



# ***STEEL WINDOWS***



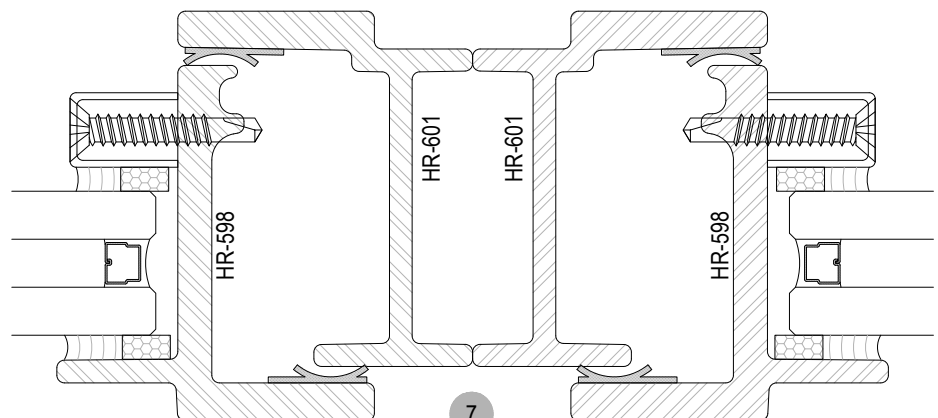
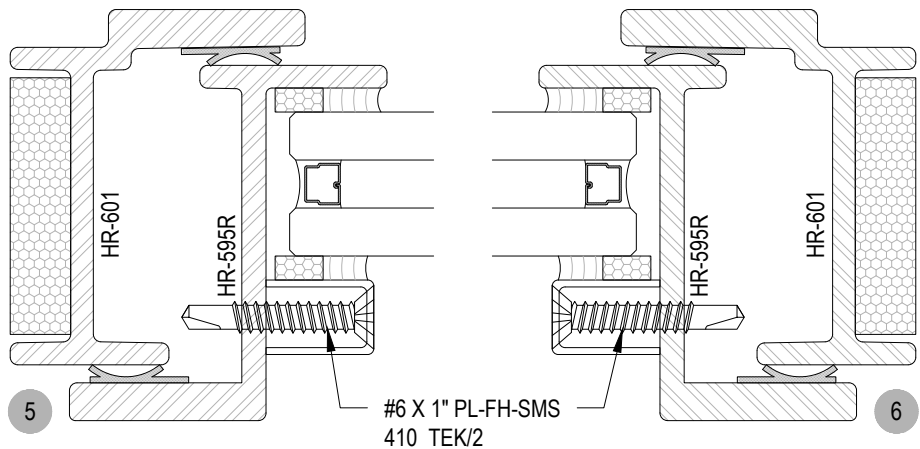
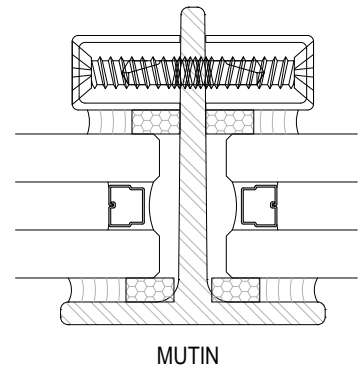
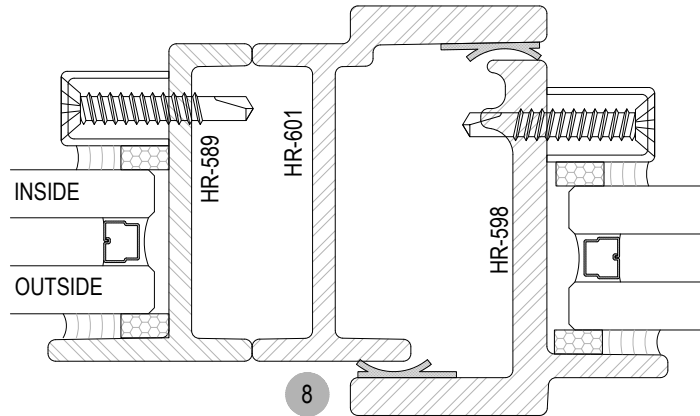
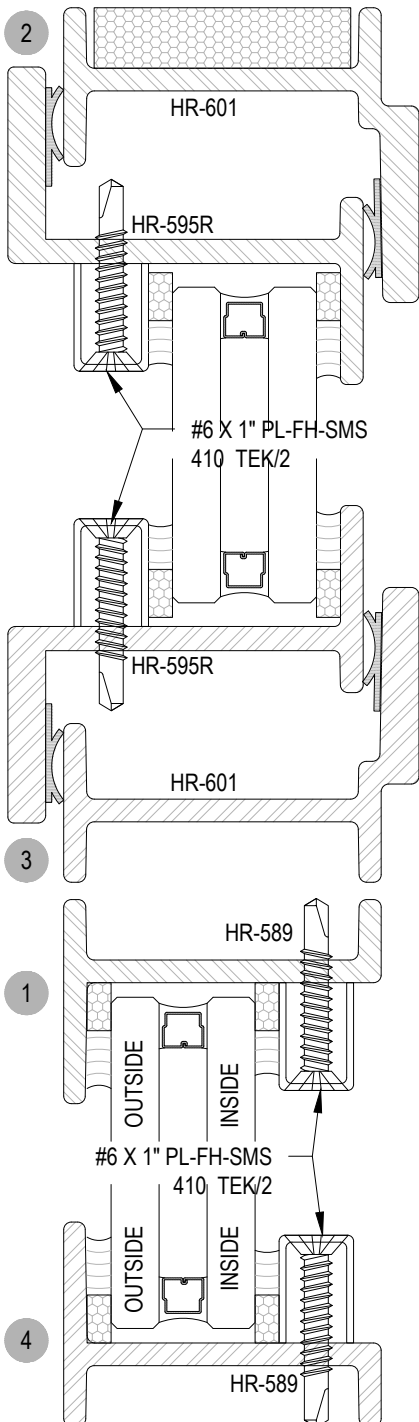
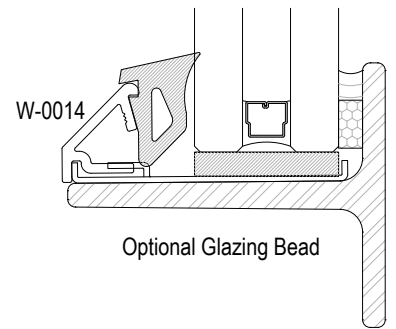
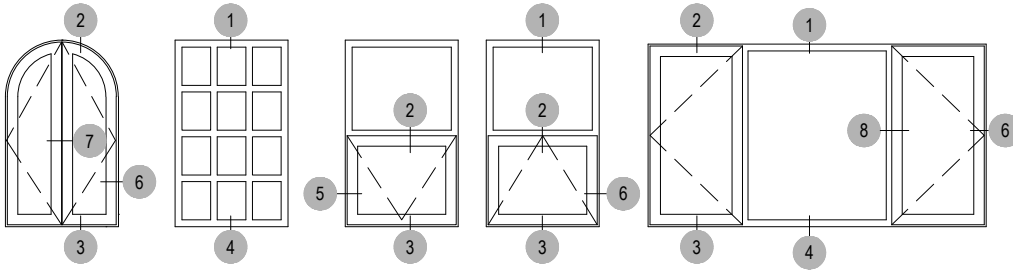
Montage Hotel & Resort  
Beverly Hills, CA  
HKS Hill Glazier Studio





