SECTION 084413 GLAZED ALUMINUM CURTAIN WALLS

This suggested guide specification has been developed using the current edition of the Construction Specifications Institute (CSI) “Manual of Practice,” including the recommendations for the CSI 3 Part Section Format and the CSI Page Format. Additionally, the development concept and organizational arrangement of the American Institute of Architects (AIA) MASTERSPEC Program has been recognized in the preparation of this guide specification. Neither CSI, AIA, USGBC nor ILFI endorse specific manufacturers and products. The preparation of the guide specification assumes the use of standard contract documents and forms, including the “Conditions of the Contract,” published by the AIA.

PART 1 - GENERAL

1.1 Related Documents

A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 Summary

A. Section Includes: Kawneer Architectural Aluminum Curtain Wall Systems, including perimeter trims, stools, accessories, shims and anchors, and perimeter sealing of curtain wall framing.

1. Types of Kawneer Aluminum Curtain Wall include:
   a. 1600 SS Curtain Wall System - 2-1/2” x 6” (63.5 x 152.4) or 2-1/2” x 7-1/2” (63.5 x 190.5), outside glazed pressure plate or structural silicone glazed (SSG) format.
   b. 1600 SS Curtain Wall System Blast Mitigation - 2-1/2” x 7-1/2” (63.5 x 190.5), outside glazed pressure plate or tape glazed format.

EDITOR NOTE: BELOW RELATED SECTIONS ARE SPECIFIED ELSEWHERE HOWEVER KAWNEER RECOMMENDS SINGLE SOURCE RESPONSIBILITY FOR ALL OF THESE SECTIONS AS INDICATED IN PART 1.6 QUALITY ASSURANCE.

1.3 Definitions

A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufacturers Association (AAMA) – AAMA Glossary (AAMA AG).

1.4 Performance Requirements

EDITOR NOTE: AIR AND WATER PERFORMANCE RESULTS ARE BASED UPON ASTM AND AAMA STANDARDS. CONSULT YOUR LOCAL KAWNEER REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.

A. General Performance: Comply with performance requirements specified, as determined by testing of glazed aluminum curtain walls representing those indicated for this Project without failure due to defective manufacture, fabrication, installation, or other defects in construction.

1. Glazed aluminum curtain walls shall withstand movements of supporting structure including, but not limited to, story drift, twist, column shortening, long-term creep, and deflection from uniformly distributed and concentrated live loads. Failure also includes the following:
   a. Thermal stresses transferring to building structure.
   b. Glass breakage.
   c. Loosening or weakening of fasteners, attachments, and other components.
   d. Failure of operating units.

B. Delegated Design: Design glazed aluminum curtain walls, including comprehensive engineering analysis by a qualified professional engineer, using performance requirements and design criteria indicated.

EDITOR NOTE: PROVIDE WIND LOAD DESIGN PRESSURES IN PSF AND INCLUDE APPLICABLE BUILDING CODE AND YEAR EDITION.

C. Wind loads: Provide Curtain Wall system; include anchorage, capable of withstanding wind load design pressures of (____) lbs./sq. ft. or (____)Pa, inward and (____) lbs./sq. ft. or (____)Pa, outward. The design pressures are based on the (____) Building Code; (____) Edition.
D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.06 cfm/ft2 (0.3 l/s · m2) at a static air pressure differential of 6.24 psf (300 Pa).

E. Water Resistance, (static): The test specimen shall be tested in accordance with ASTM E 331. There shall be no leakage at a static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.

F. Water Resistance, (dynamic): The test specimen shall be tested in accordance with AAMA 501.1. There shall be no leakage at an air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.

G. Uniform Load: A static air design load of 40 psf (1915 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330. There shall be no deflection in excess of L/175 of the span of any framing member at design load. At structural test load equal to 1.5 times the specified design load, no glass breakage or permanent set in the framing members in excess of 0.2% of their clear spans shall occur.

H. Seismic: When tested to AAMA 501.4, system must meet design displacement of 0.010 x the story height and ultimate displacement of 1.5 x the design displacement.

EDITOR NOTE: THERMAL TRANSMITTANCE AND CONDENSATION RESISTANCE TEST RESULTS IN ACCORDANCE WITH AAMA 1503 OR CSA A440 ARE BASED UPON 1" CLEAR INSULATING GLASS, (1/4", 1/2" AS, 1/4"). REFER TO THERMAL TRANSMITTANCE CHARTS IN ACCORDANCE WITH AAMA 507 FOR PROJECT SPECIFIC U-FACTORs, SHGC AND VT REFER TO THERMAL PERFORMANCE MATRIX FOR NFRC VALUES.

