

# Western Integrated Materials, Inc.

3310 E. 59<sup>th</sup> Street • Long Beach, CA 90805 • 562-643-2823

## Specifications Section 08120

### PART 1 GENERAL

#### 1.1 SECTION INCLUDES

- A. Pre-finished aluminum door frames for interior use.
- B. Pre-finished aluminum window frames for interior use.
- C. Pre-finished aluminum framing system for interior use.

#### 1.2 RELATED SECTIONS

- A. Section 08211 – Flush Wood Doors.
- B. Section 08410 – Aluminum Entrances and Storefront.
- C. Section 08520 – Aluminum Windows.
- D. Section 08710 – Door Hardware.
- E. Section 08800 – Glass and Glazing.

#### 1.3 SUBMITTAL

- A. Submit under provisions of Section 01300.
- B. Product Data: Manufacturer's fabrication and installation instructions.
- C. Shop Drawings:
  - 1. Provide standard installation details for typical architectural conditions.
  - 2. Provide details of connections to special construction and other custom features.
- D. Selection Samples: Provide aluminum chips in full range of manufacturer's standard finishes for Architect's color selection.
- E. Verification Samples: Provide two samples of each type of framing member required, not less than 12 inches long, in selected finish.

#### 1.4 QUALITY ASSURANCE

- A. Manufacturer: Provide aluminum frames manufactured by a single firm specializing in production of this type of work for a minimum of five years.
- B. Fire Rated Assemblies:
  - 1. In locations where fire-rated openings are scheduled or required by regulatory agencies, provide fire-rated aluminum frames that have been tested and certified for specified exposure by an agency acceptable to governing authorities.
  - 2. Provide labels permanently fastened on each frame that is within size limits established by NFPA and the testing authority.

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- a. Provide 20-minute labels.
- b. Provide 90-minute labels.
- c. Provide labels for openings as scheduled on the drawings.

### 1.5 DELIVERY, STORAGE AND HANDLING

- A. Deliver frames and doors packaged to provide protection during transit and storage at project site.
- B. Inspect frames upon delivery for damage.
  1. Repair minor damage to polyester finish by using air-drying spray enamel of matching color.
  2. Replace frames that cannot be satisfactorily repaired.
- C. Store frames at project site under cover and as near as possible to final installation location. Do not use covering material that will cause discoloration of aluminum finish.

### 1.6 ENVIRONMENTAL REQUIREMENTS

- A. Do not begin installation of aluminum frames until area of work has been completely enclosed and interior is protected from the elements.
- B. Maintain temperature and humidity in areas of installation within reasonable limits, as close as possible to final occupancy standards. If necessary, provide artificial heating, cooling, and ventilation to maintain required environmental conditions.

## PART 2 PRODUCTS

### 2.1 MANUFACTURERS

- A. Provide products manufactured by:  
Western Integrated Materials, Inc.  
3310 E. 59<sup>th</sup> St., Long Beach, CA 90805  
Telephone: 562-634-2823  
[www.Western-Integrated.com](http://www.Western-Integrated.com)
  1. Substitutions will not be acceptable.
  2. Substitutions: Comply with provisions of Section 01600 for substitution requests.

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### 2.2 MATERIALS

- A. Aluminum Frames: (Extruded Aluminum) Standard alloys shall conform to requirements published in AA ASD-1 and ASTM B221; Controlled alloy billets of 6063T5, to assure compliance with tight dimensional tolerances and maintain color uniformity Extruded Aluminum minimum thickness of .062 in.

