

# SPECIFICATIONS

## “AOL”

### ALLIED ONE LITE

**APPLICATION: INTERIOR OR EXTERIOR INSTALLATION: INSERTS REMOVE TO INTERIOR OR EXTERIOR RESPECTIVELY**

#### **PART 1 – GENERAL**

**1. 1.1 SCOPE.** All aluminum windows of the types and sizes shown in the plans and/or as called for in this specification shall be furnished with all necessary hardware, fasteners and miscellaneous equipment as herein specified and shall be manufactured by Allied Window, Inc. Quality standards shall be as described within these specifications.

#### **PART 2 – MATERIALS**

**2.1 ALLOYS.** Aluminum shall be of commercial quality and of proper alloy for window construction free from defects impairing strength and durability. All straight extruded sections shall be of 6063-T5 alloy and temper and shall have a minimum ultimate tensile strength of 22,000 P.S.I. and a yield of 16,000 P.S.I.

**2.2 WINDOW MEMBERS.** All master frame and insert members shall be of extruded aluminum with a 3/8” x 1 dimension. All extrusions shall be of sufficient strength to perform as designed. Window members shall have a nominal wall thickness of not less than .062”. All corner keys shall be of extruded aluminum.

**2.3 FASTENERS.** All screws and other miscellaneous fastening devices incorporated shall be zinc plated, cadmium plated or other non-corrosive metals compatible with aluminum.

**2.4 HARDWARE.** All insert clips shall be nylon, or zinc die cast.

**2.5 “INVISIBLE” CLIPS.** Optional insert clips shall be a 3-part zinc die cast assembly which shall be flush with the face of the insert frame.

#### **PART 3 – CONSTRUCTION**

**3.1 ASSEMBLY.** All windows shall be assembled in a secure and workmanlike manner. The master frame and insert frame(s) shall be of mitered head and sill. Frame rails and stiles shall be neatly joined together using extruded aluminum corner keys staked in place.

**3.2 SILL EXPANDER.** Sill expander (optional) shall be of “H” type with minimum wall thickness of .062” and .125” web thickness, and modified to permit weepage. Sill expander is mandatory when units are provided with “invisible” clips.

**3.3 INSERTS.** Insert(s) shall be freely removable and equipped with a full bottom rail lift handle. Insert(s) held in place by cam action clips.

**3.4 HARDWARE.** Latching clips shall have cam action and provide positive seal between master frame and insert(s).

**3.5 “INVISIBLE” CLIPS.** Latching clips shall be activated by use of a phillips-head screwdriver, with a 90 degree turn being sufficient to engage or dis-engage the cam clip.

#### **PART 4 – FINISH**

The exposed surfaces of all aluminum members shall be clean and free from serious surface blemishes. Standard finishes shall be electrostatically applied baked acrylic enamel in white, beige, black or bronze. Painted finish shall meet AAMA 603.6. Optional custom color finish to be two-part polyurethane paint (air dried). Clear anodized, bronze anodized and Kynar finishes are available under appropriate circumstances.

#### **PART 5 – SCREEN(S) (Optional)**

Extruded screen insert frame(s) (3/8" x 1 1/16") with extruded aluminum corner keys shall be provided. Standard screen cloth is charcoal aluminum 18 x 16 mesh securely held in frame with vinyl spline (fiberglass, black aluminum, bright aluminum, or bronze screen wire optional).

#### **PART 6 – GLASS AND GLAZING**

**6.1 GLASS.** Glass shall be not less than "B" quality. Standard factory glazing shall be "DSB" (1/8"). Optional use of 5/32", 3/16", or tempered glass shall be dictated by size of panels, code requirements, or project specifications.

**6.2 GLAZING MATERIAL.** Glass shall be held in place with removable and reusable vinyl glazing splines. Vinyl shall be manufactured from virgin polyvinyl chloride. All corners shall be neatly mitered.

#### **PART 7 – INSTALLATION**

The installer shall securely fasten windows in place to a straight, plumb and level condition, without distortion of the windows and shall make final adjustments for proper operation in accordance with the manufacturer's instructions.

#### **PART 8 – WARRANTY**

Manufacturer shall provide a five (5) year warranty against faulty materials, paint and workmanship.

*SPECIFICATIONS SUBJECT TO CHANGE WITHOUT NOTICE.*

*For More Information Contact:*

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