## Integra Series

Description: STL212HR Hot Rolled Window  
Function: Awning, Hopper, Casement, Fixed  
Detail: ALL  
Scale: 1'-0" = 1'-0" (Full)





**1995 CSI SECTION 08510 Steel Windows**  
**2004 CSI SECTION 08 51 23 Steel Windows**

**PART 1 - GENERAL**

**1. DESCRIPTION**

- A. Work included:
  - 1. Furnish all labor and materials to complete the fabrication of windows as shown on architect's drawings and as specified herein. All windows covered by this specification shall be fabricated by Arcadia Inc. Vernon, California
- B. Related work specified elsewhere:
  - 1. Glass, glazing and glazing materials, Section 08810.
  - 2. Perimeter caulking, Section 07915.
  - 3. Miscellaneous structural items, Section 05100.

**2. QUALITY ASSURANCE**

- A. Allowable tolerances: Size dimensions + 1/16 inch.
- B. Source quality control:
  - 1. Air infiltration test
    - a. Products must be independently lab tested and meet or exceed ASTM E-283.
    - b. Maximum air infiltration 0.30 CFM/ SQFT with differential pressure across window unit of 1.57 / 6.24 PSF
  - 2. Water penetration test
    - a. Products must be independently lab tested and meet or exceed ASTM E331.
    - b. No water penetration for 15 minutes when window is subjected to a rate of flow of 5 gal./hr/sq.ft with differential pressure across window unit of 6.00 PSF
  - 3. Field Testing
    - a. Field testing criteria (when applicable) shall be in accordance with AAMA 502-08.
  - 4. Structural test
    - a. Meets or exceeds ASTM E330
  - 5. Forced entry test
    - a. Meets or exceeds ASTM F588
    - b. Grade 40 @ 300 pounds
  - 6. Quality of top coat combination shall meet or exceed the following ASTM designations:
    - a. ASTM D4585 Humidity Test
    - b. ASTM D714 Paint Blistering Test
    - c. ASTM B117-03 Salt Spray (Fog) Test
    - d. ASTM D1654-05 Painted Products in Corrosive Environments
    - e. ASTM G85 Cyclic Fog/Dry Test (Prohesion)
    - f. ASTM D5894-96 Salt Fog/UV Painted Metal
    - g. ASTM D4541 Pull off Strength of Coating Test

**3. SUBMITTALS**

- A. Shop drawings
  - 1. Submit for approval shop drawings showing window and installation details, including anchorage, fastening and recommended sealing methods.
  - 2. Dimensioned elevations showing window opening and window sizes.

**4. PRODUCT, STORAGE AND HANDLING**

- A. The General Contractor shall be responsible for the protection and storage of the windows after delivery to the site.

**5. WARRANTY**

- A. Provide Arcadia's standard 10 year Limited Warranty.

- A. Heavy custom windows shall be manufactured from solid hot rolled steel shapes
  - 1. Combined weight of frame and ventilator sections shall be a minimum of 4.20 pounds per lineal foot. Frame section alone shall not weigh less than 1.80 pounds per lineal foot.
- B. Operable Hardware:
  - 1. Awning, Hopper:
    - a. Fastener: Brass or Bronze cam fastener.
    - b. Ventilators shall be hung on heavy-duty stainless steel four bar hinges with brass friction shoes.
  - 2. Casement:
    - a. Fastener: Brass or Bronze cam fastener
    - b. Pivots: Aluminum-bronze pivot with stainless steel pin.
    - c. Friction and limit device: Stainless steel with sliding brass shoe and screw adjusted friction.
- C. All screws that are furnished by Arcadia for hardware, trim, covers, anchoring, weatherbars, water dams, screens, etc. shall be non-ferrous brass or stainless steel. Glazing bead retainer screws are plated steel.

**2. FABRICATION**

- A. Fabricate steel windows in accordance with approved shop drawings.
- B. Prior to fabrication, all hot rolled steel sections shall be cleaned by shot blasting.
- C. Glazing
  - 1. All windows shall be designed for outside glazing.
  - 2. Provide replaceable continuous glazing beads to suit the glass as specified.
- D. Weatherstrip
  - 1. All ventilators shall receive continuous EPDM weatherstripping that shall be applied to the interior and exterior contact surfaces of the frame and ventilator sections.

