

**I. GENERAL****Scope**

The Doors shall be **100 SERIES** - non-Insulated, as manufactured by **Aluminex**. Furnish materials, labour, plant, equipment, related items and services necessary for fabrication, supply and installation of Aluminum Doors and their Framing as shown on the drawings, listed in the door schedule, and required by job conditions and specified herein. (Note: Aluminum framing, glass, sealants, and others closely related items, should be included wherever possible).

**Work Not Included**

Structural support for the door framing, wood-liner, interior or exterior J-mouldings, closures, trim, caulking as well as flashings unless specifically detailed and called out as such.  
(Specifier List of Other Exclusions).

**Related Work Specified Elsewhere**  
(Specifier List)**Submittals - Shop Drawings**

Prior to fabrication submit shop drawings showing door & frame elevations, all required details, door & frame dimensions, caulking joints with their sizes, and specifications for the system, materials and hardware, as well as necessary installation's requirements.

**Submittals - Samples**

Before any work is fabricated, all requested representative and properly labelled samples, including specified products with their finishes, shall be submitted to the Architect for his approval.

**II. PRODUCTS****Door System**

- ° Door System shall be **100 SERIES Trimline** for single glass (sealed insulating glass units-Specifier selection) as manufactured by **Aluminex**.
- ° The door aluminum profiles nominal dimensions shall be as follows:
  - frame metal thickness 3mm / 0.12" minimum,
  - glazing stop metal thickness 1.3 mm / 0.05" minimum,
  - depth of the frame 45 mm / 1.75",
  - face width of stiles 51 mm / 2",
  - face width of rails 76 mm / 3", (optional: 152 mm / 6" for the bottom rail).
- ° Glass retention, as for dry glazing method, shall be achieved by extruded aluminum glazing stop profiles.
- ° Whenever substitute systems and/or products are considered, supporting data must be submitted ten (10) days prior to bid date to allow for valid comparison.

**Performance**

- ° Structural Load Capacity minimum requirements shall not be less than 850 N / 190 lbs when tested by the Dual Moment Load, where passing a 45° lever arm rotation angle is considered as the mock-up failure.
- ° Air infiltration (applicable to single acting offset pivot or butt hung doors). ASTM E 283 Air Infiltration Test Standard is an acceptable alternative. The permissible rate of air infiltration, for 900 mm x 2100 mm / 3' x 7' and 1800mm x 2100mm / 6' x 7' standard size doors c/w their frame, shall not exceed 8.35 (16.7) m<sup>3</sup>/h per 1m / 4.9 (9.8) ft<sup>3</sup>/min per 1ft of the perimeter joint, of the single and double doors respectively, at 75 Pa / 1.6 PSF differential air pressure.

**Materials**

- ° Extruded aluminum shall be AA 6063 T5, Fy = 110 MPa / 16 KSI, alloy and temper.
- ° Any defects impairing strength, durability or appearance are not acceptable.
- ° Sufficient strength and size fasteners shall be made of corrosion-resistant and compatible material such as cadmium or zinc plated carbon steel, stainless steel or aluminum, to prevent any galvanic action (electrolytic corrosion).

- ° The minimum standard weathering shall be (pile cloth with a vinyl fin - the minimum for Specifier selection) or an extruded thermoplastic elastomer tubular profile with a semi-rigid polymeric backing key.
- ° The optional weathering at the bottom rail shall be a sweep blade type .
- ° Glazing shall utilize extruded dense Neoprene, EPDM, or other equal material, wedge or spline gaskets. Gasket profiles shall be designed and sized to work with the system and properly serve glazing rabbet assembly.
- ° Setting of glass must be properly designed, sized, placed, and compatible with the insulating glass sealant.

**Finish**

All exposed surfaces shall be free from defects, scratches and serious blemishes. Aluminum shall receive one of the following available finishes specified by the Architect:

- Standard commercial clear anodic coating integral colour (02),
- Standard commercial bronze hardcolour anodic coating (04),
- Optional anodic coating finishes are champagne (03) and black (05),
- Standard baked enamel paint in white and rideau-brown colours,
- Other paint qualities and colours in baked enamel are available upon request.

**Hardware**

The door hardware shall be as supplied and/or installed by Aluminex and shall include the following (Specifier selection):

- Offset pivots / butt hinges / centre pivots
- Adams Rite M.S. Lock with cylinder & thumb-turn
- Flush-bolt for inactive leaf
- Door closures - Dorma overhead exposed, overhead or floor concealed
- Standard 150 mm / 6" extruded aluminum threshold
- Tubular 12" Off-Set "D" Push/Pull Back to Back Mount - Aluminex standard
- Optional hardware - available upon request.

All applicable hardware and templates shall be furnished by the manufacturer for the door installation.