I. Energy Efficiency:
   1. Thermal Transmittance (U-factor): The thermal transmittance (U-factor) shall not be more than:
      a. Captured - 0.65 (clear) when tested to AAMA 1503
      b. SSG - 0.58 (clear) when tested to AAMA 1503,
      or
      Project Specific ( ) BTU/hr·ft² °F per AAMA 507 or ( ) BTU/hr·ft² °F per NFRC 100.

J. Condensation Resistance (CRF): When tested to AAMA Specification 1503, the condensation resistance factor shall not be less than:
   1. Captured - 61frame and 60glass (clear),
   2. SSG - 72same and 62glass (clear),
   or
   Condensation Index (I): when tested to CSA-A440-00, the Condensation Index shall not be less than:
   1. Captured - 61frame and 51glass (clear),
   2. SSG - 64frame and 54glass (clear).

K. Sound Transmission Loss: When tested to ASTM E90 and ASTM E1425, the Sound Transmission Class (STC) and Outdoor/Indoor Transmission Class (OITC) shall not be less than:
   1. Captured - STC 31 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4"),
   2. SSG - STC 32 or OITC 26 based upon 1" (25.4) insulating glass (1/4", 1/2" AS, 1/4").

L. Blast Mitigation Performance: Shall be tested or proven through analysis to meet ASTM F1642, GSA-TS01, and UFC 04-010.01 performance criteria. To meet UFC 04-010-01, B-3.1 Standard 10 for Windows and Skylights, the following options are available:
   1. Section B-3.1.1 Dynamic analysis
   2. Section B-3.1.2 Testing
   3. Section B-3.1.3 ASTM F2248 Design Approach

M. Environmental Product Declaration (EPD): Shall have a Type III Product-Specific EPD created from a Product Category Rule.

EDITOR NOTE: MATERIAL INGREDIENT REPORTING IF REQUIRED TO MEET PROJECT REQUIREMENTS AND ON ANY GREEN BUILDING CERTIFICATIONS SUCH AS LEED OR LBC.

EDITOR NOTE: MATERIAL INGREDIENT REPORTING ONLY FOR ANODIZED PRODUCTS.

N. Material Ingredient Reporting: Shall have a complete list of chemical ingredients to at least 100ppm (0.01%) that covers 100% of the product, acceptable documentation includes:
   1. Manufacturer's inventory with Chemical Abstract Service Registration Number (CASRN or CAS#).
1.5 Submittals

EDITOR NOTE: ADD RECYCLED CONTENT SECTION IF REQUIRED TO MEET PROJECT REQUIREMENTS AND/OR GREEN BUILDING CERTIFICATIONS SUCH AS LEED, LIVING BUILDING CHALLENGE (LBC), ETC. ARE REQUIRED.

* IF RECYCLED CONTENT REQUIREMENTS ARE NOT SPECIFIED - PRIME (ZERO RECYCLED CONTENT) ALUMINUM COULD BE SUPPLIED.

A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
   1. Recycled Content:
      a. Provide documentation that aluminum has a minimum of 50% mixed pre- and post-consumer recycled content with a sample document illustrating project specific information that will be provided after product shipment.
      b. Once product has shipped, provide project specific recycled content information, including:
         1) Indicate recycled content; indicate percentage of pre- and post-consumer recycled content per unit of product.
         2) Indicate relative dollar value of recycled content product to total dollar value of product included in project.
         3) Indicate location recovery of recycled content.
         4) Indicate location of manufacturing facility.
   2. Environmental Product Declaration (EPD):
      a. Include a Type III Product-Specific EPD created from a Product Category Rule.

EDITOR NOTE: MATERIAL INGREDIENT REPORTING ONLY FOR ANODIZED PRODUCTS.

3. Material Ingredient Reporting:
   a. Include documentation for material reporting that has a complete list of chemical ingredients to at least 100ppm (0.01%) that covers 100% of the product.

B. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.

C. Samples for Initial Selection: For units with factory-applied color finishes.

D. Samples for Verification: For each type of exposed finish required, in manufacturer’s standard sizes.

E. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified preconstruction testing agency, for glazed aluminum curtain walls, indicating compliance with performance requirements.

F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed curtain wall systems, made from 12” (304.8 mm) lengths of full-size components and showing details of the following:
   1. Joinery.
   2. Glazing.

