

SECTION 08 4413 - GLAZED ALUMINUM CURTAIN WALLS

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 glazed aluminum curtain walls.

1.3 ACTION SUBMITTALS

- A. Product Data: For each type of product.
 - 1. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.
- B. LEED Submittals:
 - 1. Product Data for Credit IEQ 4.1: For glazing sealants used inside the weatherproofing system, documentation including printed statement of VOC content.
- C. Shop Drawings: For glazed aluminum curtain walls. Include plans, elevations, sections, full-size details, and attachments to other work.
 - 1. Include details of provisions for assembly expansion and contraction and for draining moisture occurring within the assembly to the exterior.
 - 2. Include full-size isometric details of each vertical-to-horizontal intersection of glazed aluminum curtain walls, showing the following:
 - a. Joinery, including concealed welds.
 - b. Anchorage.
 - c. Expansion provisions.
 - d. Glazing.
 - e. Flashing and drainage.
 - 3. Show connection to and continuity with adjacent thermal, weather, air, and vapor barriers.
- D. Samples for Initial Selection: For units with factory-applied color finishes.
- E. Samples for Verification: For each type of exposed finish required, in manufacturer's standard sizes.

- F. Fabrication Sample: Of each vertical-to-horizontal intersection of assemblies, made from 12-inch (300-mm) lengths of full-size components and showing details of the following:
 - 1. Joinery, including concealed welds.
 - 2. Anchorage.
 - 3. Expansion provisions.
 - 4. Glazing.
 - 5. Flashing and drainage.

- G. Delegated-Design Submittal: For glazed aluminum curtain walls indicated to comply with performance requirements and design criteria, including analysis data signed and sealed by the qualified professional engineer responsible for their preparation.

1.4 INFORMATIONAL SUBMITTALS

- A. Preconstruction Laboratory Mockup Testing Submittals:
 - 1. Testing Program: Developed specifically for Project.
 - 2. Test Reports: Prepared by a qualified preconstruction testing agency for each mockup test.
 - 3. Record Drawings: As-built drawings of preconstruction laboratory mockups showing changes made during preconstruction laboratory mockup testing.

- B. Qualification Data: For Installer and laboratory mockup testing agency and field testing agency.

- C. Energy Performance Certificates: For glazed aluminum curtain walls, accessories, and components from manufacturer.
 - 1. Basis for Certification: NFRC-certified energy performance values for each glazed aluminum curtain wall.

- D. Product Test Reports: For glazed aluminum curtain walls, for tests performed by manufacturer and witnessed by a qualified testing agency.

- E. Quality-Control Program: Developed specifically for Project, including fabrication and installation, according to recommendations in ASTM C 1401. Include periodic quality-control reports.

- F. Source quality-control reports.

- G. Field quality-control reports.

- H. Sample Warranties: For special warranties.

1.5 CLOSEOUT SUBMITTALS

- A. Maintenance Data: For glazed aluminum curtain walls to include in maintenance manuals.

- B. Maintenance Data for Structural Sealant: For structural-sealant-glazed curtain walls to include in maintenance manuals. Include ASTM C 1401 recommendations for post-installation-phase quality-control program.

1.6 QUALITY ASSURANCE

- A. Comply with the most current edition of the Northwestern University Design Standards.
- B. Installer Qualifications: An entity that employs installers and supervisors who are trained and approved by manufacturer.
- C. Laboratory Mockup Testing Agency Qualifications: Qualified according to ASTM E 699 for testing indicated.
 - 1. Firm shall be approved by the University.
- D. Testing Agency Qualifications: Qualified according to ASTM E 699 for testing indicated.
 - 1. Firm shall be approved by the University.
- E. 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 change intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If changes are proposed, submit comprehensive explanatory data to Architect for review.
- F. Structural-Sealant Glazing: Comply with ASTM C 1401 for design and installation of curtain wall assemblies.

1.7 MOCKUPS

- A. Mockups: Build mockups to verify selections made under Sample submittals and to demonstrate aesthetic effects and set quality standards for fabrication and installation.
 - 1. Build mockup of typical wall area as shown on Drawings.
 - a. Mockup shall be at least 2 stories high by 2 bays wide.
 - 2. Testing shall be performed on mockups according to requirements in "Field Quality Control" Article.
 - 3. Approval of mockups does not constitute approval of deviations from the Contract Documents contained in mockups unless Architect specifically approves such deviations in writing.
 - 4. Maintain mock-ups in good condition during construction.
 - 5. Demolish mock-ups when directed, and remove from site.

