SECTION 08 46 00

WINDOW WALL ASSEMBLIES

**Graham Architectural Products**

**Series W4500 Window Wall**

*This suggested guide specification has been developed using the Construction Specifications Institute (CSI) “Manual of Practice,” including the recommendations for the CSI 3 Part Section Format and the CSI Page Format.*

**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: Graham Architectural Aluminum Window Wall Systems, including sill starter, head receptor, slab cover, misc. accessories, shims and anchors and perimeter sealing of window wall framing.

1. Types of Graham Architectural Aluminum Window Wall include:

a. W4500 Window Wall System: 4-1/2”, inside glazed and outside glazed system.

B. Related Sections:

1. 07 27 00 “Air Barriers”

2. 07 92 00 “Joint Sealants”

3. 08 11 16 “Aluminum Doors and Frames”

4. 08 51 13 “Aluminum Windows”

5. 08 80 00 “Glazing”

**1.3 Definitions**

A. Definitions: For fenestration industry standard terminology and definitions refer to American Architectural Manufactures 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 GRAHAM REPRESENTATIVE CONCERNING SPECIFIC PROJECT PERFORMANCE REQUIREMENTS.*

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

1. Glazed aluminum window 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 window 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 Window Wall system; include anchorage, capable of withstanding wind load design pressures of 30.80 lbs./sq. ft. or 1475 Pa, inward and 30.80 lbs./sq. ft. or 1475 Pa, outward.

D. Air Infiltration: The test specimen shall be tested in accordance with ASTM E 283. Air infiltration rate shall not exceed 0.10 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 minimum static air pressure differential of 12 psf (718 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 a minimum static air pressure differential of 12 psf (575 Pa) as defined in AAMA 501.

H. Uniform Load: A static air design load of 30.80 psf (1475 Pa) shall be applied in the positive and negative direction in accordance with ASTM E 330/E 330M. When testing 120” by 99” size. 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.

1. Thermal Transmittance (U-factor): When tested to AAMA Specification 1503, AAMA Specification 507 or NFCR 100 the thermal transmittance (U-factor) shall not be more than;

1. 1-1/4" Cardinal E366 low-e insulating glass with argon and warm edge spacer.

a. U-Factor not more than 0.35 BTU/hr/ft2 /°F. per AAMA 1503 or NFRC 100 when using project specified glass.

J. Condensation Resistance Test (CRF): Provide aluminum window wall tested for thermal performance according to AAMA 1503, the condensation resistance factor (CRF) shall not be less than;

1. 1-1/4" Cardinal E366 low-e insulating glass with argon and warm edge spacer.

a. CRF not less than 70.

K. Sound Transmission Class (STC) and Outdoor-Indoor Transmission Class (OITC): When tested in accordance with AAMA Specification 1801, the STC and OITC shall not be less than;

1. 1-1/4" insulating glass made with exterior 1/4" annealed glass, 3/4" spacer, and interior 1/4" annealed glass.

a. STC not less than 33; OITC not less than 26.

**1.5 Submittals**

A. Product Data: For each type of product indicated. Include construction details, material descriptions, dimensions of individual components and profiles, and finishes.

B. Shop Drawings: For glazed aluminum window 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 window walls, indicating compliance with performance requirements.

F. Fabrication Sample: Of each vertical-to-horizontal intersection of aluminum-framed window wall systems, made from 12" (300 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 window walls that meet or exceed performance requirements.

C. Source Limitations: Obtain aluminum window 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 window 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 window 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 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.”*

**2.1 Manufacturers**

A. Basis-of-Design Product:

1. Graham Architectural Products

2. W4500 Window Wall

3. Frame depth: 4-1/2”, inside glazed or outside glazed system.

*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 GRAHAM ARCHITECTURAL FOR RECOMMENDATIONS ON ALTERNATE MANUFACTURERS AND PRODUCTS MEETING THE DESIGN CRITERIA AND PROJECT REQUIREMENTS. GRAHAM 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.*

B. Subject to compliance with requirements, provide a comparable product by the following:

1. Manufacturer: (\_\_\_\_\_\_\_\_\_\_)

2. Series: (\_\_\_\_\_\_\_\_\_\_)

3. Profile dimension: (\_\_\_\_\_\_\_\_\_\_)

C. Substitutions: Refer to Substitutions Section for procedures and submission requirements.

1. Pre-Contract (Bidding Period) Substitutions: Submit written requests ten (10) days prior to bid date.

2. Post-Contract (Construction Period) Substitutions: Submit written request in order to avoid window wall installation and construction delays.

3. Product Literature and Drawings: Submit product literature and drawings modified to suit specific project requirements and job conditions.

4. Certificates: Submit certificate(s) certifying substitute manufacturer (1) attesting to adherence to specification requirements for window wall system performance criteria, and (2) has been engaged in the design, manufacturer and fabrication of aluminum window walls for a period of not less than ten (10) years. (Company Name).

