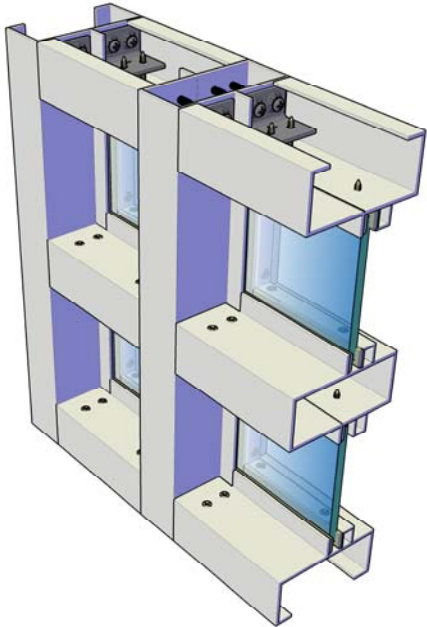
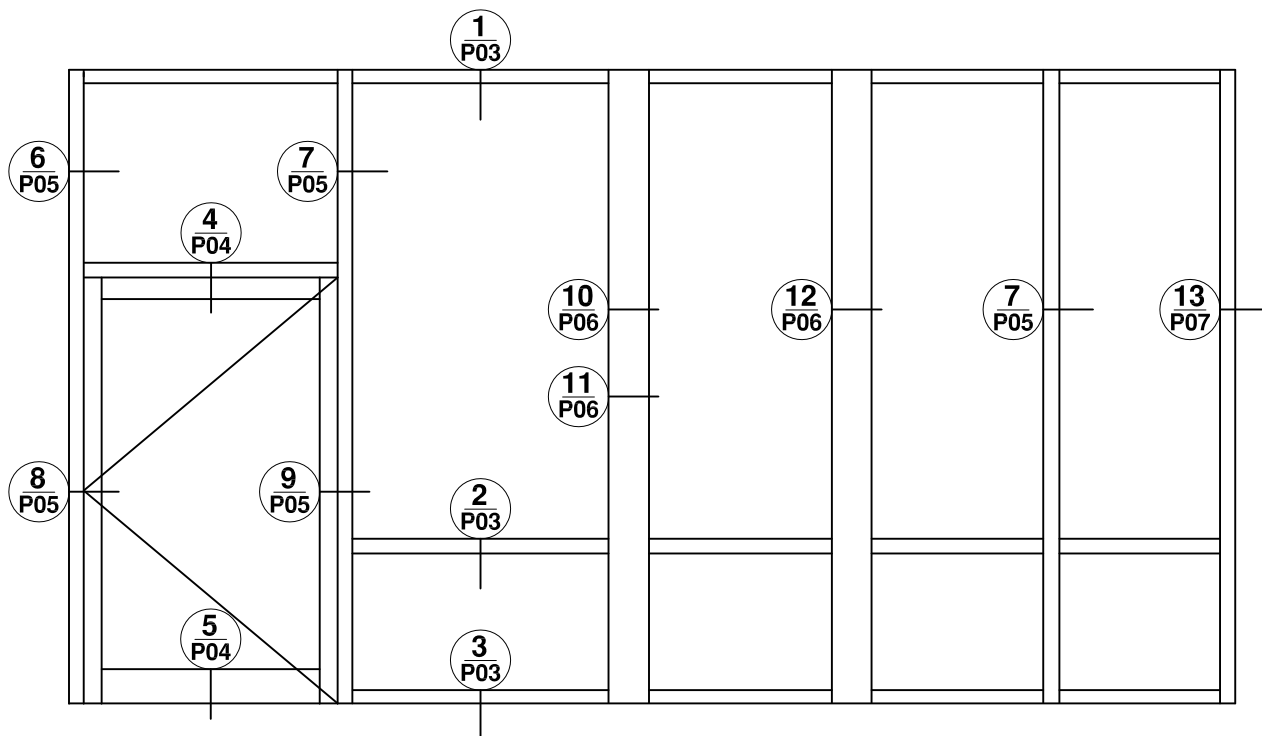