**3. FACTORY FINISHING**

- A. Pretreatment
  - 1. Pretreatment process to thoroughly clean and prepare the substrates for zinc coating.
- B. Paint Finish Top coat
  - 1. Following the zinc primer coat(s), all windows and accessories are given a spray coat of acrylic polyurethane and oven baked at 225°F for 15 minutes to dry film thickness of 1.5-2.0 mils.

**PART 3 - EXECUTION**

**1. INSPECTION**

- A. Window openings shall conform to details, dimensions and tolerances shown on the window manufacturer's approved shop drawings.

**2. INSTALLATION**

- A. Install windows in openings in strict accordance with approved shop drawings.

**3. CLEANING**

- A. Window installer shall leave window surfaces clean after installation and ready to receive glass and glazing. The window installer will not be responsible for final cleaning.

**END OF SECTION**

**6.**

**PART 2 - PRODUCT AND FABRICATION**

**1. MATERIALS**





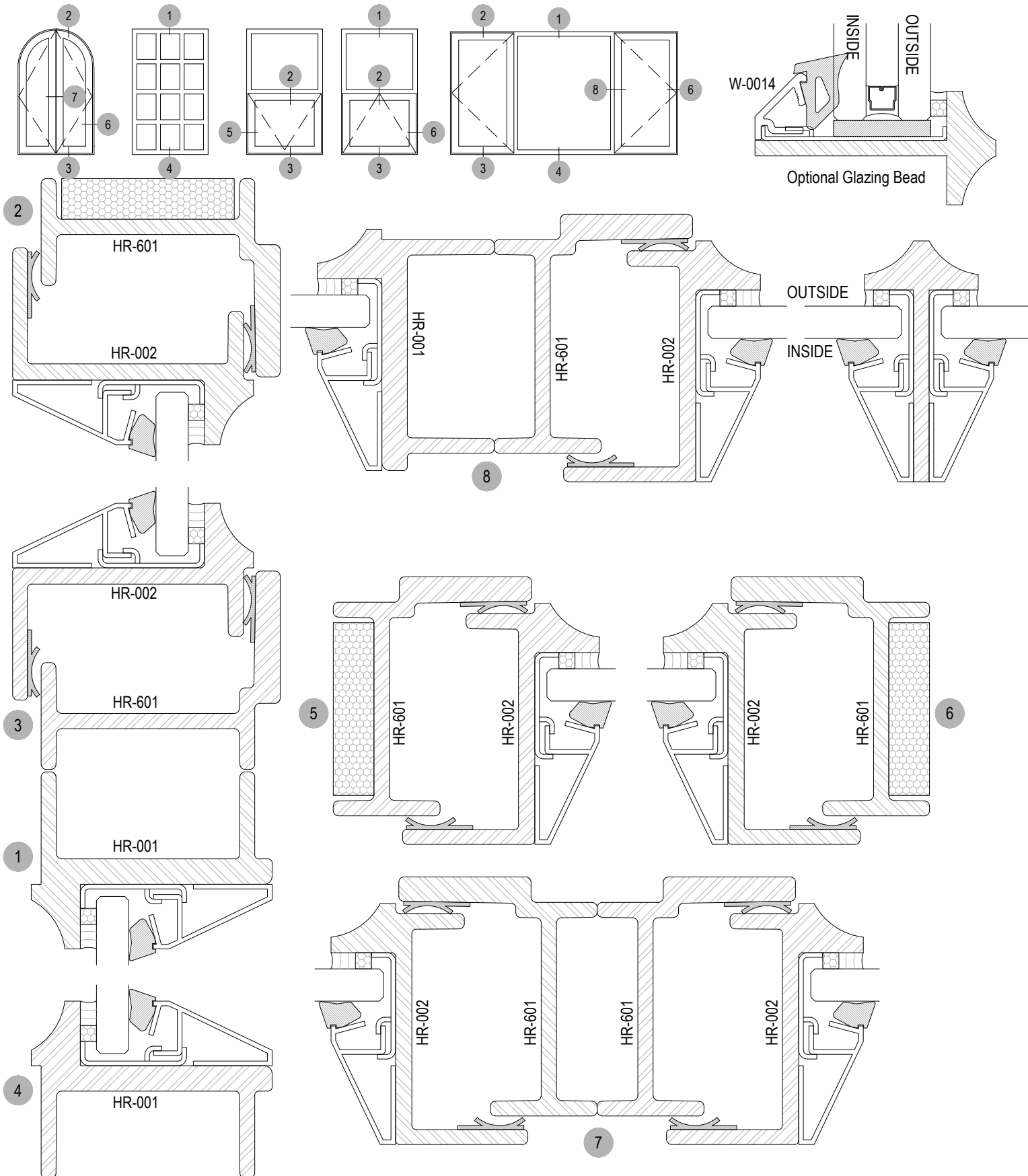
## Victoria Series

Description: STL212HRV Hot Rolled Window

Function: Awning, Hopper, Casement, Fixed

Detail: ALL

Scale: 1'-0" = 1'-0" (Full)





**1995 CSI SECTION 08510 Steel Windows**  
**2004 CSI SECTION 08 51 23 Steel Windows**

**PART 1 - GENERAL**

**1. DESCRIPTION**

- A. Work included:
1. Furnish all labor and materials to complete the fabrication of windows as shown on architect's drawings and as specified herein. All windows covered by this specification shall be fabricated by Arcadia Inc. Vernon, California
- B. Related work specified elsewhere:
1. Glass, glazing and glazing materials, Section 08810.
  2. Perimeter caulking, Section 07915.
  3. Miscellaneous structural items, Section 05100.