1.8 PRECONSTRUCTION LABORATORY MOCKUPS

- A. Preconstruction Testing Service: **[Owner will engage]** **[Engage]** a qualified testing agency to perform testing on preconstruction laboratory mockups.
- B. Build preconstruction laboratory mockups at testing agency facility; use personnel, products, and methods of construction that will be used at Project site.

1. Size and Configuration: At least 2 stories high by 2 bays wide.
2. Notify Architect seven days in advance of the dates and times when preconstruction laboratory mockups will be constructed and tested.

C. Preconstruction Laboratory Mockup Testing Program: Test preconstruction laboratory mockups according to requirements in "Performance Requirements" Article. Perform the following tests in the following order:

1. Air Infiltration: ASTM E 283.
2. Water Penetration under Static Pressure: ASTM E 331.
3. Thermal transmittance: AAMA 1503.1.
4. Condensation resistance: AAMA 1503.1.

1.9 WARRANTY

A. Special Assembly Warranty: Manufacturer agrees to repair or replace components of glazed aluminum curtain wall that do not comply with requirements or that fail in materials or workmanship within specified warranty period.

1. Failures include, but are not limited to, the following:
 - a. Structural failures including, but not limited to, excessive deflection.
 - b. Noise or vibration created by wind and thermal and structural movements.
 - c. Deterioration of metals[, **metal finishes**,] and other materials beyond normal weathering.
 - d. Water penetration through fixed glazing and framing areas.
 - e. Failure of operating components.
2. Warranty Period: [**Two**] [**Five**] [**10**] <Insert number> years from date of Substantial Completion.

B. Special Finish Warranty: Standard form in which manufacturer agrees to repair finishes or replace aluminum that shows evidence of deterioration of factory-applied finishes within specified warranty period.

1. Deterioration includes, but is not limited to, the following:
 - a. Color fading more than 5 Hunter units when tested according to ASTM D 2244.
 - b. Chalking in excess of a No. 8 rating when tested according to ASTM D 4214.
 - c. Cracking, checking, peeling, or failure of paint to adhere to bare metal.
2. Warranty Period: [**Five**] [**10**] [**20**] <Insert number> years from date of Substantial Completion.

PART 2 - PRODUCTS

2.1 PERFORMANCE REQUIREMENTS

A. Delegated Design: Engage a qualified professional engineer, as defined in Section 014000 "Quality Requirements," to design glazed aluminum curtain walls.

- B. 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.
 2. Failure also includes the following:
 - a. Thermal stresses transferring to building structure.
 - b. Glass breakage.
 - c. Noise or vibration created by wind and thermal and structural movements.
 - d. Loosening or weakening of fasteners, attachments, and other components.
 - e. Failure of operating units.
- C. Structural Loads:
1. Wind Loads: As indicated on Drawings.
 2. Other Design Loads: **<Insert loads>**.
- D. Deflection of Framing Members: At design wind pressure, as follows:
1. Deflection Parallel to Glazing Plane: Limited to 1/360 of clear span or 1/8 inch (3.2 mm), whichever is smaller amount not exceeding that which reduces glazing bite to less than 75 percent of design dimension and that which reduces edge clearance between framing members and glazing or other fixed components to less than 1/8 inch (3.2 mm).
 2. Cantilever Deflection: Where framing members overhang an anchor point, as follows:
 - a. Perpendicular to Plane of Wall: No greater than 1/240 of clear span plus 1/4-inch (6.35-mm) for spans greater than 11 feet 8-1/4 inches (3.6 m) or 1/175 times span, for spans less than 11 feet 8-1/4 inches (3.6 m).
- E. Structural: Test according to ASTM E 330 as follows:
1. When tested at positive and negative wind-load design pressures, assemblies do not evidence deflection exceeding specified limits.
 2. When tested at 150 percent of positive and negative wind-load design pressures, assemblies, including anchorage, do not evidence material failures, structural distress, or permanent deformation of main framing members exceeding 0.2 percent of span.
 3. Test Durations: As required by design wind velocity, but not less than 10 seconds.
- F. Air Infiltration: Test according to ASTM E 283 for infiltration as follows:
1. Fixed Framing and Glass Area:
 - a. Maximum air leakage of 0.06 cfm/sq. ft. (0.30 L/s per sq. m) at a static-air-pressure differential of 6.24 lbf/sq. ft. (300 Pa).
- G. Water Penetration under Static Pressure: Test according to ASTM E 331 as follows:
1. No evidence of water penetration through fixed glazing and framing areas when tested according to a minimum static-air-pressure differential of 20 percent of positive wind-load design pressure, but not less than 6.24 lbf/sq. ft. (300 Pa).