TECHNICAL DATA

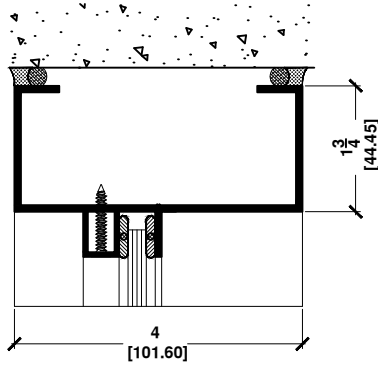
| | | |
|------------------------------|--|---|
| <u>DESCRIPTION:</u> | NON-THERMALLY BROKEN GLAZED SYSTEM. PROFILE DIM. 1-3/4" x 4" (44.5 x 101.6mm) WITH 5/8" (15.9mm) FIN. |  |
| <u>COMPATIBILITY:</u> | DESIGNED TO SUIT ALL STANDARD DOORS AND DOOR HARDWARE. | |
| <u>FINISH:</u> | MOST PROFILES ARE STOCKED IN #17 CLEAR AND #40 BRONZE ANODIZED. OTHER ANODIZED AND PAINT FINISHES ARE AVAILABLE UPON REQUEST. | |
| <u>STOCK LENGTH:</u> | 24'-2" (7.37 METERS). | |
| <u>ASSEMBLY:</u> | DESIGNED FOR BRACKET ASSEMBLY. | |
| <u>STRENGTH:</u> | REFER TO WIND LOAD CHARTS FOR MAXIMUM ALLOWABLE SPANS. | |
| <u>ANCHORING:</u> | REFER TO FABRICATION AND INSTALLATION MANUAL. | |
| <u>GLAZING:</u> | 400 SERIES IS DESIGNED FOR INTERIOR/EXTERIOR GLAZING APPLICATIONS AND WILL ACCEPT SINGLE, SEALED UNIT OR LAMINATED COMBINATIONS UP TO A MAXIMUM THICKNESS OF 1-1/4" (32mm). GLASS STOP POSITIONS ARE NOT PRE-DRILLED. | |