1.6 Quality Assurance

A. Installer Qualifications: Installer who has had successful experience with installation of the same or similar systems required for the project and other projects of similar size and scope.

B. Manufacturer Qualifications: A manufacturer capable of fabricating glazed aluminum curtain walls that meet or exceed performance requirements.

C. Source Limitations: Obtain aluminum curtain wall system through one source from a single manufacturer.

D. Product Options: Information on Drawings and in Specifications establishes requirements for aesthetic effects and performance characteristics of assemblies. Aesthetic effects are indicated by dimensions, arrangements, alignment, and profiles of components and assemblies as they relate to sightlines, to one another, and to adjoining construction.
   1. Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect’s approval. If revisions are proposed, submit comprehensive explanatory data to Architect for review.

E. Mockups: Build mockups to verify selections made under sample submittals and to demonstrate aesthetic effects and set quality standards for materials and execution.
   1. Build mockups for type(s) of curtain wall elevation(s) indicated, in location(s) shown on Drawings.

F. Pre-installation Conference: Conduct conference at Project site to comply with requirements in Division 01 Section “Project Management and Coordination”.

1.7 Project Conditions

A. Field Measurements: Verify actual locations of structural supports for glazed aluminum curtain walls by field measurements before fabrication and indicate measurements on Shop Drawings.

1.8 Warranty

A. Manufacturer’s Warranty: Submit, for Owner’s acceptance, manufacturer’s standard warranty.
   1. Warranty Period: Two (2) years from Date of Substantial Completion of the project provided however that the Limited Warranty shall begin in no event later than six months from date of shipment by manufacturer.
PART 2 - PRODUCTS

EDITOR NOTE: RETAIN BELOW FOR ALTERNATE MANUFACTURERS/PRODUCTS AS SPECIFIED IN THE CONTRACT DOCUMENTS. COORDINATE BELOW WITH BID DOCUMENTS IF ANY, AND DIVISION 1 ALTERNATES SECTION. CONSULT WITH KAWNEER COMPANY FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. KAWNEER RECOMMENDS OTHER MANUFACTURERS REQUESTING APPROVAL TO BID THEIR PRODUCT AS AN EQUAL MUST SUBMIT THEIR REQUEST IN WRITING (10) DAYS PRIOR TO CLOSE OF BIDDING.

2.1 Manufacturers

A. Basis-of-Design Product:
   1. Kawneer Company Inc.
   2. 1600 SS Curtain Wall.
   3. Frame depth options: 2-1/2" x 6" (63.5 x 152.4) or 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed captured or structural silicone glazed (SSG) format.
   4. 1600 SS Curtain Wall Blast Mitigation
   5. Frame options: 2-1/2" x 7-1/2" (63.5 x 190.5), outside glazed captured or tape glazed format.

EDITOR NOTE: RETAIN BELOW ARTICLE FOR PROPRIETARY METHOD SPECIFICATION. ADD PRODUCT ATTRIBUTES, PERFORMANCE CHARACTERISTICS, MATERIAL STANDARDS, AND DESCRIPTIONS AS APPLICABLE, DO NOT USE THE PHRASE "OR EQUAL," "OR APPROVED EQUAL," OR SIMILAR PHRASES. USE OF SUCH PHRASES CAUSES AMBIGUITY IN THE SPECIFICATIONS BECAUSE OF THE DIFFERENT INTERPRETATIONS AMONG THE DIVERGENT PARTIES OF THE CONSTRUCTION PROCESS AND READERS OF THE SPECIFICATIONS. SUCH PHRASES REQUIRE EXTENSIVE AND COMPLETE REQUIREMENTS (PROCEDURAL, LEGAL, REGULATORY, AND RESPONSIBILITY) FOR DETERMINING "OR EQUAL."

2.2 Materials

A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum curtain wall manufacturer for strength, corrosion resistance, and application of required finish and not less than 0.070" (1.8) wall thickness at any location for the main frame and complying with ASTM B 221: 6063-T6 alloy and temper.

EDITOR NOTE: ADD RECYCLED CONTENT SECTION IF REQUIRED TO MEET PROJECT REQUIREMENTS AND/OR GREEN BUILDING CERTIFICATIONS SUCH AS LEED, LIVING BUILDING CHALLENGE (LBC), ETC. ARE REQUIRED.

* IF RECYCLED CONTENT REQUIREMENTS ARE NOT SPECIFIED, PRIME (ZERO RECYCLED CONTENT) ALUMINUM COULD BE SUPPLIED.

