

## 600 Series – Windload Certified / Insulated Rolling Steel Door Foamed in Place Urethane (FIP)

### PART 1 – GENERAL

#### 1.01 DESCRIPTION

- A. Type:** Windload certified Insulated Doors to be manufactured by Asta America.  
**B. Operation:** standard chain hoist operated using gear reduction, motor operation optional.  
**C. Mounting:** to be interior face mounted on a prepared opening, between jamb under lintel, between jamb face of wall or exterior.

#### 1.02 RELATED WORK

- A. Opening preparation, access panels, finish or field painting are in the scope of the work of other sections or trades.

### PART 2 - PRODUCT

#### 2.01 CURTAIN

**A. Slats:** galvanized steel cold roll formed in continuous lengths. Galvanized according to A.S.T.M. A653- and finished with baked epoxy primer and baked polyester topcoat.

1. Model 622 – 22-gauge (front) and 24-gauge (back) up to 24' (7.32m) wide x 16' (4.88m) high
2. Model 620 – 20-gauge (front) and 24-gauge (back) up to 26' (7.92m) wide x 26' (7.92m) high or 32' (9.75m) x 20' (6.1m)
3. Model 618 – 18-gauge (front) and 24-gauge (back) up to 26' (7.92m) wide x 26' (7.92m) high or 31' (9.45m) x 24' (7.32m)

*Note 1: Optional 22-gauge back slat available only on front slats that are 22, 20- or 18-gauge doors.*

*Note 2: For larger sizes not listed please contact customer service.*

**B. Windlocks:** each end of alternate slats to be fitted with endlocks to provide a wearing surface in the guides and to maintain slat alignment, Fastened with 1/4" rivets.

**C. Windload:** Design pressures based on the test of a 24' wide +28.8/-30.5 psf and 16' wide +55/-60 psf windload pressure.

**1. Windload Certified Up To 32' wide x 30' high**

**2. Impact Rated Up To 24' wide x 30' high D. Bottom Bar:** curtain to be reinforced with a bottom bar consisting of two 2" x 2" x 12 gauge minimum to 1/4" structural steel, P.V.C. bulb astragal.

**E. Insulation:** to be 3/4" foamed in place urethane to flat slat. (R = 7.2 U = .139)

**F. Vision Lites: (Optional):** 5" x 3/4".

**Bottom Bar:** curtain to be reinforced with a bottom bar consisting of two steel angles bolted back-to-back with bottom astragal, painted black (powder coat optional).

#### **E. Insulation:**

1. to be 3/4" foamed in place urethane (FIP) to flat slat. (R = 7.2 and U = .139)

**F. Vision Lites: (Optional):** 5" x 3/4"

#### 2.02 BARREL ASSEMBLY

**A. Barrel:** to be a steel pipe of diameter and wall thickness to restrict maximum deflection to .03" per foot (2.5 mm/m) of door width.

**B. Springs:** to be oil tempered, grease packed helical torsion type designed to cycle 25,000 times. Springs are to be mounted on a cold rolled steel inner shaft.

**C. End Bearing:** to be self-lubricating ball bearings or oil impregnated bronze bushings.

#### 2.03 BRACKET PLATES

**A. Bracket Plates:** to be 1/4" (6.35mm) minimum thickness steel plate and enclose ends of barrel assembly.

**B. Drive End Bracket Plate:** to be fitted with a self-aligning sealed ball bearing.

#### 2.04 OPERATION

- A. Chain Hoist:** to consist of roller chains and sprockets.
- B. Hand Chain:** to be galvanized machine link. Pull not to exceed 35 lbs. (156 N).
- C. Electric Motor Operation:** to be front of hood mount or wall mounted.

## **2.05 GUIDE ASSEMBLY**

- A. Wall Angles:** to be 3/16" (4.76mm) minimum thickness structural steel angles.
- B. Guides:** wind-bar guides to be structural steel angles 3/16" (4.76mm) minimum thickness with removable headstops and 30"(762mm) service cutout on both sides.
- C. Guide Depth:** to provide slat penetration adequate to satisfy specified windloading.
- D. Weather Seal:** non-coil side to be clip on vinyl weather seal (optional aluminum retainer with brush seal).

## **2.06 HOODS**

- A. Hoods:** to be 24-gauge galvanized steel with baked epoxy primer and baked polyester top coat and enclose coil. 8" P.V.C. baffle to be riveted to inside of hood.
- B. Reinforcing:** to be 1/4" (6.35mm) thick steel brackets for doors over 16'0" (4877mm) wide.

## **2.07 LOCKING**

- A. Hand Chain Lock:** lockable bracket, mounted on guide angle or wall, suitable for padlocking (padlock by others), slide bolt locks and cylinder locks optional.

## **2.08 FINISH**

- A. Ungalvanized Surfaces:** to be shop coated with rust reducing black prime paint, except malleable windlocks.
- Curtain finish options:**
1. White topcoat
  2. Gray topcoat
  3. Tan topcoat
  4. Galvanized (22 gauge only)

## **PART 3 - EXECUTION**

### **3.01 INSTALLATION**

- A. Installation:** to be by an authorized representative according to Asta America standards and instructions.