extruded or roll-formed aluminum. Muntins shall be rectangular or contour in shape, per architect's request.
1. True divided lite muntins: Provide an extruded aluminum muntin with a minimum nominal wall thickness of .125 inch. Finish to match windows.
  2. Simulated Muntins:
    - a) Roll Form Muntins: Provide simulated muntins suspended within the insulated glass units.
    - b) Applied Muntins: See and use S3250XTC-G Casement series with Grid.
- C. Mullions: Provide extruded aluminum mullions with a minimum nominal wall thickness of .125 inch and cover plates, where required, to complete window to window connections. Provide mullions with a minimum 39mm 6/6 polyamide strut thermal break.
- D. Receptors: Provide two-piece extruded aluminum receptors for the head and/or jambs of the window openings with a minimum nominal wall thickness of .125 inch. Provide one row of TPE gasket placed into extruded grooves in each receptor piece to ensure no window unit to receptor metal contact. Provide receptors with a minimum 39mm 6/6 polyamide strut thermal break. Finish receptors to match windows.
- E. Subsills: Provide subsills with a minimum nominal wall thickness of .125 inch. Provide subsills with means to weep water to the exterior. Provide subsills with a minimum of 39mm 6/6 polyamide strut thermal break. Finish subsills to match windows.
- F. Panning: Provide extruded aluminum panning of the type and configuration required by the architect with a minimum nominal wall thickness of .062 inches. Provide one row of vinyl gasket placed into extruded grooves in each panning member to ensure no window unit to panning members. Clips shall be attached with stainless steel fasteners. Space stainless steel clips appropriately to allow the window units to secure themselves tightly to the panning. Window units shall lip over the panning sill member allowing water to weep to the exterior. Finish panning to match window units.

- G. Trims: Provide extruded aluminum trim of the type and configuration required by the architect with a minimum nominal wall thickness of .050 inches. Provide extruded aluminum trim clips, with a minimum nominal wall thickness of .050 inch, to allow attachment of the trim to the window units and/or openings. Finish trim to match window units.

## 2.4 CASEMENT WINDOWS

- A. Window Grade and Class: Comply with requirements of AAMA Grade and Performance Class AW-PG100. Window units shall successfully pass operating force test performance requirements specified in AAMA 101.

- 1. Provide window units with a 3 1/4" minimum main frame depth.
- 2. Provide 1" – 1 3/4" maximum overall glazing thickness. See Section 08800 glass and glazing.

- B. Hardware: Provide one of the following operating hardware packages commensurate to projection direction:

- 1. Hardware Package #1

- a. Heavy-duty, 5-knuckle butt hinges with nylon bushings and stainless steel pins.
- b. Gear-type rotary operator located on sill.
- c. Single or gang-type combination lever handle and cam latch.

- 2. Hardware Package #2

- a. Heavy-duty, 5-knuckle butt hinges with nylon bushings and stainless steel pins.
- b. Heavy-duty stainless steel friction adjuster.
- c. Combination lever handle and cam latch.
- d. Push/Pull handle of White Bronze US-25-D construction.

- 3. Hardware Package #3

- a. Four-bar 90 degrees friction hinges of stainless steel construction.
- b. Combination lever handle and cam latch.
- c. Push/Pull handle of White Bronze US-25-D construction.

- 4. Hardware Package #4

- a. Custodial cam latch of White Bronze US-25-D construction.
- b. Heavy-duty, 5-knuckle butt hinges with nylon bushings and stainless steel pins.
- c. Heavy-duty stainless steel friction adjuster.

- C. Glazing Gaskets: Provide sliding-type gaskets.

- 1. Provide TPE gaskets placed into extruded grooves in glazing stop.
  - a. Provide one row of TPE gasket at all glazing stops.

D. Weatherstripping Gaskets: Provide sliding-type gaskets.

1. Provide TPE gaskets placed into extruded grooves in sash members.
  - a. Provide two rows of TPE gaskets at all sash members.

## 2.5 FABRICATION

- A. Fabricate components in accordance with manufacturer's tested assemblies. Remove burrs and ease edges. Shop fabricate to greatest extent practicable to minimum field assembly. Disassemble only to the extent necessary for shipping and handling limitations.
- B. Thermal Break: Manufacturer's minimum length of two 39mm 6/6 polyamide thermal strut barrier, located between exterior and interior members to provide thermal separation. Provide thermal break that has been tested for thermal conductance and condensation resistance factor (CRF).
- C. Weep System: Provide drain system to evacuate water entering joints occurring within windows.