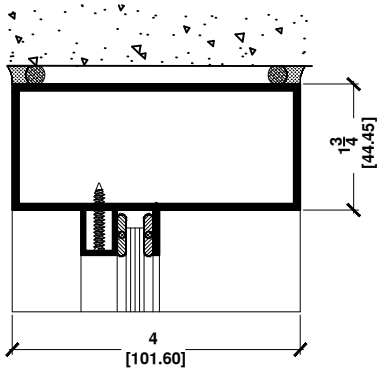
Elevation



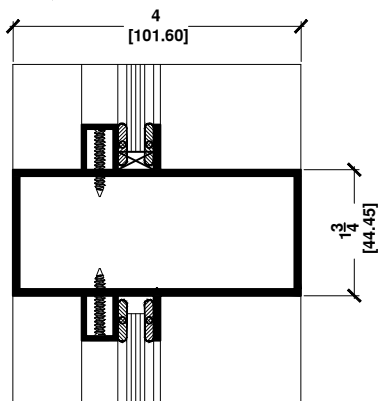
Plan



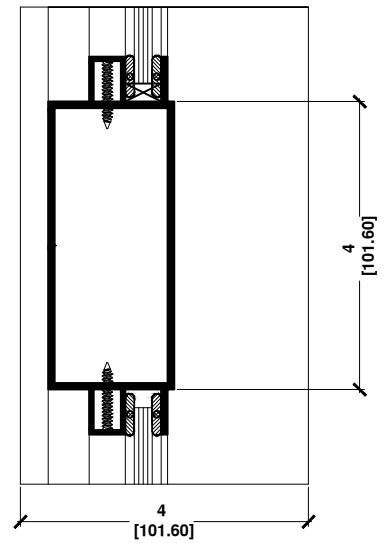
1 HEAD
FIXED GLASS
O/B ONE FIN TUBE



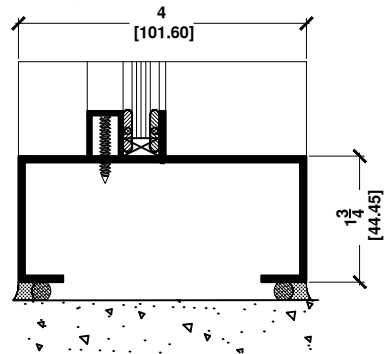
1a HEAD
FIXED GLASS
C/B ONE FIN TUBE



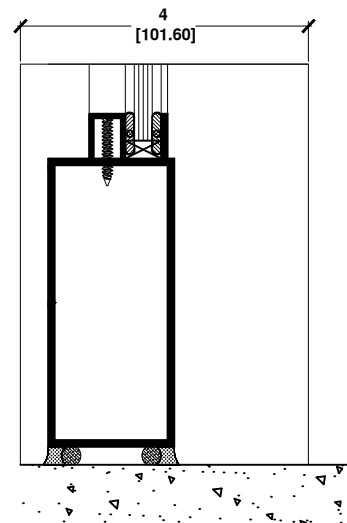
2 HOR. TUBE
FIXED GLASS - FIXED GLASS
TWO FIN TUBE



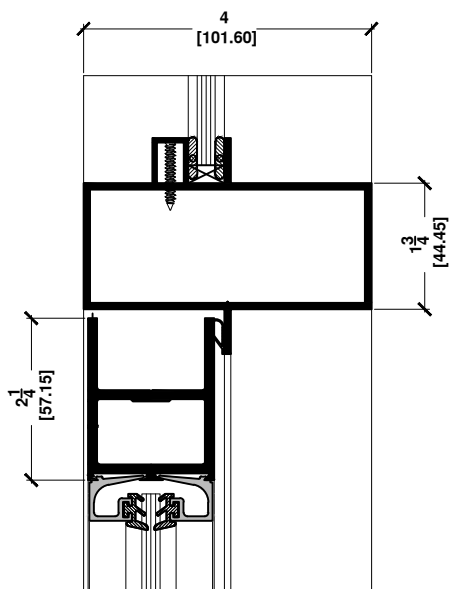
2a HOR. TUBE
FIXED GLASS - FIXED GLASS
TWO FIN TUBE



