SPECIFICATIONS 08330

420 Series - Vent Master Rolling Steel Door / 20 Gauge

11/23/2009

Part 1 - GENERAL

1.01 DESCRIPTION

A. **Type:** Vent-Master Rolling Steel Doors to be manufactured by Porvene Doors, Inc.
B. **Operation:** to be chain hoist operated using gear reduction.
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:** 20 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. **Vents:** flat slats to have Vent cutouts 5" (127mm) wide x 7/8" (22mm) high. Spaced 3" (76mm) apart.
C. **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.
D. **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). Consult factory for available sizes and corresponding windloads.
E. **Bottom Bar:** curtain to be reinforced with a bottom bar consisting of two 2" X 2" X 1/8" (50.8mm x 50.8mm x 3.18mm) structural steel angles with P.V.C. bulb astragal.

2.02 BARREL ASSEMBLY

A. **Barrel:** to be a steel pipe of diameter and wall thickness to restrict maximum deflection to 0.03 in/ft (2.5mm/m) of door width.
B. **Springs:** to be oil tempered, grease packed, helical torsion type designed to cycle 20,000 times with an overload factor of 25%. Springs are to be mounted on a cold rolled steel inner shaft. Option of high cycle spring life.
C. **End Bearings:** 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 self aligning sealed ball bearing.

2.04 OPERATION

A. **Drive:** to be roller chain reduction or (optional) electric motor.
B. **Hand Chain:** to be galvanized machine link. Pull not to exceed 35 lbs. (156N).

2.05 GUIDE ASSEMBLY

A. **Wall Angles:** to be structural steel angles, minimum 3/16" (4.76mm) thick.
B. **Guides:** to be structural steel angles 3/16" (4.76mm) minimum thickness with removable head stops.
C. **Guide Depth:** to provide slat penetration adequate to satisfy specified wind loading.

2.06 HOODS

A. **Hoods:** to be 24 gauge galvanized steel with baked epoxy primer and baked polyester top coat to enclose coil.
B. **Reinforcing:** to be 1/4" (6.35mm) thick steel brackets for sustaining hoods on doors over 16'-0" (4877mm) wide.

2.07 LOCKING

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

2.08 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 authorized representative according to Porvene Doors, Inc. standards and instructions.

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