**2. QUALITY ASSURANCE**

- A. Allowable tolerances: Size dimensions + 1/16 inch.
- B. Source quality control:
1. Air infiltration test
    - a. Products must be independently lab tested and meet or exceed ASTM E-283.
    - b. Maximum air infiltration 0.30 CFM/ SQFT with differential pressure across window unit of 1.57 / 6.24 PSF
  2. Water penetration test
    - a. Products must be independently lab tested and meet or exceed ASTM E331.
    - b. No water penetration for 15 minutes when window is subjected to a rate of flow of 5 gal./hr/sq.ft with differential pressure across window unit of 6.00 PSF
  3. Field Testing
    - a. Field testing criteria (when applicable) shall be in accordance with AAMA 502-08.
  4. Structural test
    - a. Meets or exceeds ASTM E330
  5. Forced entry test
    - a. Meets or exceeds ASTM F588
    - b. Grade 40 @ 300 pounds
  6. Quality of top coat combination shall meet or exceed the following ASTM designations:
    - a. ASTM D4585 Humidity Test
    - b. ASTM D714 Paint Blistering Test
    - c. ASTM B117-03 Salt Spray (Fog) Test
    - d. ASTM D1654-05 Painted Products in Corrosive Environments
    - e. ASTM G85 Cyclic Fog/Dry Test (Prohesion)
    - f. ASTM D5894-96 Salt Fog/UV Painted Metal
    - g. ASTM D4541 Pull off Strength of Coating Test

**3. SUBMITTALS**

- A. Shop drawings
1. Submit for approval shop drawings showing window and installation details, including anchorage, fastening and recommended sealing methods.
  2. Dimensioned elevations showing window opening and window sizes.

**4. PRODUCT, STORAGE AND HANDLING**

- A. The General Contractor shall be responsible for the protection and storage of the windows after delivery to the site.

**5. WARRANTY**

- A. Provide Arcadia's standard 10 year Limited Warranty.

**PART 2 - PRODUCT AND FABRICATION**

**1. MATERIALS**

- A. Heavy custom windows shall be manufactured from solid hot rolled steel shapes

1. Combined weight of frame and ventilator sections shall be a minimum of 4.20 pounds per lineal foot. Frame section alone shall not weigh less than 1.80 pounds per lineal foot.
- B. Operable Hardware:
1. Awning, Hopper:
    - a. Fastener: Brass or Bronze cam fastener.
    - b. Ventilators shall be hung on heavy-duty stainless steel four bar hinges with brass friction shoes.
  2. Casement:
    - a. Fastener: Brass or Bronze cam fastener
    - b. Pivots: Aluminum-bronze pivot with stainless steel pin.
    - c. Friction and limit device: Stainless steel with sliding brass shoe and screw adjusted friction.
- C. All screws that are furnished by Arcadia for hardware, trim, covers, anchoring, weatherbars, water dams, screens, etc. shall be non-ferrous brass or stainless steel. Glazing bead retainer screws are plated steel.

**2. FABRICATION**

- A. Fabricate steel windows in accordance with approved shop drawings.
- B. Prior to fabrication, all hot rolled steel sections shall be cleaned by shot blasting.
- C. Glazing
1. All windows shall be designed for outside glazing.
  2. Provide replaceable continuous glazing beads to suit the glass as specified.
- D. Weatherstrip
1. All ventilators shall receive continuous EPDM weatherstripping that shall be applied to the interior and exterior contact surfaces of the frame and ventilator sections.

**3. FACTORY FINISHING**

- A. Pretreatment
1. Pretreatment process to thoroughly clean and prepare the substrates for zinc coating.
- B. Paint Finish Top coat
1. Following the zinc primer coat(s), all windows and accessories are given a spray coat of acrylic polyurethane and oven baked at 225°F for 15 minutes to dry film thickness of 1.5-2.0 mils.

**PART 3 - EXECUTION**

**1. INSPECTION**

- A. Window openings shall conform to details, dimensions and tolerances shown on the window manufacturer's approved shop drawings.

**2. INSTALLATION**

- A. Install windows in openings in strict accordance with approved shop drawings.

**3. CLEANING**

- A. Window installer shall leave window surfaces clean after installation and ready to receive glass and glazing. The window installer will not be responsible for final cleaning.