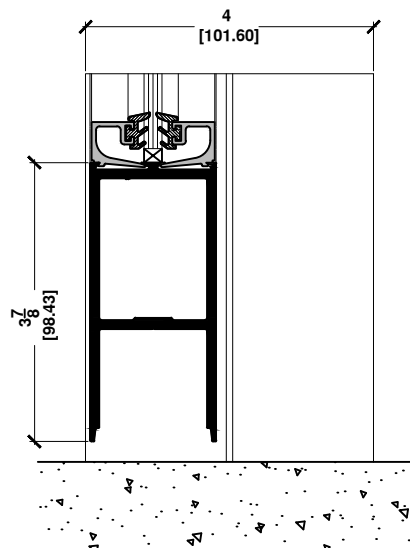
3 SILL
FIXED GLASS
O/B ONE FIN TUBE



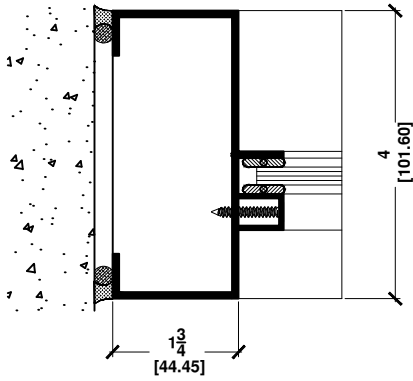
3a SILL
FIXED GLASS
ONE FIN TUBE



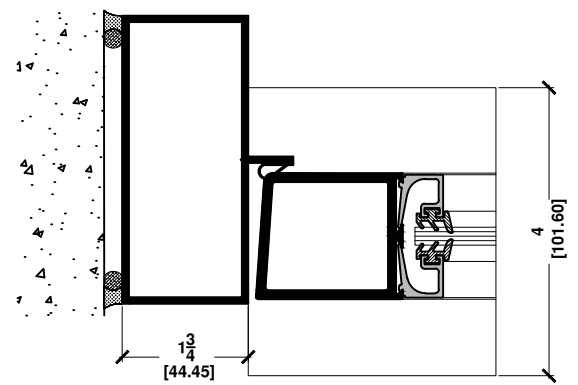
4 HOR. TUBE
FIXED GLASS/SERIES 175 DOOR
TWO FIN TUBE