### 2.3 EXTRUDED ALUMINUM FRAMES

- A. Western Integrated Materials Series 300, 400, 401, 402, 700, 701 Frames: Provide frames with the following characteristics:
1. Rectilinear design.
  2. 1-1/2", 2", 3", 4" face profiles.
  3. Trim:
    - a. 1" with 3/8" return
    - b. 1-1/4" with 5/8" return
    - c. 1-1/2" with 5/16" return
    - d. 1-7/16" with 3/8" return
    - e. 2" with 5/16" return
    - f. 3" with 5/16" return
    - g. 4" with 5/16" return
  4. Series 300 Throat sizes:  
3", 3-1/4", 3-3/8", 3-1/2", 3-3/4", 4-1/2", 4-5/8", 4-3/4", 4-7/8", 5", 5-1/4", 5-1/2", 6", 7-1/4"
  5. Series 400 Throat sizes:
    - a. From 3" to 6"
  6. Series 401 Throat sizes:
    - a. From 6" to 7-1/2"
  7. Series 402 Throat sizes:
    - a. From 7-1/2" to 9-1/2"
  8. Series 700 Throat sizes:
    - a. From 3-3/4" to 5-1/2"
  9. Series 701 Throat Sizes:
    - a. From 5-1/2" to 8-3/8"

### 2.4 FABRICATION

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- A. Pre-machine jambs and prepare for hardware, with concealed reinforcement plates, drilled and tapped as required, and fastened within frame.
- B. Manufactured to receive 4-1/2" x 4-1/2" square hinges.
- C. Manufactured to receive a standard 2-3/4" Cylindrical or 4-7/8" A.S.A. strike.
- D. Supplied with 1/8" thick aluminum strike and hinge back up, pre-mounted on jambs.
- E. Supplied with vinyl or mohair mute.
- F. Provide corner alignment clips for precise butt or mitered connections.
- G. Fabricate all components to allow secure installation without exposed fasteners.
- H. 700 and 701 Series 90 Minute Positive Pressure Frame has full length steel backer with hinge and strike pre-drilled and tapped.

### 2.5 FINISHES

- A. Factory finish extruded frame and door components so that any part exposed to view upon completion of installation will be uniform in finish and color.
- B. Acrylic Finish: Comply with AAMA 603.5; baked to assure hardness.
  - 1. Color: As selected from manufacturer's standard colors.
  - 2. Color: As indicated in schedules on the drawings.
  - 3. Custom color to match Architect's sample.
- C. Clear Anodic Coating: Comply with AAMA 611
  - 1. Commercial, AAM12C22A21 clear anodized coating, 0.4 mil minimum thickness.
- D. Dark Bronze Anodic: Comply with AAMA 611
  - 1. Commercial, AAM12C22A24 bronze anodized coating, 0.4 mil minimum thickness.
- D. Black Anodic Coating: Comply with AAMA 611
  - 1. Commercial, AAM12C22A34 black anodized coating, 0.4 mil minimum thickness.

### PART 3 EXECUTION

#### 3.1 EXAMINATION

- A. Examine project conditions and verify that the work of this section may properly commence. Do not proceed with installation until satisfactory conditions have been corrected.
- B. Verify wall thickness does not exceed standard tolerance of +/- 1/16".

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### 3.2 INSTALLATION

- A. Comply with frame manufacturer's printed installation instructions and approved shop drawings. Strictly adhere to maintaining specified wall thickness to insure dimension does not exceed frame throat size specified.
- B. Install frames plumb and square, securely anchored to substrates with fasteners recommended by frame manufacturer.
  - 1. Use Concealed installation clips to assure that splices and connections are tightly butted and properly aligned.
  - 2. Secure clips to main structural extrusion components and not to snap-in or trim members.
  - 3. Do not use screws or other fasteners that will be exposed to view when installation is complete.

### 3.3 ADJUSTING AND CLEANING

- A. Clean exposed frames promptly after installation, using cleaning methods recommended by frame manufacturer.
- B. Touch up marred areas so that touch-up is not visible from a distance of 4 feet. Remove and replace frames that cannot be satisfactorily adjusted.

### 3.4 PROTECTION

- A. Provide protection required to assure that frames and doors will be without damage or deterioration upon substantial completion of the project.