1. Recycled Content: Shall have a minimum of 50% mixed pre- and post-consumer recycled content.
   a. Indicate recycled content; indicate percentage of pre-consumer and post-consumer recycled content per unit of product.
   b. Indicate relative dollar value of recycled content product to total dollar value of product included in project.
   c. Indicate location recovery of recycled content.
   d. Indicate location of manufacturing facility.

B. Aluminum sheet alloy: Shall meet the requirements of ASTM B209.

C. Fasteners: Aluminum, nonmagnetic stainless steel or other materials to be non-corrosive and compatible with aluminum window members, trim hardware, anchors, and other components.

D. Anchors, Clips, and Accessories: Aluminum, nonmagnetic stainless steel, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.

E. Pressure Plate: Pressure plate shall be aluminum and fastened to the mullion with stainless steel screws.

F. Reinforcing Members: Aluminum, nonmagnetic stainless steel, or nickel/chrome-plated steel complying with ASTM B 456 for Type SC 3 severe service conditions, or zinc-coated steel or iron complying with ASTM B 633 for SC 3 severe service conditions or other suitable zinc coating; provide sufficient strength to withstand design pressure indicated.
G. Sealant: For sealants required within fabricated curtain wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

H. Thermal Barrier: Thermal separator shall be extruded of a silicone compatible elastomer that provides a minimum 1/4" separation.

I. Tolerances: Reference to tolerances for wall thickness and other cross-sectional dimensions of glazed curtain wall members are nominal and in compliance with AA Aluminum Standards and Data.

**EDITOR NOTE: RED LIST FREE ONLY FOR ANODIZED PRODUCTS.**

J. Red List Free: All parts and materials comply with the Living Building Challenge/DECLARE Red List and the Cradle-to-Cradle (C2C) Banned List.
   1. PVC free.
   2. Neoprene free.
   OR

K. Red List Free: Product does not contain PVC or Neoprene.

### 2.3 Curtain Wall Framing

A. Framing Members: Manufacturer's standard extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.

B. Glass: 1" (25.4) insulating glass option. 1/4" (6.3) for Spandrel applications.

C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.

D. Framing Sealants: Shall be suitable for glazed aluminum curtain wall as recommended by sealant manufacturer.

E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials. Where exposed shall be stainless steel.

F. Perimeter Anchors: When steel anchors are used, provide insulation between steel material and aluminum material to prevent galvanic action.

G. Storage, Shipping, Handling and Unloading: Deliver materials in manufacturer's original, unopened, undamaged containers with identification labels intact.

H. Storage and Protection: Store materials protected from exposure to harmful weather conditions. Handle curtain wall material against damage from elements, construction activities, and other hazards before, during and after installation.

### 2.4 Glazing

A. Glazing: Comply with Division 08 Section “Glazing”. Following glazing options are available.
   1. 1600 SS Curtain Wall: Outside glazed format with 1" (25.4) double glazed insulating glass.

B. Glazing Gaskets: Gaskets to meet the requirements of ASTM C864.

C. Spacers and Setting Blocks: Manufacturer's standard elastomeric type.

D. Bond-Breaker Tape: Manufacturer's standard TFE-fluorocarbon or polyethylene material to which sealants will not develop adhesion.

E. Glazing Sealants: As recommended by manufacturer for joint type.

### 2.5 Operable Units

A. Doors: Comply with Division 08 Section “Aluminum-Framed Entrances and Storefronts”.

B. Windows: Comply with Division 08 Section “Aluminum Windows”.

### 2.6 Accessory Materials

A. Bituminous Paint: Cold-applied asphalt-mastic paint complying with SSPC-Paint 12 requirements except containing no asbestos, formulated for 30-mil (0.762 mm) thickness per coat.

B. Versoleil™ SunShade – Outrigger/Single Blade System: An aluminum sunshade (consisting of outriggers, louvers, and fascia which may be selected from standard configurations, modified configurations, or customized) that is anchored directly to the vertical curtain wall mullions. Anchors shall be painted (Select from Kawneer’s standard paints and colors. Custom colors are available upon request.). Louvers and fascia shall be painted or anodized (Select from Kawneer’s standard paints and colors, custom colors are available upon request, or Kawneer’s anodized finishes.).
2.7 Fabrication

A. Form or extrude aluminum shapes before finishing.

B. Fabricate components that, when assembled, have the following characteristics:
   1. Profiles that are sharp, straight, and free of defects or deformations.
   2. Accurately fitted joints.
   3. Physical and thermal isolation of glazing from framing members.
   4. Accommodations for thermal and mechanical movements of glazing and framing to maintain required glazing edge clearances.
   5. Provisions for field replacement of glazing from exterior.
   6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
   7. Internal weeping system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.