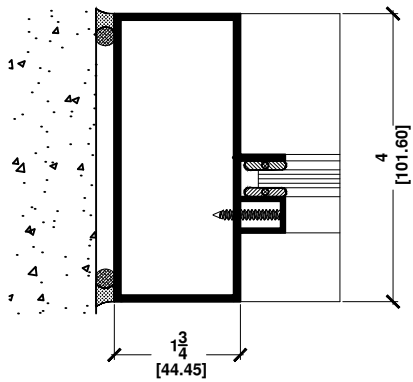
5 SERIES 175 DOOR
W/O THRESHOLD



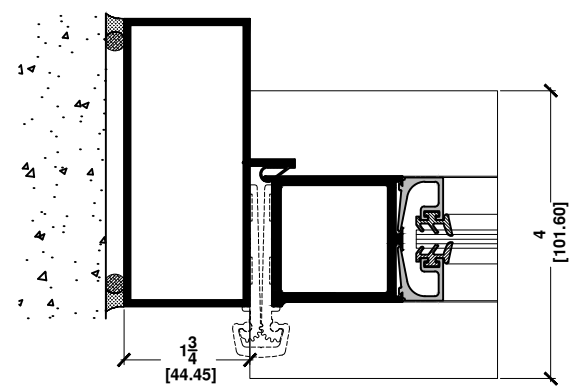
6 JAMB
FIXED GLASS
O/B ONE FIN TUBE



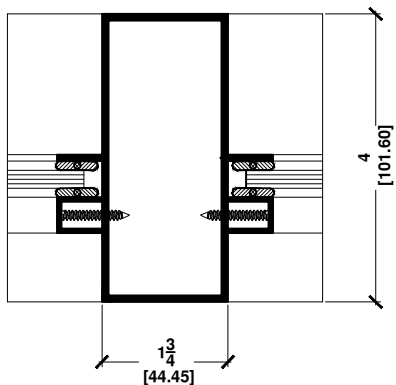
8 JAMB
SERIES 175 DOOR
C/B ONE FIN TUBE



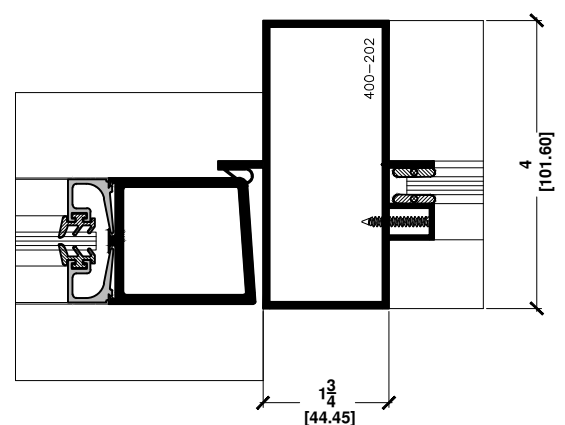
6a JAMB
FIXED GLASS
C/B ONE FIN TUBE



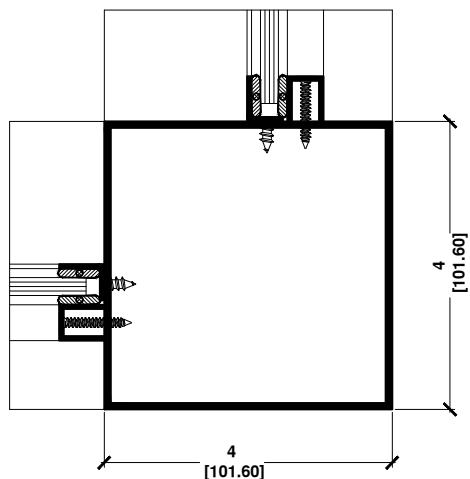
8a JAMB
SERIES 175 DOOR
C/B ONE FIN TUBE



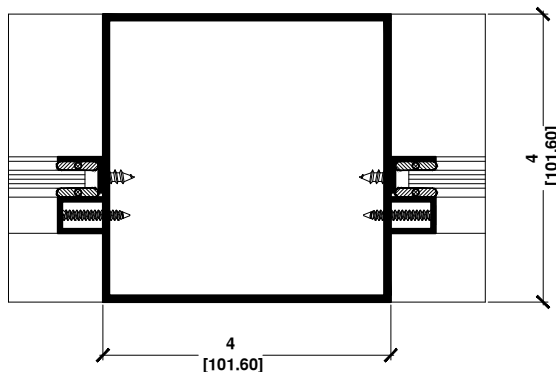
7 VERT. TUBE
FIXED GLASS - FIXED GLASS
TWO FIN TUBE



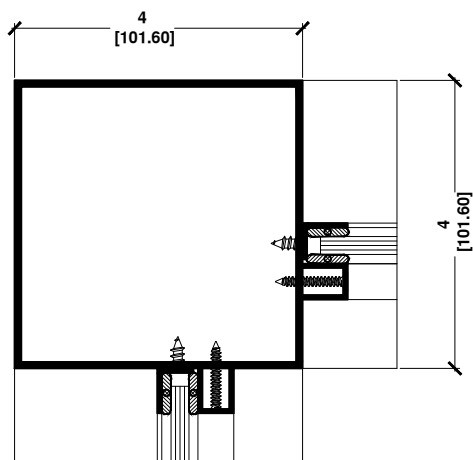
9 VERT. TUBE
SERIES 175 DOOR - FIXED GLASS
TWO FIN TUBE



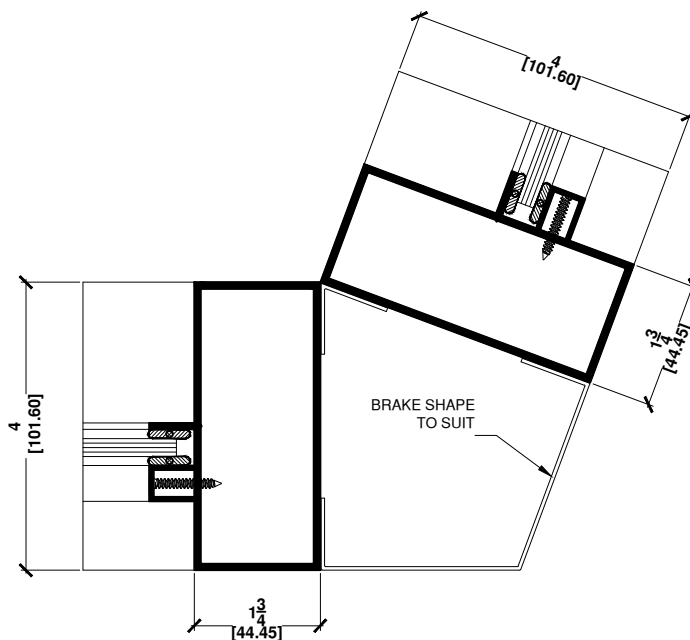
10 PLAIN TUBE
FIXED GLASS - FIXED GLASS
90° OUTSIDE CORNER