- H. Interstory Drift: Accommodate design displacement of adjacent stories indicated.
1. Design Displacement: <Insert design displacement>.
 2. Test Performance: Complying with criteria for passing based on building occupancy type when tested according to AAMA 501.4 at design displacement and 1.5 times the design displacement.
- I. Seismic Performance: Glazed aluminum curtain walls shall withstand the effects of earthquake motions determined according to ASCE/SEI 7.
1. Seismic Drift Causing Glass Fallout: Complying with criteria for passing based on building occupancy type when tested according to AAMA 501.6 at design displacement and 1.5 times the design displacement.
 2. Vertical Interstory Movement: Complying with criteria for passing based on building occupancy type when tested according to AAMA 501.7 at design displacement and 1.5 times the design displacement.
- J. Energy Performance: Certify and label energy performance according to NFRC as follows:
1. Thermal Transmittance (U-factor): Fixed glazing and framing areas shall have U-factor of not more than 0.69 Btu/sq. ft. x h x deg F (3.92 W/sq. m x K) as determined according to NFRC 100.
 2. Solar Heat Gain Coefficient: Fixed glazing and framing areas shall have a solar heat gain coefficient of no greater than [0.35] [0.40] [0.45] <Insert value> as determined according to NFRC 200.
 3. Condensation Resistance: Fixed glazing and framing areas shall have an NFRC-certified condensation resistance rating of no less than 45 as determined according to NFRC 500.
- K. Thermal Movements: Allow for thermal movements resulting from ambient and surface temperature changes:
1. Temperature Change: 120 deg F (67 deg C), ambient; 180 deg F (100 deg C), material surfaces.
- L. Structural-Sealant Joints:
1. Designed to carry gravity loads of glazing.
 2. Designed to produce tensile or shear stress of less than 20 psi (138 kPa).
- M. Structural Sealant: Capable of withstanding tensile and shear stresses imposed by structural-sealant-glazed curtain walls without failing adhesively or cohesively. When tested for preconstruction adhesion and compatibility, cohesive failure of sealant shall occur before adhesive failure.
1. Adhesive failure occurs when sealant pulls away from substrate cleanly, leaving no sealant material behind.
 2. Cohesive failure occurs when sealant breaks or tears within itself but does not separate from each substrate because sealant-to-substrate bond strength exceeds sealant's internal strength.

2.2 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
1. EFCO Corporation.
 2. Kawneer North America: an Alcoa company.
 3. Pittco Architectural Metals, Inc.
 4. Tubelite Inc.
- B. Source Limitations: Obtain all components of curtain wall system, including framing spandrel panels entrances sun control and accessories, from single manufacturer.

2.3 FRAMING

- A. Framing Members: Manufacturer's extruded- or formed-aluminum framing members of thickness required and reinforced as required to support imposed loads.
1. Construction: [**Thermally broken**] [**Thermally improved**].
 2. Glazing System: Retained mechanically with gaskets on four sides.
 3. Glazing Plane: <Insert location>.
 4. Finish: [**Clear anodic finish**] [**Color anodic finish**] [**High-performance organic finish**].
 5. Fabrication Method: Either factory- or field-fabricated system.
- B. Pressure Caps: Manufacturer's standard aluminum components that mechanically retain glazing.
1. Include snap-on aluminum trim that conceals fasteners.
- C. Brackets and Reinforcements: Manufacturer's standard high-strength aluminum with nonstaining, nonferrous shims for aligning system components.
- D. Materials:
1. Aluminum: Alloy and temper recommended by manufacturer for type of use and finish indicated.
 - a. Sheet and Plate: ASTM B 209 (ASTM B 209M).
 - b. Extruded Bars, Rods, Profiles, and Tubes: ASTM B 221 (ASTM B 221M).
 - c. Extruded Structural Pipe and Tubes: ASTM B 429/B 429M.
 - d. Structural Profiles: ASTM B 308/B 308M.
 2. Steel Reinforcement: Manufacturer's standard zinc-rich, corrosion-resistant primer complying with SSPC-PS Guide No. 12.00; applied immediately after surface preparation and pretreatment. Select surface preparation methods according to recommendations in SSPC-SP COM, and prepare surfaces according to applicable SSPC standard.
 - a. Structural Shapes, Plates, and Bars: ASTM A 36/A 36M.
 - b. Cold-Rolled Sheet and Strip: ASTM A 1008/A 1008M.
 - c. Hot-Rolled Sheet and Strip: ASTM A 1011/A 1011M.