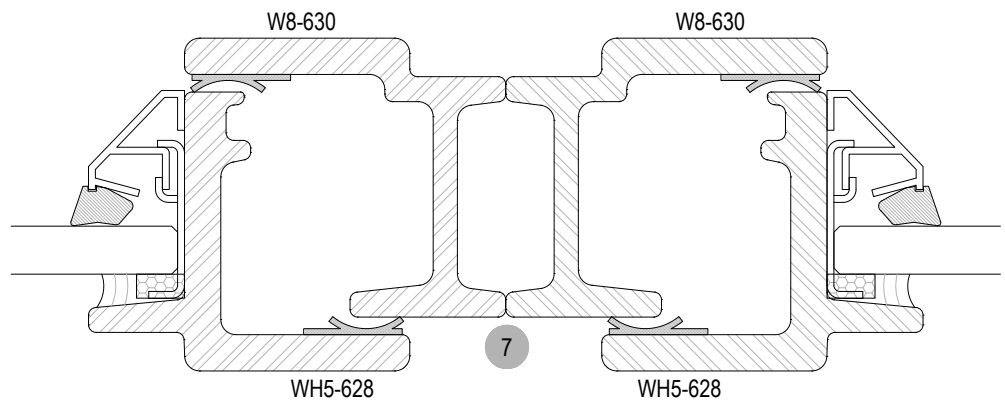
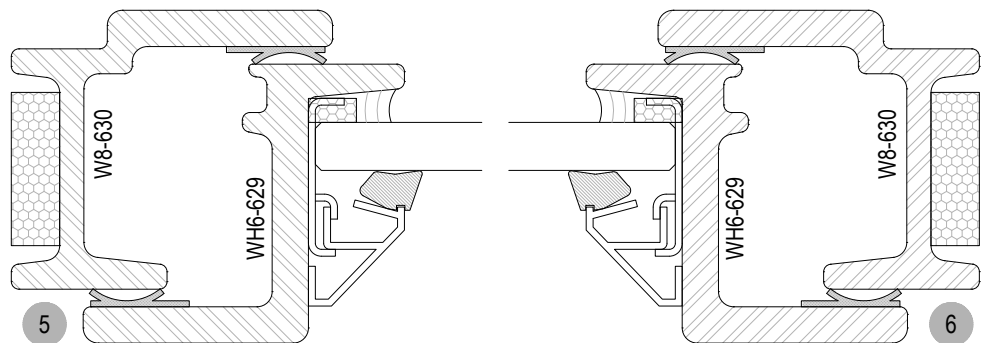
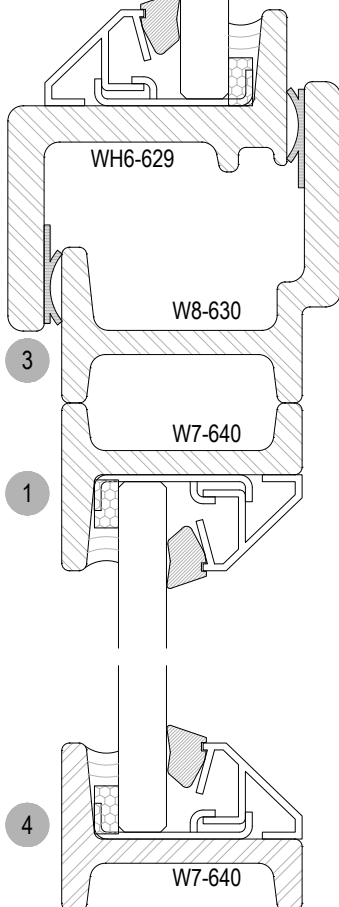
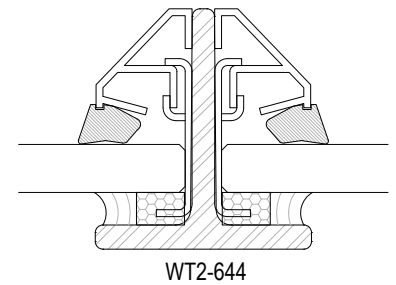
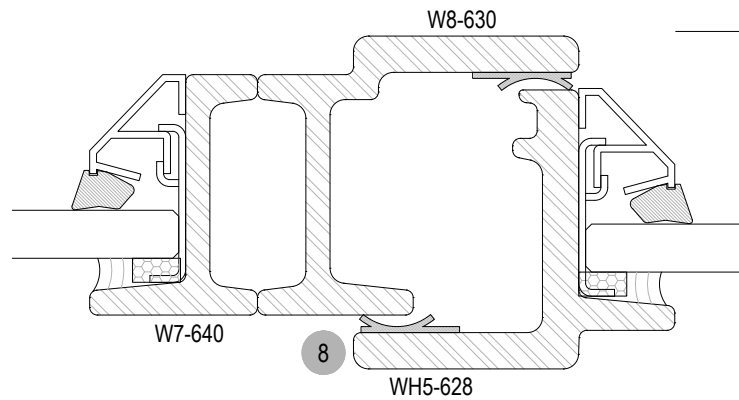
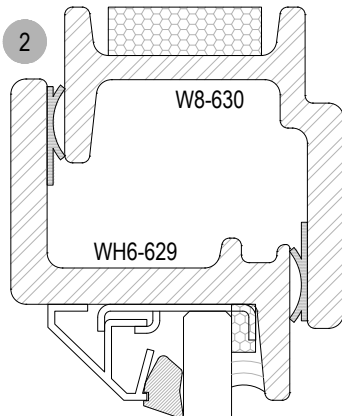
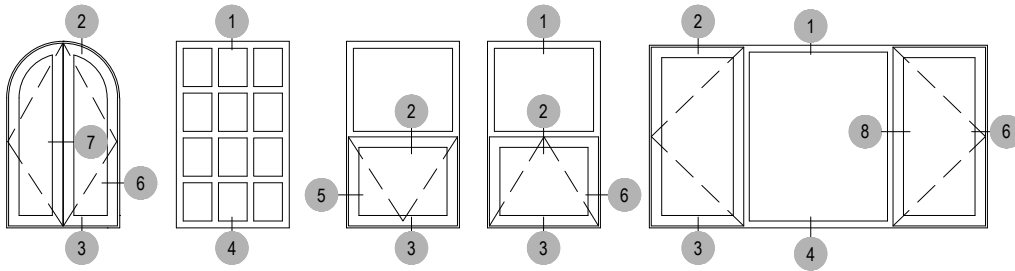
**END OF SECTION**

**6.**



## Venetian Series

Description: STL175HR Hot Rolled Window  
Function: Awning, Hopper, Casement, Fixed  
Detail: ALL  
Scale: 1'-0" = 1'-0" (Full)