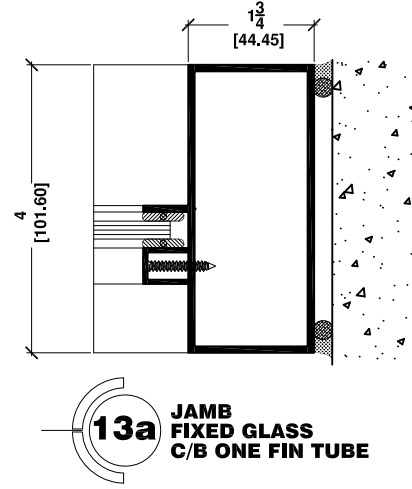
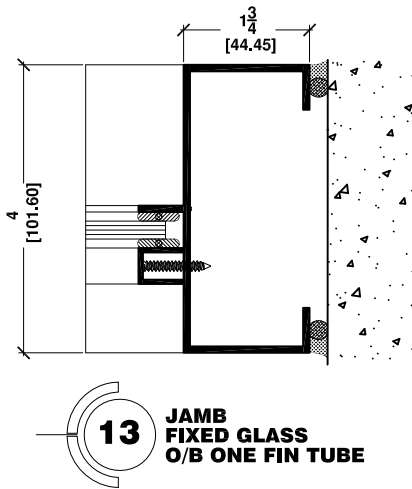
12 PLAIN TUBE
FIXED GLASS - FIXED GLASS



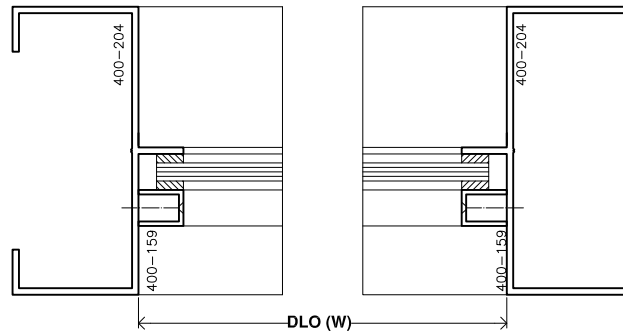
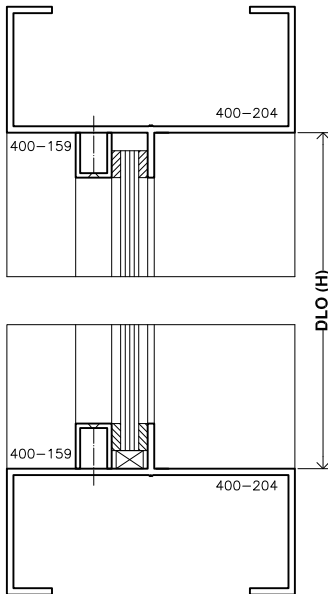
11 PLAIN TUBE
FIXED GLASS - FIXED GLASS
90° INSIDE CORNER



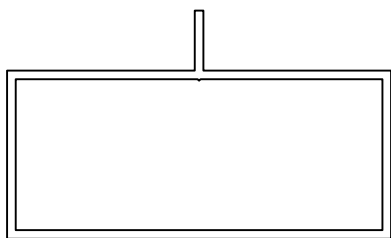
12a VERT. TUBE
FIXED GLASS - FIXED GLASS
110° OUTSIDE CORNER