2.4 ENTRANCES

- A. Entrances: Comply with Section 084113 "Aluminum-Framed Entrances and Storefronts."

2.5 GLAZING

- A. Glazing: Comply with Section 088000 "Glazing."
- B. Glazing Gaskets: Manufacturer's standard sealed-corner pressure-glazing system of black, resilient elastomeric glazing gaskets, setting blocks, and shims or spacers.
- C. Glazing Sealants: As recommended by manufacturer.
- D. Sealants used inside the weatherproofing system shall have a VOC content of 250 g/L or less.
- E. Structural Glazing Sealants: ASTM C 1184, chemically curing silicone formulation that is compatible with system components with which it comes in contact, specifically formulated and tested for use as structural sealant and approved by structural-sealant manufacturer for use in curtain-wall assembly indicated.
 - 1. Color: <Insert color>.
- F. Weatherseal Sealants: ASTM C 920 for Type S; Grade NS; Class 25; Uses NT, G, A, and O; chemically curing silicone formulation that is compatible with structural sealant and other system components with which it comes in contact; recommended by structural-sealant, weatherseal-sealant, and structural-sealant-glazed curtain-wall manufacturers for this use.
 - 1. Color: Match structural sealant.

2.6 ACCESSORIES

- A. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding fasteners and accessories compatible with adjacent materials.
 - 1. Use self-locking devices where fasteners are subject to loosening or turning out from thermal and structural movements, wind loads, or vibration.
 - 2. Reinforce members as required to receive fastener threads.
 - 3. Use exposed fasteners with countersunk Phillips screw heads, finished to match framing system.
- B. Anchors: Three-way adjustable anchors with minimum adjustment of 1 inch (25.4 mm) that accommodate fabrication and installation tolerances in material and finish compatible with adjoining materials and recommended by manufacturer.
 - 1. Concrete and Masonry Inserts: Hot-dip galvanized cast-iron, malleable-iron, or steel inserts complying with ASTM A 123/A 123M or ASTM A 153/A 153M requirements.
- C. Concealed Flashing: Manufacturer's standard corrosion-resistant, nonstaining, nonbleeding flashing compatible with adjacent materials.
- D. 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.

2.7 FABRICATION

- A. Form or extrude aluminum shapes before finishing.
- B. Weld in concealed locations to greatest extent possible to minimize distortion or discoloration of finish. Remove weld spatter and welding oxides from exposed surfaces by descaling or grinding.
- C. 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 with ends coped or mitered.
 - 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 interior for vision glass and exterior for spandrel glazing or metal panels.
 - 6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.
 - 7. Components curved to indicated radii.
- D. Fabricate components to resist water penetration as follows:
 - 1. Internal guttering system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.
- E. Curtain-Wall Framing: Fabricate components for assembly using manufacturer's standard assembly method.
- F. Factory-Assembled Frame Units:
 - 1. Rigidly secure nonmovement joints.
 - 2. Prepare surfaces that are in contact structural sealant according to sealant manufacturer's written instructions to ensure compatibility and adhesion.
 - 3. Preparation includes, but is not limited to, cleaning and priming surfaces.
 - 4. Seal joints watertight unless otherwise indicated.
 - 5. Install glazing to comply with requirements in Section 088000 "Glazing."
- G. After fabrication, clearly mark components to identify their locations in Project according to Shop Drawings.

2.8 ALUMINUM FINISHES

- A. Clear Anodic Finish: AAMA 611, AA-M12C22A41, Class I, 0.018 mm or thicker.
- B. Color Anodic Finish: AAMA 611, AA-M12C22A42/A44, Class I, 0.018 mm or thicker.
 - 1. Color: <Insert color>.
- C. High-Performance Organic Finish: Three-coat fluoropolymer finish complying with AAMA 2605 and containing not less than 70 percent PVDF resin by weight in both color coat and clear

topcoat. Prepare, pretreat, and apply coating to exposed metal surfaces to comply with coating and resin manufacturers' written instructions.

1. Color and Gloss: **<Insert color and gloss>**.

2.9 SOURCE QUALITY CONTROL

- A. Structural Sealant: Perform quality-control procedures complying with ASTM C 1401 recommendations including, but not limited to, assembly material qualification procedures, sealant testing, and assembly fabrication reviews and checks.