**1995 CSI SECTION 08510 Steel Windows**  
**2004 CSI SECTION 08 51 23 Steel Windows**

**PART 1 - GENERAL**

1. DESCRIPTION
  - A. Work included:
    1. Furnish all labor and materials to complete the fabrication of windows as shown on architect's drawings and as specified herein. All windows covered by this specification shall be fabricated by Arcadia Inc. Vernon, California
  - B. Related work specified elsewhere:
    1. Glass, glazing and glazing materials, Section 08810.
    2. Perimeter caulking, Section 07915.
    3. Miscellaneous structural items, Section 05100.
2. QUALITY ASSURANCE
  - A. Allowable tolerances: Size dimensions + 1/16 inch.
  - B. Source quality control:
    1. Air infiltration test
      - a. Products must be independently lab tested and meet or exceed ASTM E-283.
      - b. Maximum air infiltration 0.30 CFM/ SQFT with differential pressure across window unit of 1.57 / 6.24 PSF
    2. Water penetration test
      - a. Products must be independently lab tested and meet or exceed ASTM E331.
      - b. No water penetration for 15 minutes when window is subjected to a rate of flow of 5 gal./hr/sq.ft with differential pressure across window unit of 6.00 PSF
    3. Field Testing
      - a. Field testing criteria (when applicable) shall be in accordance with AAMA 502-08.
    4. Structural test
      - a. Meets or exceeds ASTM E330
    5. Forced entry test
      - a. Meets or exceeds ASTM F588
      - b. Grade 40 @ 300 pounds
    6. Quality of top coat combination shall meet or exceed the following ASTM designations:
      - a. ASTM D4585 Humidity Test
      - b. ASTM D714 Paint Blistering Test
      - c. ASTM B117-03 Salt Spray (Fog) Test
      - d. ASTM D1654-05 Painted Products in Corrosive Environments
      - e. ASTM G85 Cyclic Fog/Dry Test (Prohesion)
      - f. ASTM D5894-96 Salt Fog/UV Painted Metal
      - g. ASTM D4541 Pull off Strength of Coating Test
3. SUBMITTALS
  - A. Shop drawings
    1. Submit for approval shop drawings showing window and installation details, including anchorage, fastening and recommended sealing methods.
    2. Dimensioned elevations showing window opening and window sizes.
4. PRODUCT, STORAGE AND HANDLING
  - A. The General Contractor shall be responsible for the protection and storage of the windows after delivery to the site.
5. WARRANTY
  - A. Provide Arcadia's standard 10 year Limited Warranty.

**PART 2 - PRODUCT AND FABRICATION**

1. MATERIALS
  - A. Heavy custom windows shall be manufactured from solid hot rolled steel shapes
    1. Combined weight of frame and ventilator sections shall be a minimum of 4.20 pounds per lineal foot. Frame section alone shall not weigh less than 1.80 pounds per lineal foot.
  - B. Operable Hardware:
    1. Awning, Hopper:
      - a. Fastener: Brass or Bronze cam fastener.
      - b. Ventilators shall be hung on heavy-duty stainless steel four bar hinges with brass friction shoes.
    2. Casement:
      - a. Fastener: Brass or Bronze cam fastener
      - b. Pivots: Aluminum-bronze pivot with stainless steel pin.
      - c. Friction and limit device: Stainless steel with sliding brass shoe and screw adjusted friction.
  - C. All screws that are furnished by Arcadia for hardware, trim, covers, anchoring, weatherbars, water dams, screens, etc. shall be non-ferrous brass or stainless steel. Glazing bead retainer screws are plated steel.
2. FABRICATION
  - A. Fabricate steel windows in accordance with approved shop drawings.
  - B. Prior to fabrication, all hot rolled steel sections shall be cleaned by shot blasting.
  - C. Glazing
    1. All windows shall be designed for outside glazing.
    2. Provide replaceable continuous glazing beads to suit the glass as specified.
  - D. Weatherstrip
    1. All ventilators shall receive continuous EPDM weatherstripping that shall be applied to the interior and exterior contact surfaces of the frame and ventilator sections.
3. FACTORY FINISHING
  - A. Pretreatment
    1. Pretreatment process to thoroughly clean and prepare the substrates for zinc coating.
  - B. Paint Finish Top coat
    1. Following the zinc primer coat(s), all windows and accessories are given a spray coat of acrylic polyurethane and oven baked at 225°F for 15 minutes to dry film thickness of 1.5-2.0 mils.

**PART 3 - EXECUTION**

1. INSPECTION
  - A. Window openings shall conform to details, dimensions and tolerances shown on the window manufacturer's approved shop drawings.
2. INSTALLATION
  - A. Install windows in openings in strict accordance with approved shop drawings.
3. CLEANING
  - A. Window installer shall leave window surfaces clean after installation and ready to receive glass and glazing. The window installer will not be responsible for final cleaning.