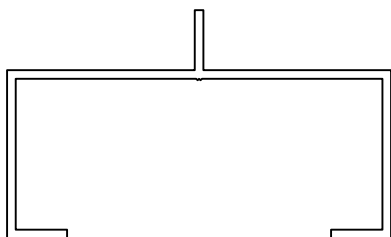
GLASS CALCULATION



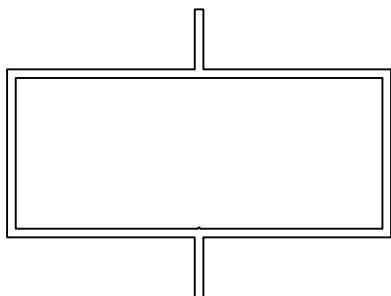
$\frac{1}{4}" (6.0\text{mm})$ Glass (W) = $\text{DLO(W)} - \frac{1}{2}" (12.7\text{mm})$
 $1" (25.4\text{mm})$ Glass (H) = $\text{DLO(H)} - \frac{1}{2}" (12.7\text{mm})$
 $1\frac{1}{4}" (32.0\text{mm})$



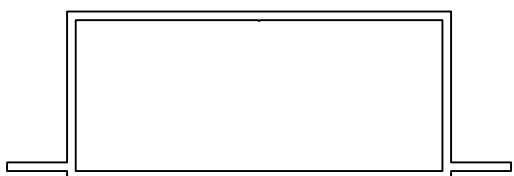
PART #: 400-201
CLOSED BACK ONE FIN
1-3/4" X 4"
(44.5mm X 101.6mm)



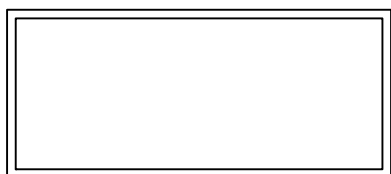
PART #: 400-204
OPEN BACK ONE FIN
1-3/4" X 4"
(44.5mm X 101.6mm)



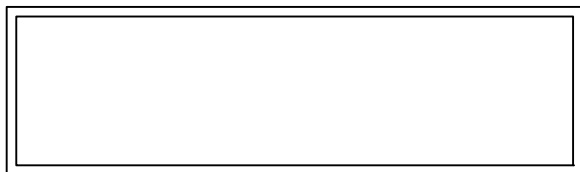
PART #: 400-202
TWO FIN TUBE
1-3/4" X 4"
(44.5mm X 101.6mm)



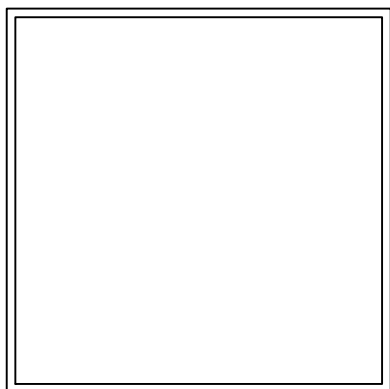
PART #: 400-206
TWO FIN TUBE
4" X 1-3/4"
(101.6mm X 44.5mm)



PART #: 400-200
PLAIN TUBE
1-3/4" X 4"
(44.5mm X 101.6mm)



PART #: 400-096
PLAIN TUBE
1-3/4" X 6"
(44.5mm X 152.4mm)



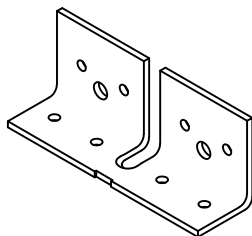
PART #: 400-205
SQUARE TUBE
4" X 4"
(101.6mm X 101.6mm)



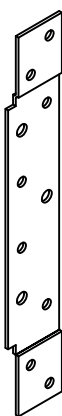
PART #: 400-159
CHANNEL STOP
5/8" X 1/2"
(15.9mm X 12.7mm)







PART #: 400-160
ANGLE STOP
5/8" X 1/2"
(15.9mm X 12.7mm)