**III. EXECUTION****Construction & Fabrication**

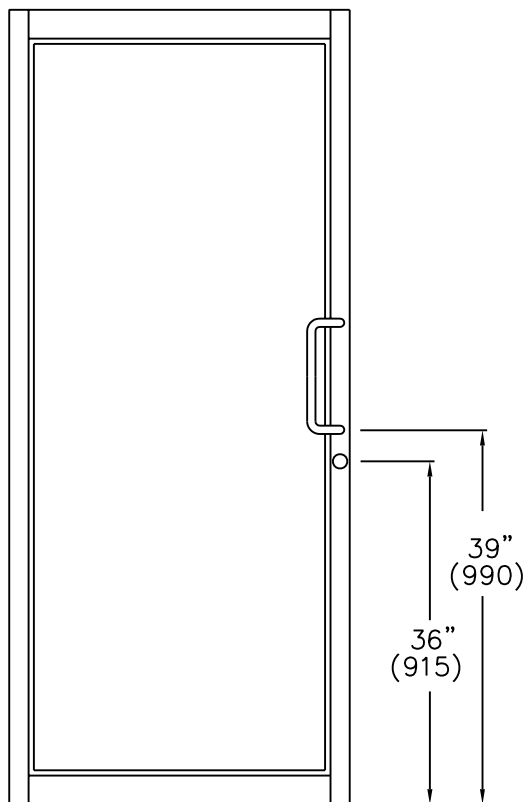
- ° Door assembly shall provide accurately fit tight hairline joints only.
- ° All corner joinery shall utilize a 5 mm / 0.19" mm. plated steel reinforcing - assembly bracket, and shall be fastened by means of tension (torque to 12 Nm / 100 lb/in) applied to a 10mm / 0.375" D-UNC Gr.5 mm. plated steel rod to allow for a permanent true and square set of the frame members. Welded joints are also available.
- ° Specified hardware shall be connected accurately to aluminum framing by anti-corrosive fasteners as per manufacturers specifications.

**Installation**

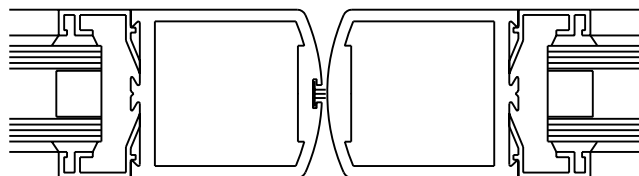
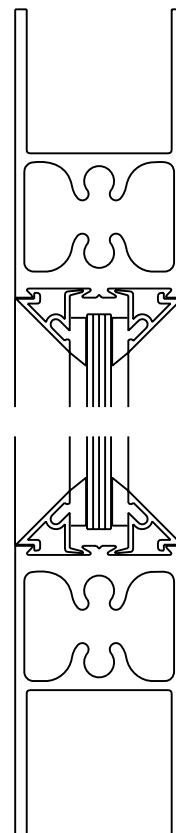
- ° Doors shall be installed by an experienced crew, in correct locations as shown on drawings, in prepared openings, set level, plumb, square and aligned with other work, in accordance with manufacturer's instructions, approved shop drawings and published standards.
- ° All items of the operating hardware, checked and readjusted where required, shall be left in a ready for use condition.
- ° All perimeter joints shall be sealed and caulked with approved sealant materials to ensure a weather-tight installation.

**Protection and Cleaning**

- ° All work shall be protected against damage during and after installation.
- ° After installation all exposed surfaces shall be cleaned of all contaminants.
- ° The General Contractor is responsible for System protection during construction and final cleaning.

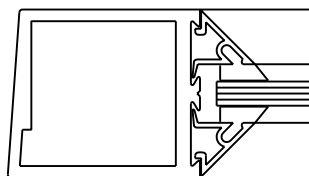


- The "100" series Door is the most popular commercial door, offering economy along with strength, quality and performance.
- The door also accommodates most standard hardware available.
- Optional hardware such as concealed closers and panic hardware are available upon request.
- Optional bottom and mid-rails are available in various dimensions, as illustrated on pages A-7.1 & A-7.2
- Accommodates both single and double glazing.
- Compatible with all Aluminex framing systems, thermally and non-thermally broken.
- Available in both clear and bronze anodized finish, also an unlimited variety of the baked enamel colours.

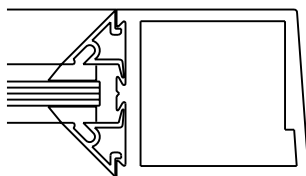


PAIR MEETING STILES

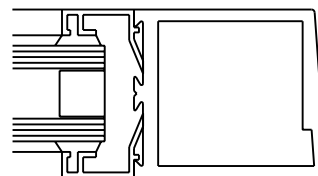
VERTICAL STILE – 2" (50.8)  
 TOP RAIL – 3" (76.2)  
 BOTTOM RAIL – 3" (76.2)  
 DOOR THICKNESS – 1.75" (44.5)  
 A5 TYPE (TYP) DOOR HANDLE



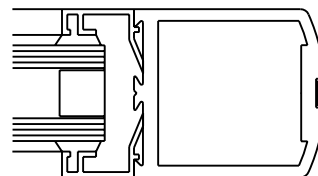
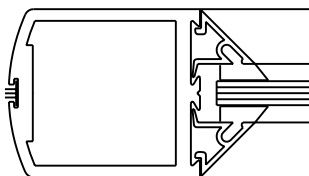
SINGLE ACTING



DOUBLE ACTING



DOUBLE GLAZED OPTION



DOUBLE GLAZED OPTION