**END OF SECTION**

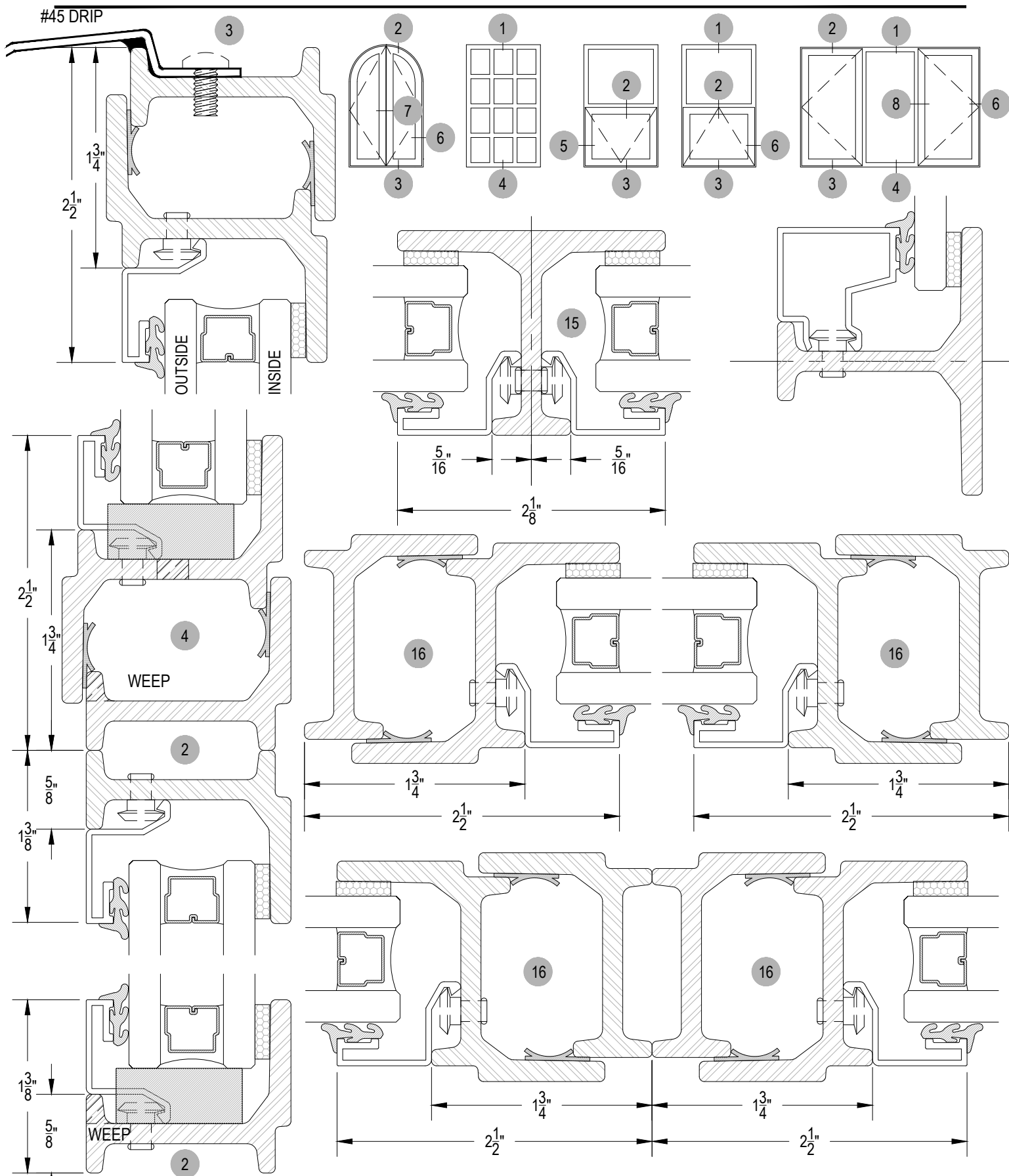


# Milano Series

Description: STL1375M Hot Rolled Window  
Function: Awning, Hopper, Casement, Fixed  
Detail: ALL

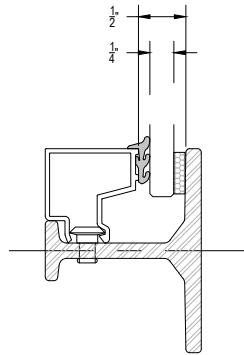
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SHEET 1 OF 1

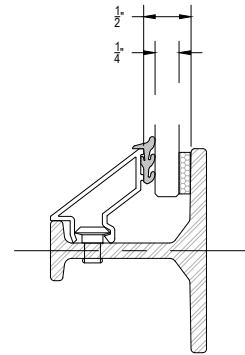




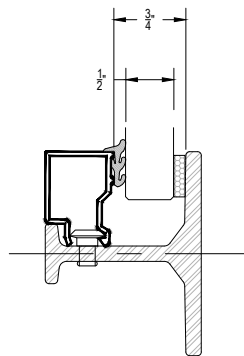
#S515 ALUMINUM SNAP-ON  
GLAZING BEAD  
1/2" GLASS POCKET  
1/4" THICK GLASS SHOWN  
(ALSO FOR 1/8" & 3/16")



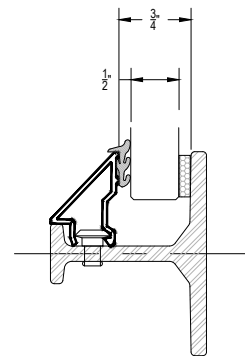
#S516 ALUMINUM SNAP-ON  
GLAZING BEAD  
1/2" GLASS POCKET  
1/4" THICK GLASS SHOWN  
(ALSO FOR 1/8" & 3/16")



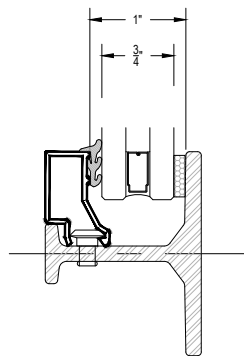
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GLAZING BEAD  
3/4" GLASS POCKET  
1/2" THICK GLASS SHOWN  
(ALSO FOR 3/8" GLASS)



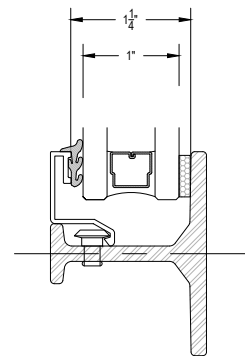
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GLAZING BEAD  
3/4" GLASS POCKET  
1/2" THICK GLASS SHOWN  
(ALSO FOR 5/8")



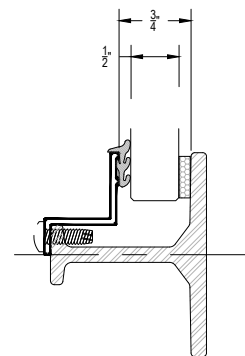
#S505 ALUMINUM SNAP-ON  
GLAZING BEAD  
1" GLASS POCKET  
3/4" THICK GLASS SHOWN  
(ALSO FOR 5/8" GLASS)



#S506 ALUMINUM SNAP-ON  
GLAZING BEAD  
1 1/4" GLASS POCKET  
1" THICK GLASS SHOWN  
(ALSO FOR 7/8" & 15/16")



#S508 ALUMINUM SCREW-ON  
GLAZING BEAD  
3/4" GLASS POCKET  
1/2" THICK GLASS SHOWN  
(ALSO FOR 3/8" GLASS)





**1995 CSI SECTION 08510 Steel Windows**  
**2004 CSI SECTION 08 51 23 Steel Windows**

**PART 1 - GENERAL**

**1. DESCRIPTION**

- A. Work included:
  - 1. Furnish all labor and materials to complete the fabrication of windows as shown on architect's drawings and as specified herein. All windows covered by this specification shall be fabricated by Arcadia Inc. Vernon, California
- B. Related work specified elsewhere:
  - 1. Glass, glazing and glazing materials, Section 08810.
  - 2. Perimeter caulking, Section 07915.
  - 3. Miscellaneous structural items, Section 05100.

