

**SECTION 085113
ALUMINUM WINDOWS**

PART 1 GENERAL

1.01 SECTION INCLUDES

- A. Extruded aluminum windows with fixed sash.

1.02 REFERENCE STANDARDS

- A. AAMA/WDMA/CSA 101/I.S.2/A440 - North American Fenestration Standard/Specification for Windows, Doors, and Skylights; 2022, with Errata (2023).
- B. AAMA CW-10 - Care and Handling of Architectural Aluminum from Shop to Site; 2015.
- C. AAMA 502 - Voluntary Specification for Field Testing of Newly Installed Fenestration Products; 2021.
- D. AAMA 611 - Specification for Anodized Architectural Aluminum; 2024.
- E. AAMA 1503 - Voluntary Test Method for Thermal Transmittance and Condensation Resistance of Windows, Doors and Glazed Wall Sections; 2009.
- F. ASTM B209/B209M - Standard Specification for Aluminum and Aluminum-Alloy Sheet and Plate; 2021a.
- G. ASTM B221 - Standard Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes; 2021.
- H. ASTM B221M - Standard Specification for Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes (Metric); 2021.
- I. ASTM E90 - Standard Test Method for Laboratory Measurement of Airborne Sound Transmission Loss of Building Partitions and Elements; 2023.
- J. ASTM E283/E283M - Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Skylights, Curtain Walls, and Doors Under Specified Pressure Differences Across the Specimen; 2019.
- K. ASTM E331 - Standard Test Method for Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Uniform Static Air Pressure Difference; 2000 (Reapproved 2023).
- L. ASTM E783 - Standard Test Method for Field Measurement of Air Leakage Through Installed Exterior Windows and Doors; 2002 (Reapproved 2018).
- M. ASTM E1105 - Standard Test Method for Field Determination of Water Penetration of Installed Exterior Windows, Skylights, Doors, and Curtain Walls, by Uniform or Cyclic Static Air Pressure Difference; 2015 (Reapproved 2023).
- N. ASTM E1332 - Standard Classification for Rating Outdoor-Indoor Sound Attenuation; 2022.
- O. ASTM E1996 - Standard Specification for Performance of Exterior Windows, Curtain Walls, Doors, and Impact Protective Systems Impacted by Windborne Debris in Hurricanes; 2023.
- P. ASTM F588 - Standard Test Methods for Measuring the Forced Entry Resistance of Window Assemblies, Excluding Glazing Impact; 2017 (Reapproved 2023).

1.03 SUBMITTALS

- A. See Section 013000 - Administrative Requirements for submittal procedures.
- B. Product Data: Include component dimensions, information on glass and glazing, internal drainage details, and descriptions of hardware and accessories.
- C. Shop Drawings: Indicate opening dimensions, elevations of different types, framed opening tolerances, anchorage locations, and installation requirements.
- D. Grade Substantiation: Prior to submitting shop drawings or starting fabrication, submit one of the following showing compliance with specified grade:
 - 1. Evidence of AAMA Certification.

2. Evidence of WDMA Certification.
3. Evidence of CSA Certification.
4. Test report(s) by independent testing agency itemizing compliance and acceptable to authorities having jurisdiction.
- E. Test Reports: Prior to submitting shop drawings or starting fabrication, submit test report(s) by independent testing agency showing compliance with performance requirements in excess of those prescribed by specified grade.
- F. Manufacturer's Installation Instructions: Include complete preparation, installation, and cleaning requirements.
- G. Field Quality Control Submittals: Report of field testing for water penetration and air leakage.
- H. Manufacturer's qualification statement.
- I. Installer's qualification statement.

1.04 QUALITY ASSURANCE

- A. Manufacturer Qualifications: Company specializing in manufacturing products specified in this section with minimum three years of documented experience.
- B. Installer Qualifications: Company specializing in performing work of type specified and with at least three years of documented experience.

1.05 DELIVERY, STORAGE, AND HANDLING

- A. Comply with requirements of AAMA CW-10.
- B. Protect finished surfaces with wrapping paper or strippable coating during installation. Do not use adhesive papers or sprayed coatings that bond to substrate when exposed to sunlight or weather.

1.06 FIELD CONDITIONS

- A. Do not install sealants when ambient temperature is less than 40 degrees F (5 degrees C).
- B. Maintain this minimum temperature during and 24 hours after installation of sealants.

1.07 WARRANTY

- A. See Section 017800 - Closeout Submittals for additional warranty requirements.
- B. Manufacturer Warranty: Provide 5-year manufacturer warranty against failure of glass seal on insulating glass units, including interpane dusting or misting. Include provision for replacement of failed units. Complete forms in Owner's name and register with manufacturer.
- C. Manufacturer Warranty: Provide 20-year manufacturer warranty against excessive degradation of exterior finish. Include provision for replacement of units with excessive fading, chalking, or flaking. Complete forms in Owner's name and register with manufacturer.

PART 2 PRODUCTS

2.01 BASIS OF DESIGN - AW PERFORMANCE CLASS WINDOWS

- A. Grade: AAMA/WDMA/CSA 101/I.S.2/A440 having Performance Class of AW, and Performance Grade at least as high as specified design pressure.