## 2.6 FINISHES

- A. Clear Anodized, Class I: Etched, medium matte, clear anodic coating, 0.7 mil thickness. Meeting AAMA 611-98 and AA-M12C22A41.
- B. Color Anodized Class I: Etched, medium matte, colored anodic coating, 0.7 mil thickness. Meeting AAMA 611-98 and AA-M12C22A44.
  1. Standard Color: Color as selected by architect from window manufacturer's full range of standard colors.
    - a. Dark Bronze
  2. Custom Colors: Color selected by architect from window manufacturer's full range of custom colors.
    - a. Light Bronze
    - b. Medium Bronze
    - c. Black
- C. Fluorocarbon, High Performance Paint Coating: Color as selected from manufacturer's full range of colors by architect. Fluorocarbon spray coating shall be applied by a licensed applicator and shall meet AAMA 2605-98 specifications.
  1. Fluorocarbon 2-Coat System: Inhibitive primer and fluoropolymer color top coating of not less than 70 percent polyvinylidene fluoride complying with AAMA 2605-98. Prepare and pre-treat metal surfaces to comply with paint manufacturer's instructions.
  2. Fluorocarbon 3-coat System: Inhibitive primer, fluoropolymer color coating, and clear fluoropolymer top coating complying with AAMA 2605-98. Fluoropolymer color and clear coats shall not have less than 70 percent polyvinylidene fluoride. Prepare and pre-treat metal surfaces to comply with paint manufacturer's instructions.

- D. High Solids Paint Coating: A high solids coating shall be applied by a licensed applicator and shall meet AAMA 2603-98 specifications.
  - 1. Standard Colors: Color as selected by architect from window manufacturer's full range of standard colors. Prepare and pre-treat metal surfaces to comply with paint manufacturer's instructions.
  - 2. Custom Colors: Color as selected by architect from paint manufacturer's full range of colors. Prepare and pre-treat metal surfaces to comply with paint manufacturer's instructions.

## PART 3 – EXECUTION

### 3.1 INSPECTION

- A. Remove and properly dispose of existing windows in accordance with Section 02070. Verify that openings are dimensionally within allowable tolerances, plumb, level, and clean. Provide solid anchoring surfaces that are in accordance with approved shop drawings.
- B. Verify that the opening into which the windows will be installed is the correct size to permit installation of the new windows according to the manufacturer's installation instructions.
- C. Do not install windows until unsatisfactory conditions are corrected.

### 3.2 INSTALLATION

- A. Install windows with skilled tradesperson in exact accordance with approved shop drawings.
- B. Aluminum that is not organically coated shall be insulated from direct contact with steel, masonry concrete or noncompatible materials by bituminous paint, zinc chromate primer, or other suitable insulating material.
- C. Install vapor retardant tape between window perimeter and adjoining collateral materials and existing wall barriers to insure continuity.
- D. Plumb and align window faces in a single plane for each wall plane. Erect square and true. Anchor to maintain position when subjected to normal thermal and building movement (seismic forces), and specified wind loads.
- E. Install glass and glazing in accordance with approved shop drawings to provide satisfactory, leak-free installation.
- F. Perimeter Sealing: Seal joints at the perimeters in accordance with approved shop drawings to provide watertight installation.
  - 1. Joints and surfaces to receive sealants shall be clean, free from loose material, free of effervescence or mortar leaking, and dry. Sealants shall not be applied when the temperature is below the sealant manufacturer's instructions.
  - 2. Clean the joints and surfaces before sealing or priming. Then prime the joints in accordance with the sealant manufacturer's instructions.
  - 3. Provide joint backing in all joints where a suitable backer to receive sealant is otherwise not available. Joint depth shall be equal to ½ of the width.

4. Caulk joint width shall not be less than  $\frac{1}{4}$  inch not more than  $\frac{1}{2}$  inches unless otherwise recommended by the sealant manufacturer. Wipe off the excess material and leave the exposed surfaces and joints clean and smooth.

### 3.3 ADJUSTING

- A. After installation, windows and glazing shall be inspected and adjusted to provide smooth operation and a weathertight window system.

### 3.4 CLEANING

- A. After installation, leave windows clean and free of temporary labels and dirt. Protect finished installation against damage.
- B. Final cleaning of the anodized finish shall be in accordance with AAMA 690.1.
- C. Final cleaning of the painted finish shall be in accordance with AAMA 610.1.

END OF SECTION 08520