PART #: 400-901
ASSEMBLY STEEL BRACKET
TO ASSEMBLE HORIZONTAL
TO VERTICAL



PART #: 9000-127
UNIVERSAL BACK-UP
PLATE FOR BUTT HINGE
USE # 12-24 x1/2" FMS

| DRAWING | DESCRIPTION | APPLICATION | QTY/ JOINT |
|---|--|--|---------------|
|  | PART #:9902-400 #10 X 1/2" P.H. SCREW | TO FASTEN HORIZONTAL MULLION TO JAMB | 4 |
|  | PART #:9902-400 #10 X 1/2" P.H. SCREW | TO FASTEN HORIZONTAL MULLION TO BRACKET | 2 |
|  | PART #:9902-600 #10-24 x 5/8" FHM SCREW AVAILABLE IN CLEAR OR BRONZE | TO FASTEN HORIZONTAL MULLION TO BRACKET | 4 |
|  | PART #:9902-102 #6 X 1" F.H. SCREW. AVAILABLE IN CLEAR OR BRONZE | TO FASTEN STOP CHANNEL TO MULLION | AS REQUIRED |

| DRAWING | DESCRIPTION |
|--|--|
|  | PART #: 9904-001 POLYSHIM TAPE .150 X .375 - .125" USE FOR GLAZING |
|  | PART #: 9903-128-00 $\frac{1}{4}$ " X $\frac{1}{2}$ " SEAL USE FOR DOOR SEAL |

400 SERIES FRAMING SYSTEM SPECIFICATION

PART 1 - GENERAL

1.1 Work Included

Furnish labour, materials and services for the complete fabrication, assembly and installation of Series 400 Framing system manufactured by Commdoor Aluminum. Work to include all necessary accessories, anchors and sealants as required based on the purchase agreement.

1.2 Work Excluded

Structural steel, wood blocking or framing, interior trims, concrete masonry, final cleaning, protection, related work specified elsewhere, convactor covers and trims and ceiling trims.

1.3 Quality Assurance

The framing system supplied under this specification is based upon Series 400 manufactured by Commdoor Aluminum.

1.4 Shop Drawings

All work of this section shall be executed in strict accordance with approved shop drawings.

1.5 Warranty

The work of this section shall be guaranteed against defects of materials and workmanship for a period of one year from date of certificate of substantial completion.

PART 2 - PRODUCTS

2.1 Material

2.1.1 Aluminum Extrusion

All extruded aluminum sections to be 6063-T6 alloy or equivalent.

2.1.2 Glazing Material

Macro-polyisobutylene glazing tape with a continuous built in shim; highly adhesive and elastic.

2.1.3 Fasteners

Fasteners shall be zinc plated.

2.2 Fabrication

Fabrication will be carried out according to the approved shop drawings. All joints will be assembled tight and using manufactures provided assembly brackets to maintain the product design performance.

2.3 Finish

2.3.1 Anodize

Anodic Oxide Treatments are to be processed in accordance with AAMA designations.

M12C22A31 class II designation is for #17 Clear anodized finish (0.0004). M12C22A41 class I designation is for #14 Clear Anodized finish (0.0007) and colour finishes such as #26 light bronze, #40 bronze and #29 black.

2.3.2 Paint

Thermosetting Acrylic Enamel coating are to be applied in accordance with AAMA 603.8. Specify colour and type from PPG. Standard charts.

2.3.3 Fluoropolymer paint Coating

Based on Kynar 500 Resins are to be applied in accordance AAMA 605.2. Specify colour from Valspar current chart.

PART 3 - EXECUTION

3.1 Protection

Aluminum shall be isolated from concrete, mortar, plaster and dissimilar materials with a coating of Bituminous paint.

Exposed aluminum surface shall be protected from long term contamination of mortar, concrete, paint, mud, etc.

Doors and door frames shall be protected from impact damage by wood sheathing and plastic wraps.

3.2 Installation

Commdoor Aluminum products to be installed according to manufacturers instructions and in conjunction with approved shop drawings. The work shall be performed by qualified skilled personnel ensuring proper equipment provided in order to expedite the project in an efficient professional manner.

3.3 Cleaning

Interim and final cleaning shall be performed in accordance with the general conditions listing methods outlined in AAMA 609 & 610-02 (2002)