2.02 ALUMINUM WINDOWS

- A. Aluminum Windows: Extruded aluminum frame and sash, factory fabricated, factory finished, with operating hardware, related flashings, and anchorage and attachment devices.
 1. Fabrication: Joints and corners flush, hairline, and weatherproof, accurately fitted and secured; prepared to receive anchors; fasteners and attachments concealed from view; reinforced as required for operating hardware and imposed loads.
 2. Perimeter Clearance: Minimize space between framing members and adjacent construction while allowing expected movement.
 3. Movement: Accommodate movement between window and perimeter framing and deflection of lintel, without damage to components or deterioration of seals.

4. System Internal Drainage: Drain to the exterior by means of a weep drainage network any water entering joints, condensation occurring in glazing channel, and migrating moisture occurring within system.
 5. Thermal Movement: Design to accommodate thermal movement caused by 180 degrees F (82.2 degrees C) surface temperature without buckling stress on glass, joint seal failure, damaging loads on structural elements, damaging loads on fasteners, reduction in performance or other detrimental effects.
- B. Fixed, Non-Operable Type:
1. Construction: Thermally broken.
 2. Glazing: Single; clear; transparent.
 3. Exterior Finish: Class I natural anodized.

2.03 PERFORMANCE REQUIREMENTS

- A. Grade: AAMA/WDMA/CSA 101/I.S.2/A440 requirements for specific window type:
1. Performance Class (PC): R.
 2. Performance Grade (PG): 15, with minimum design pressure (DP) of 15.04 psf (720 Pa).
- B. Member Deflection: Limit member deflection to flexure limit of glass in any direction, with full recovery of glazing materials.
- C. Wind-Borne-Debris Resistance: Identical full-size glazed assembly without auxiliary protection, tested by independent agency in accordance with ASTM E1996 for Wind Zone 4 - Additional Protection for Large and Small Missile impact and pressure cycling at design wind pressure.
- D. Water Leakage: No uncontrolled leakage on interior face when tested in accordance with ASTM E331 at differential pressure of 12.11 psf (580 Pa).
- E. Air Leakage: 0.1 cfm/sq ft (0.5 L/sec sq m) maximum leakage per unit area of outside window frame dimension when tested in accordance with ASTM E283/E283M.
- F. Condensation Resistance Factor of Frame: 50, measured in accordance with AAMA 1503.
- G. Overall Thermal Transmittance (U-value): 0.35, maximum, including glazing, measured on window sizes required for this project.
- H. Forced Entry Resistance: Tested to comply with ASTM F588 requirements for performance level of Grade 10 for specific window style required.
- I. Acoustic Performance: Minimum outdoor-indoor transmission class (OITC) rating of 34, when tested in accordance with ASTM E90 and ASTM E1332.

2.04 MATERIALS

- A. Extruded Aluminum: ASTM B221 (ASTM B221M), 6063 alloy, T6 temper.
- B. Sheet Aluminum: ASTM B209/B209M, 5005 alloy, H12 or H14 temper.

2.05 FINISHES

- A. Class I Natural Anodized Finish: AAMA 611 AA-M12C22A41, clear anodic coating not less than 0.7 mil (0.018 mm) thick.
- B. Finish Color: As selected by Architect from manufacturer's standard range.

PART 3 EXECUTION

3.01 EXAMINATION

- A. Verify that wall openings and adjoining water-resistive barrier materials are ready to receive aluminum windows; see Section 072500.

3.02 PRIME WINDOW INSTALLATION

- A. Install windows in accordance with manufacturer's instructions.
- B. Attach window frame and shims to perimeter opening to accommodate construction tolerances and other irregularities.

- C. Align window plumb and level, free of warp or twist. Maintain dimensional tolerances and alignment with adjacent work.
- D. Install sill and sill end angles.
- E. Provide thermal isolation where components penetrate or disrupt building insulation. Pack fibrous insulation in shim spaces at perimeter of assembly to maintain continuity of thermal barrier.

3.03 FIELD QUALITY CONTROL

- A. See Section 014000 - Quality Requirements for independent field testing and inspection requirements, and requirements for monitoring quality of specified product installations.
- B. Provide field testing of installed aluminum windows by independent laboratory in accordance with AAMA 502 and AAMA/WDMA/CSA 101/I.S.2/A440 during construction process and before installation of interior finishes.
 - 1. Field test for water penetration in accordance with ASTM E1105 using Procedure B - cyclic static air pressure difference; test pressure shall not be less than 1.9 psf (91 Pa).
 - 2. Field test for air leakage in accordance with ASTM E783 with uniform static air pressure difference of 1.57 psf (75 Pa).
- C. Repair or replace fenestration components that have failed designated field testing, and retest to verify performance complies with specified requirements.

3.04 ADJUSTING

- A. Adjust hardware for smooth operation and secure weathertight closure.

3.05 CLEANING

- A. Remove protective material from factory finished aluminum surfaces.
- B. Wash surfaces by method recommended and acceptable to window manufacturer; rinse and wipe surfaces clean.
- C. Remove excess glazing sealant by moderate use of mineral spirits or other solvent acceptable to sealant and window manufacturer.

END OF SECTION