5. Test Reports: Submit test reports verifying compliance with each test requirement required by the project.

6. Samples: Provide samples of typical product sections and finish samples in manufacturer's standard sizes.

D. Substitution Acceptance: Acceptance will be in written form, either as an addendum or modification, and documented by a formal change order signed by the Owner and Contractor.

**2.2 Materials**

A. Aluminum Extrusions: Alloy and temper recommended by glazed aluminum window wall manufacturer for strength, corrosion resistance, and application of required finish and each framing member shall have a wall thickness sufficient to meet the specified structural requirements and complying with ASTM B 221: 6063-T6 alloy and temper.

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 wall 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. 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.

F. Sealant: For sealants required within fabricated window wall system, provide permanently elastic, non-shrinking, and non-migrating type recommended by sealant manufacturer for joint size and movement.

G. Thermal Barrier: Provide a continuously extruded, multi-directional 25% glass fiber reinforced 6/6 polyamide nylon (Thermal Strut). Aluminum window framing members separated with a locking mechanical connection to the Thermal Strut by properly knurling the aluminum cavity and crimping the Thermal Strut into place to create a composite thermal barrier assembly. Structural performance values of the Thermal Barrier assembly to meet specific product/project design criteria or at a minimum certified testing criteria and procedures as described by the AAMA TIR-A8 performance standards. Other thermal barrier assemblies such as rolled-in PVC, single directional glass fiber-reinforced polyamides, or pour-and-debridged polyurethane systems will not be accepted.

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

**2.3 Window 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.

1. Glazing System: 4 sided captured.

2. Glazing Plane: Front.

B. Glass: 1-1/4" insulating glass option.

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

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

E. Fasteners and Accessories: Manufacturer's standard corrosion-resistant, non-staining, non-bleeding 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. Packing, 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 window wall material and components to avoid damage. Protect window 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. System: Inside glazed or outside glazed system with 1-1/4" 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. Glazing Sealants: As recommended by sealant manufacturer for joint type.

**2.5 Operable Units**

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

**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 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 exterior (on exterior glazed version).

6. Fasteners, anchors, and connection devices that are concealed from view to greatest extent possible.

7. Internal guttering system or other means to drain water passing joints, condensation occurring within framing members, and moisture migrating within glazed aluminum window wall to exterior.

8. Double barrier design with primary air and vapor barrier at interior side of glazed aluminum window wall and secondary seal weeped and vented to exterior.

C. Window Wall Framing: Fabricate components for assembly using screw spline 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 Finishes**

*EDITOR NOTE: SELECT BELOW FINISH AND COLOR FROM GRAHAM’S STANDARD COLORS. CUSTOM COLORS ARE AVAILABLE UPON REQUEST. THE EXTERIOR AND INTERIOR OF THE WINDOW WALL CAN BE A DIFFERENT FINISH AND/OR COLOR. FOR DUAL FINISH, RETAIN BOTH FINISHES BELOW AND ADD “EXTERIOR” AND “INTERIOR” BEFORE THE “COLOR” NAME.*

A. Shop Finishing:

1. AA-M10C22A44, AAMA 611, Architectural Class I Color Anodic Coating (Color: [Light Bronze] [Medium Bronze] [Dark Bronze] [Black]).

2. AA-M10C22A41, AAMA 611, Architectural Class I Clear Anodic Coating.

3. AA-M10C22A31, AAMA 611, Architectural Class II Clear Anodic Coating.

4. Provide manufacturer’s standard acrylic or polyester, baked-on, electrostatically applied enamel coating of manufacturer’s standard [custom] colors as selected by the Architect, applied over manufacturer’s standard substrate preparation including cleaning, degreasing, and chromate conversion coating. Finish shall meet or exceed AAMA 2603. (Color \_\_\_\_\_\_\_\_\_\_).

5. Provide manufacturer’s standard 2 coat 50% Fluoropolymer or Silicone Polyester, baked on, electrostatically applied enamel coating. Color to be selected from manufacturer’s standard [custom non-exotic] [custom exotic] colors as selected by the Architect, applied over manufacturer’s standard substrate preparation including cleaning, degreasing and chromate conversion coating. Finish shall meet or exceed AAMA 2604. (Color \_\_\_\_\_\_\_\_\_\_).

6. Provide manufacturer’s standard 2 coat Fluoropolymer 70% Kynar baked on, electrostatically applied enamel coating. Color to be selected from manufacturer’s standard [custom non-exotic] [custom exotic] colors as selected by the Architect, applied over manufacturer’s standard substrate preparation including cleaning, degreasing and chromate conversion coating. Finish shall meet or exceed AAMA 2605. (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 window 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 inside glazed or outside glazed and held in place with extruded aluminum glass stops.

3. Water Drainage: Each light of glass shall be internally drained using weep holes, pressure equalization holes and sealant to divert water to the sill weep locations. Weep holes shall be located in the sill 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.

a. Reference: ANSI Z97.1, CPSC 16 CFR 1201 and GANA Glazing Manual

**3.3 Field Quality Control**

A. Field Tests: Architect shall select window 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 0.15 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 window 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 08 46 00**