

**1995 CSI SECTION 08120 Aluminum Doors And Frames**  
**2004 CSI SECTION 08 11 16 Aluminum Doors And Frames**

**Part 1 – General**

1.01 Summary

- A. Section includes:
  1. Aluminum Doors and Frames
- B. Related Sections:

1.02 References

- A. American Architectural Manufacturers Association (AAMA)
- B. American Society for Testing and Materials (ASTM)
- C. Aluminum Association (AA)

1.03 System Description

- A. General: In addition to requirements shown or specified, comply with:
  1. Applicable provisions of AAMA Aluminum Storefront and Entrance Manual for design, materials, fabrication and installation of component parts.
- B. Design Requirements: Arcadia 450T Series Arena Entrance System is a single source package of door, doorframe and hardware that is engineered for monumental appeal and maximum protection in tough traffic areas.
- C. Performance Requirements: Each assembly tested by a recognized testing laboratory or agency in accordance with specified test methods.
  1. Tested by the dual moment corner joint strength test.

1.04 Quality Assurance

- A. Single Source Responsibility:
  1. Obtain entrances, storefronts, ribbon walls, window walls, curtain walls, window systems, and finish through one source from a single manufacturer.
- B. Provide test reports from AAMA accredited laboratories certifying the performances as specified in 1.03.

1.05 Warranty

- A. Door warranted against failure and/or deterioration of metals due to manufacturing process for a period of two (2) years.

**Part 2 – Products**

2.01 Manufacturers

- A. Acceptable Manufacturers:
  1. Arcadia, Inc., 2301 E Vernon, Vernon, CA. Telephone 323/269-7300, Fax 323/269-7390.
- B. Acceptable Products:
  1. Arcadia, Inc., 450T Series, Arena Entrance System, 2-1/4".
    - a. Vertical Stiles: 6 inches.
    - b. Top Rail: 4-1/2 inches.
    - c. Bottom Rail: 10 inches.
    - d. Glazing Insert: Snap-in type for \_\_\_\_\_ (1/4" or 1") infill.
  2. Door stiles, rails and frames shall have a nominal .188" and inserts shall have a .062" wall thickness.

2.02 Materials and Accessories

- A. Door members: Extruded 6063-T6 aluminum alloy (ASTM B221-Alloy G.S. 10a T6).
- B. Screws, fastening devices, and internal components: Aluminum, stainless steel, or zinc plated steel in accordance with ASTM A-164. Shall be aluminum or steel, providing the steel is properly isolated from aluminum.
- C. Glazing Gasket (compression-type design).

2.03 Hardware

- A. Hardware furnished and installed by the door manufacturer, and include the following standard hardware (as selected).
  1. Weatherstripping: Hard-backed poly pile in door and/or frame. Meeting stile of all pair of doors have a double line hard-backed poly-pile astragal.
  2. Threshold: Extruded Aluminum with ribbed surface.
  3. Sill Sweeps: Brush strip (exposed, concealed).
  4. Pivoting/Hinging: (Center, offset pivot; butt, continuous.)
  5. Closers: (Overhead concealed, surface, floor.)
  6. Latches/Strike: (Dead-latch combination, two-point.)
  7. Latch Handle: (Lever, eurostyle/ w/return, paddle.)
  8. Electric Release: (Offset strike, center hung strike.)
  9. Locks/Strike: (Maximum security hooklock, deadbolt.)

- 10. Auxiliary Locks: (Two-point, three-point, flushbolts.)  
Cylinders: (Mortise, rim, dummy, thumbturn.)
- 11. Panic Devices: (Cross, touch bar, flush mid panel.)
- 12. Push/Pulls: (Standard, offset radius, straight radius.)
- 13. Cylinder Guard: (Security ring/retainer ring.)
- 14. Exit Indicator: (Message panel.)
- 15. Transom Decal: (This door to remain . . .)
- 16. Door Stop/Holder:
- 17. Mail slot.

SPECIFIER NOTE: Refer to Arcadia Architectural Manual, Hardware Section for description of items 4-18.

2.04 Finish

- A. Finish all exposed areas of aluminum and components as indicated.
  1. An Architectural Class II or I color anodic coating conforming with AA-M12C22A34/AA-M12C22A44.
    - a. Anodized finish color shall be Colornodic \_\_\_\_\_. (AB1 Light Champagne, AB2 Champagne, AB3 Light Bronze, AB4 Medium Bronze, AB5 Standard Medium Bronze, AB6 Dark Bronze, AB7 Standard Dark Bronze, AB8 Black.)
  - (or) 1. An Architectural Class II or I anodic coating conforming with AA-M12C22A31/AA-M12C22A41.
    - a. Anodize finish color shall be Colornodic \_\_\_\_\_ (#11 Clear)
  - (or) 1. Fluorocarbon Coating: AAMA 2605.2.
    - a. Resin: 70% PVDF Kynar 500/Hylar 5000.
    - b. Substrate: cleaned and pretreated with chromium phosphate.
    - c. Primer: Manufacturer's standard resin base compatible coating. Dry film thickness.
      - (a) Extrusion: Minimum 0.20 mil.
    - d. Color Coat: 70% PVDF, dry film thickness.
      - (a) Extrusion: 1.0 mil.
    - e. Color: As selected by Architect.
    - f. Acceptable Coatings Manufacturers:
      - (a) PPG Industries, Inc.
      - (b) Valspar Corporation
      - (c) BASF

2.05 Door Fabrication

- A. Door stiles and rails shall be tubular sections accurately joined at corners with heavy concealed thru bolts, machine bolts and then MIG welded.
- B. Each door leaf equipped with an adjusting mechanism, located in the top rail near the lock stile.
- C. Custom hardware templates and physical hardware must be submitted prior to any fabrication.

**Part 3 – Execution**

3.01 Examinations

- A. Examine conditions and verify substrate conditions are acceptable for product installation.

3.02 Installation

- A. Install in accordance with approved shop drawings and manufacturers installation instructions.

3.03 Field Quality Control

- A. Make all necessary final adjustments to attain normal operation of each door and its mechanical hardware.

**END OF SECTION**