**2. QUALITY ASSURANCE**

- A. Allowable tolerances: Size dimensions + 1/16 inch.
- B. Source quality control:
  - 1. Air infiltration test
    - a. Products must be independently lab tested and meet or exceed ASTM E-283.
    - b. Maximum air infiltration 0.30 CFM/ SQFT with differential pressure across window unit of 1.57 / 6.24 PSF
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    - b. No water penetration for 15 minutes when window is subjected to a rate of flow of 5 gal./hr/sq.ft with differential pressure across window unit of 6.00 PSF
  - 3. Field Testing
    - a. Field testing criteria (when applicable) shall be in accordance with AAMA 502-08.
  - 4. Structural test
    - a. Meets or exceeds ASTM E330
  - 5. Forced entry test
    - a. Meets or exceeds ASTM F588
    - b. Grade 40 @ 300 pounds
  - 6. Quality of top coat combination shall meet or exceed the following ASTM designations:
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    - b. ASTM D714 Paint Blistering Test
    - c. ASTM B117-03 Salt Spray (Fog) Test
    - d. ASTM D1654-05 Painted Products in Corrosive Environments
    - e. ASTM G85 Cyclic Fog/Dry Test (Prohesion)
    - f. ASTM D5894-96 Salt Fog/UV Painted Metal
    - g. ASTM D4541 Pull off Strength of Coating Test

**3. SUBMITTALS**

- A. Shop drawings
  - 1. Submit for approval shop drawings showing window and installation details, including anchorage, fastening and recommended sealing methods.
  - 2. Dimensioned elevations showing window opening and window sizes.

**4. PRODUCT, STORAGE AND HANDLING**

- A. The General Contractor shall be responsible for the protection and storage of the windows after delivery to the site.

**5. WARRANTY**

- A. Provide Arcadia's standard 10 year Limited Warranty.

**PART 2 - PRODUCT AND FABRICATION**

**1. MATERIALS**

- A. Heavy custom windows shall be manufactured from solid hot rolled steel shapes
  - 1. Combined weight of frame and ventilator sections shall be a minimum of 4.20 pounds per lineal foot. Frame section alone shall not weigh less than 1.80 pounds per lineal foot.
- B. Operable Hardware:
  - 1. Awning, Hopper:
    - a. Fastener: Brass or Bronze cam fastener.
    - b. Ventilators shall be hung on heavy-duty stainless steel four bar hinges with brass friction shoes.
  - 2. Casement:
    - a. Fastener: Brass or Bronze cam fastener
    - b. Pivots: Aluminum-bronze pivot with stainless steel pin.
    - c. Friction and limit device: Stainless steel with sliding brass shoe and screw adjusted friction.
- C. All screws that are furnished by Arcadia for hardware, trim, covers, anchoring, weatherbars, water dams, screens, etc. shall be non-ferrous brass or stainless steel. Glazing bead retainer screws are plated steel.

**2. FABRICATION**

- A. Fabricate steel windows in accordance with approved shop drawings.
- B. Prior to fabrication, all hot rolled steel sections shall be cleaned by shot blasting.
- C. Glazing
  - 1. All windows shall be designed for outside glazing.
  - 2. Provide replaceable continuous glazing beads to suit the glass as specified.
- D. Weatherstrip
  - 1. All ventilators shall receive continuous EPDM weatherstripping that shall be applied to the interior and exterior contact surfaces of the frame and ventilator sections.

**3. FACTORY FINISHING**

- A. Pretreatment
  - 1. Pretreatment process to thoroughly clean and prepare the substrates for zinc coating.
- B. Paint Finish Top coat
  - 1. Following the zinc primer coat(s), all windows and accessories are given a spray coat of acrylic polyurethane and oven baked at 225°F for 15 minutes to dry film thickness of 1.5-2.0 mils.

**PART 3 - EXECUTION**

**1. INSPECTION**

- A. Window openings shall conform to details, dimensions and tolerances shown on the window manufacturer's approved shop drawings.

**2. INSTALLATION**

- A. Install windows in openings in strict accordance with approved shop drawings.

**3. CLEANING**

- A. Window installer shall leave window surfaces clean after installation and ready to receive glass and glazing. The window installer will not be responsible for final cleaning.

**END OF SECTION**





Montage Hotel & Resort  
Beverly Hills, CA  
*HKS Hill Glazier Studio*



Corporate Location

2301 East Vernon Avenue  
Vernon, CA 90058

Ph 323.269.7300

Fx 323-269-7390

info@arcadiainc.com

Washington Location

7830 S. 196th Street  
Kent, Washington 98032

Ph 425-869-7300

Fx 253-395-4234

Arizona Location

2510 West Geneva Drive  
Tempe, AZ 85282

Ph 602-437-2514

Fx 602-437-2515

New Mexico Location

4705 Mcleod Road N.E.  
Albuquerque, NM 87109

Ph 505-341-4222

Fx 505-341-4225

Nevada Location

1850 East Maule Avenue  
Las Vegas, NV 89119

Ph 702-798-7300

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