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.

3.2 PREPARATION

- A. Prepare surfaces that will contact structural sealant according to sealant manufacturer's written instructions to ensure compatibility and adhesion. Preparation includes, but is not limited to, cleaning and priming surfaces.

3.3 INSTALLATION

- A. General:
 1. Comply with manufacturer's written instructions.
 2. Do not install damaged components.
 3. Fit joints to produce hairline joints free of burrs and distortion.
 4. Rigidly secure nonmovement joints.
 5. Install anchors with separators and isolators to prevent metal corrosion and electrolytic deterioration and to prevent impeding movement of moving joints.
 6. Where welding is required, weld components in concealed locations to minimize distortion or discoloration of finish. Protect glazing surfaces from welding.
 7. Seal joints watertight unless otherwise indicated.
- B. Metal Protection:
 1. Where aluminum is in contact with dissimilar metals, protect against galvanic action by painting contact surfaces with primer, applying sealant or tape, or installing nonconductive spacers as recommended by manufacturer for this purpose.
 2. Where aluminum is in contact concrete or masonry, protect against corrosion by painting contact surfaces with bituminous paint.
- C. Install components to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum curtain wall to exterior.

- D. Install components plumb and true in alignment with established lines and grades.
- E. Install glazing as specified in Section 088000 "Glazing."
 - 1. Prepare surfaces that will contact structural sealant according to sealant manufacturer's written instructions to ensure compatibility and adhesion. Preparation includes, but is not limited to, cleaning and priming surfaces.
- F. Install weatherseal sealant according to Section 079200 "Joint Sealants" and according to sealant manufacturer's written instructions to produce weatherproof joints. Install joint filler behind sealant as recommended by sealant manufacturer.

3.4 ERECTION TOLERANCES

- A. Erection Tolerances: Install glazed aluminum curtain walls to comply with the following maximum tolerances:
 - 1. Plumb: 1/8 inch in 10 feet (3.2 mm in 3 m); 1/4 inch in 40 feet (6.35 mm in 12.2 m).
 - 2. Level: 1/8 inch in 20 feet (3.2 mm in 6 m); 1/4 inch in 40 feet (6.35 mm in 12.2 m).
 - 3. Alignment:
 - a. Where surfaces abut in line or are separated by reveal or protruding element up to 1/2 inch (12.7 mm) wide, limit offset from true alignment to 1/16 inch (1.6 mm).
 - b. Where surfaces are separated by reveal or protruding element from 1/2 to 1 inch (12.7 to 25.4 mm) wide, limit offset from true alignment to 1/8 inch (3.2 mm).
 - c. Where surfaces are separated by reveal or protruding element of 1 inch (25.4 mm) wide or more, limit offset from true alignment to 1/4 inch (6 mm).
 - 4. Location: Limit variation from plane to 1/8 inch in 12 feet (3.2 mm in 3.6 m); 1/2 inch (12.7 mm) over total length.

3.5 FIELD QUALITY CONTROL

- A. Testing Agency: Owner will engage a qualified testing agency to perform tests and inspections.
- B. Test Area: Perform tests on two bays wide by two stories.
- C. Field Quality-Control Testing: Perform the following test on representative areas of glazed aluminum curtain walls.
 - 1. Perform AAMA 501.3 ("static") test.
 - a. Perform testing before covering up of inside face of wall assembly.
 - 2. Water-Spray Test: Before installation of interior finishes has begun, areas designated by Architect shall be tested according to AAMA 501.2 and shall not evidence water penetration.
 - a. Perform a minimum of two tests in areas as directed by Architect.
 - 3. Air Infiltration: ASTM E 783 at 1.5 times the rate specified for laboratory testing in "Performance Requirements" Article but not more than 0.09 cfm/sq. ft. (0.45 L/s per sq. m) at a static-air-pressure differential of 1.57 lbf/sq. ft. (75 Pa).

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ISSUED: 03/29/2017

- a. Perform a minimum of two tests in areas as directed by Architect.
- D. Structural-Sealant Adhesion: Test structural sealant according to recommendations in ASTM C 1401, Destructive Test Method A, "Hand Pull Tab (Destructive)," Appendix X2.
 - 1. Test a minimum of <Insert number> areas on each building facade.
 - 2. Repair installation areas damaged by testing.
- E. Glazed aluminum curtain walls will be considered defective if they do not pass tests and inspections.
- F. Prepare test and inspection reports.

END OF SECTION 08 4413