C. Curtain Wall Framing: Fabricate components for assembly using shear block system following manufacturer's standard installation instructions.

D. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 Aluminum Finishes

EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM KAWNEER'S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST FROM THE KAWNEER COMPANY. OTHER PIGMENTED ORGANIC COATINGS CONFORMING TO AAMA 2603 ARE AVAILABLE. CONSULT WITH YOUR KAWNEER REPRESENTATIVE FOR OTHER SURFACE TREATMENTS AND FINISHES.

A. Finish designations prefixed by AA comply with the system established by the Aluminum Association for designating aluminum finishes.

B. Factory Finishing:
   4. Kawneer Permafluor™ (70% PVDF), AAMA 2605, Fluoropolymer Coating (Color __________).
   5. Kawneer Permadize™ (50% PVDF), AAMA 2604, Fluoropolymer Coating (Color __________).
   6. Kawneer Permacoat™ AAMA 2604, Powder Coating (Color __________).
   7. Other: Manufacturer __________ Type __________ (Color __________).

PART 3 - EXECUTION

3.1 Examination

A. Examine areas, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.

B. Proceed with installation only after unsatisfactory conditions have been corrected.

EDITOR NOTE: COORDINATE BELOW ARTICLE WITH MANUFACTURER'S RECOMMENDED INSTALLATION DETAILS AND INSTALLATION INSTRUCTIONS.

3.2 Installation

A. General: Install curtain wall systems plumb, level, and true to line, without warp or rack of frames with manufacturer's prescribed tolerances and installation instructions. Provide support and anchor in place.
   1. Dissimilar Materials: Provide separation of aluminum materials from sources of corrosion or electrolytic action contact points.
   2. Glazing: Glass shall be outside glazed and held in place with extruded aluminum pressure plates anchored to the mullion using stainless steel fasteners spaced no greater than 9" on center.
   3. Water Drainage: Each light of glass shall be compartmentalized using joint plugs and silicone sealant to divert water to the horizontal weep locations. Weep holes shall be located in the horizontal pressure plates and covers to divert water to the exterior of the building.

B. Related Products Installation Requirements:
   1. Sealants (Perimeter): Refer to Joint Treatment (Sealants) Section.
   2. Glass: Refer to Glass and Glazing Section.
3.3 Field Quality Control

A. Field Tests: Architect shall select curtain wall units to be tested as soon as a representative portion of the project has been installed, glazed, perimeter caulked and cured. Conduct tests for air infiltration and water penetration with manufacturer’s representative present. Tests not meeting specified performance requirements and units having deficiencies shall be corrected as part of the contract amount.

1. Testing: Testing shall be performed per AAMA 503 by a qualified independent testing agency. Refer to Testing Section for payment of testing and testing requirements.
   a. Air Infiltration Tests: Conduct tests in accordance with ASTM E 783. Allowable air infiltration shall not exceed 1.5 times the amount indicated in the performance requirements or 0.09 cfm/ft², whichever is greater.
   b. Water Infiltration Tests: Conduct tests in accordance with ASTM E 1105. No uncontrolled water leakage is permitted when tested at a static test pressure of two-thirds the specified water penetration pressure but not less than 8 psf (383 Pa).

B. Manufacturer’s Field Services: Upon Owner’s written request, provide periodic site visit by manufacturer’s field service representative.

3.4 Adjusting, Cleaning and Protection

A. Protection: Protect installed product’s finish surfaces from damage during construction. Protect aluminum curtain wall system from damage from grinding and polishing compounds, plaster, lime, acid, cement, or other harmful contaminants.

B. Cleaning: Repair or replace damaged installed products. Clean installed products in accordance with manufacturer’s instructions prior to owner’s acceptance. Remove construction debris from project site and legally dispose of debris.

C. Remove and replace glass that has been broken, chipped, cracked, abraded, or damaged during construction period.

DISCLAIMER STATEMENT

This guide specification is intended to be used by a qualified construction specifier. The guide specification is not intended to be verbatim as a project specification without appropriate modifications for the specific use intended. The guide specification must be used and coordinated with the procedures of each design firm, and the particular requirements of a specific construction project.

END OF SECTION 084413