



322 Series – Commercial Slat Door/ 22 Gauge

1/12/2007

Part 1 - GENERAL

1.01 DESCRIPTION

- A. **Type:** Commercial Slat Doors to be manufactured by Porvene Doors, Inc.
- B. **Operation:** to be chain hoist operation using gear reduction. Electric motor is optional.
- C. **Mounting:** to be interior face mounted on a prepared opening.

1.02 RELATED WORK

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

Part 2 - PRODUCT

2.01 CURTAIN

- A. **Slats:** 22 gauge galvanized steel cold roll-formed in continuous lengths. Galvanized according to A.S.T.M. A653-G60^{*} and finished with baked epoxy primer and baked polyester topcoat.
- B. **Endlocks:** 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:** door construction designed to satisfy a *non-operational* windload in the closed lock position of windloads up to 20 PSF (0.96KPA) or 87 MPH (140 KPH). *Doors over 17'-0" wide offer no windload ratings.*
- D. **Bottom Bar:** curtain to be reinforced with a bottom bar consisting of a 2" X 2" X 3/16" (50.8mm x 50.8mm x 4.76mm) structural steel angle with E.P.D.M. astragal.

2.02 DRUM ASSEMBLY

- A. **Drum:** to be stamped from 18 gauge galvanized steel.
- B. **Torque Tube:** to be formed with 24 gauge galvanized steel sheet for doors over 12' wide, otherwise 26 gauge, rolled around and fastened to stamped galvanized steel drums to resist deflection to 0.03 in/ft (2.5mm/m) of door width.
- C. **Springs:** to be oil tempered, grease packed, helical torsion type designed to cycle 12,500 times with an overload factor of 25%. Springs are to be mounted on a 1.5/16" (33.34mm) black steel pipe of minimum Schedule 40.
- D. **End Bearings:** to be self-lubricating ball bearings.

2.03 SUPPORT BRACKETS

- A. **Support Brackets:** to be 3/16" (4.76mm) thick structural steel angles and a 1/4" (6.35mm) thick steel diagonal

brace welded in a triangular form to support ends of drum assembly.

2.04 OPERATION

- A. **Chain Hoist:** to be roller chain reduction.
- B. **Hand Chain:** to be galvanized machine link. Pull not to exceed 35 lbs. (156N).

2.05 GUIDE ASSEMBLY

- A. **Wall Angles:** to be 1/8" (3.18mm) thick structural steel angles.
- B. **Guides:** to be roll formed 13 gauge galvanized steel channels. 12 gauge guides on doors requiring windlocks.
- C. **Guide Depth:** to provide slat penetration adequate to satisfy specified wind loading.

2.06 LOCKING

- A. **Hand Chain Lock:** bracket, to be mounted on guide angle or wall for chain operated doors.
- B. **Curtain Lock:** to be hardened galvanized steel slide bolts attached to bottom angle, suitable for padlocking. (Padlock by others.)

2.07 FINISH

- A. **Ungalvanized Surfaces:** to be shop coated with rust reducing black prime paint.

Part 3 - EXECUTION

3.01 INSTALLATION

- A. **Installation:** to be by Porvene Doors, Inc. authorized representative according to Porvene Doors, Inc. standards and instructions.

*A.S.T.M. A653 is the new designation of ASTM A527