

GLASS FACADES

***** Unique, custom designed, glass facades, entrances, storefronts, curtain walls, skylights, canopies, and other structures can add distinction, exceptional beauty, and expansive visibility to a construction project. However, these glass structures require meticulous engineering, extensive knowledge of materials and codes, broad experience, quality materials, and expert craftsmanship. Each design will have unique parameters and requirements which must be accurately addressed in order to provide a safe, functional, durable, weather-resistant glass structure which can withstand wind and seismic loads and thermal expansion and contraction. It is critical that unique glass structures be both designed and fabricated by a single, knowledgeable entity assuming complete responsibility. Piece-meal assembly of products from numerous manufacturers and fabricators without a comprehensive design and engineered solution is not a method for achieving a functional, safe, glass structure.

LAMGLAS Skytec® Structural Glass, A.S. can provide this essential sole source design and fabrication responsibility. They are a domestic company focused on the Europe, MiddleEast and All Turkish countries market. They provide glass luxury at affordable prices in a timely manner. **LAMGLAS** Skytec® Structural Glass, A.S. designs and fabricates a wide variety of glass structures including facades, entrances, storefronts, skylights, canopies, glass fin systems, and tension truss structures.

This specification guide can be used to specify a custom designed and engineered glass entrance and storefront. In contrast to more typical descriptive specifications, this section is a performance type emphasizing the critical factor of design and engineering. It provides a convenient format that can be edited to reflect the unique glass structure envisioned by an architect and ensure that it is correctly engineered, carefully detailed, accurately fabricated, and properly installed.

This specification section is organized by placing information in three standard parts:

PART 1 - GENERAL

Describes the design and performance criteria for the glass facade and other administrative and procedural requirements.

PART 2 - PRODUCTS

Describes materials, products, accessories, and fabrication methods to be used for the glass facade.

PART 3 - EXECUTION

Describes how the components will be assembled and installed at the construction site.

Throughout this product guide specification, references are made to other specification sections that might be contained in the project manual. These references are presented as examples and coordination reminders. For each project, these references will need to be revised to reflect actual sections being used.

Within the specification text, Imperial dimensions are presented first in brackets followed

by System International Metric (SI) equivalents also in brackets. Depending on project requirements, either the Imperial or the SI metric equivalents will need to be deleted.

The specifier will need to edit this product specification for a specific project to reflect the options and applications being used. The guide section has been written so that much editing can be accomplished by deleting unnecessary requirements and options. Additional information describing the desired characteristics of the glass structure will need to be added by the specifier. Options are indicated by []. Notes to assist the specifier in selecting options and editing the specification guide are printed in bold and indicated with *****. For final editing, all brackets and notes will need to be deleted from the guide.

PART 1 - GENERAL

1.1 SUMMARY

***** Edit the following paragraph to reflect project requirements. *****

- A. Section includes: Functional design, structural engineering, custom fabrication, and site erection required for complete glass [facade] [entrance] [storefront] [curtain wall] [_____] for [__type of project or structure__].

***** List other specification sections dealing with work directly related to this section such as the following. *****

B. Related sections:

1. Section [03 30 00] [03300] - Cast-in-Place Concrete: [Foundations and slabs] [concrete structural frame] to receive glass facade.
2. Section [05 12 00] [05120] - Structural Steel: Steel structural frame to receive glass facade.

***** Glass entry door hardware may be specified in this section or in a separate section covering hardware for all project doors. However, supply and installation of door hardware must be part of this section to ensure sole source responsibility. Include the following paragraph if door hardware is specified in a separate section. *****

3. Section [08 71 00] [08710] - Door Hardware: Hardware for glass entry doors to be supplied and installed as part of this Section.

***** Glass for facades and entrances may be specified in this section or in a separate section covering glass for all project glazing. If color tinted or reflective glass is required for various entrance, storefront, window, door, and curtain wall systems, it is important that glass be provided from a single glass manufacturer to ensure uniformity of appearance. However, supply and installation of glass must be part of this section to

ensure sole source responsibility. Include the following paragraph if glass is specified in a separate section. *****

4. Section [08 80 00] [08800] - Glazing: Glass to be supplied and installed as part of this Section.

1.2 REFERENCES

****** List by number and full title reference standards referred to in remainder of specification section. Delete non-applicable references. ******

- A. American National Standards Institute (ANSI): ANSI Z97.1 - Safety Performance Specifications and Methods of Test for Safety Glazing Material Used in Buildings.
- B. American Society of Civil Engineers (ASCE): ASCE 7 - Minimum Design Loads for Buildings and Other Structures.
- C. American Society for Testing and Materials (ASTM):
 1. ASTM A167 - Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip.
 2. ASTM A269 - Seamless and Welded Austenitic Stainless Steel Tubing for General Service.
 3. ASTM A276 - Stainless and Heat-Resisting Steel Bars and Shapes.
 4. ASTM A653 - Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by Hot-Dip Process.
 5. ASTM B248 - Wrought Copper and Copper Alloy Plate, Sheet, Strip, and Rolled Bar.
 6. ASTM B221 - Aluminum-Alloy Extruded Bar, rod, Wire, Shape, and Tube.
 7. ASTM C509 - Elastomeric Cellular Preformed Gasket and Sealing Material.
 8. ASTM C864 - Dense Elastomeric Compression Seal Gaskets, Setting Blocks, and Spacers.
 9. ASTM C920 - Elastomeric Joint Sealants.
 10. ASTM C1036 - Flat Glass.
 11. ASTM C1048 - Heat Treated Flat Glass, Kind HS, Kind FT, Coated and Uncoated.

12. ASTM C1115 - Dense Elastomeric Silicone Rubber Gaskets and Accessories.
 13. ASTM C1172 - Laminated Architectural Flat Glass.
 14. ASTM C1281 - Preformed Tape Sealants for Glazing Applications.
 15. ASTM E283 - Rate of Air Leakage Through Exterior Windows, Curtain Walls, and Doors under specified Pressure difference Across Specimen.
 16. ASTM E330 - Structural Performance of Exterior Windows, Curtain Walls, and Doors by Uniform Static Air Pressure Difference.
 17. ASTM E331 - Water Penetration of Exterior Windows, Skylights, Doors, and Curtain Walls by Uniform Static Air Pressure Difference.
 18. ASTM E546 - Frost Point of Sealed Insulating Glass Units.
 19. ASTM E576 - Frost Point of Sealed Insulating Glass Units in Vertical Position.
 20. ASTM E773 - Accelerated Weathering of Sealed Insulating Glass Units.
 21. ASTM E774 - Classification of the Durability of Sealed Insulating Glass Units.
 22. ASTM E1300 - Determining Load Resistance of Glass in Buildings.
- D. Consumer Product Safety Commission (CPSC): CPSC 16 CFR 1201 - Safety Standard for Architectural Glazing Materials.
- E. Glass Association of North America (GANA): GANA - Glazing Manual.
- F. International Code Council (ICC): ICC IBC - International Building Code.

1.3 GLASS FACADE DESCRIPTION

- A. Glass facade to be custom designed, engineered, detailed, factory fabricated, and site assembled and erected.

******* Many interesting and unique glass facades can be created by Lamglas Structural Glass, A.S. Contact them for available options and assistance in planning and specifying. Edit the following paragraph to reflect basic configuration of glass structure. *******

- B. Basic configuration: [Straight] [curved] [multi-angled] [articulated] [_____] layout with [vertical] [sloped] [_____] walls [and [swinging] [horizontal sliding] [revolving] [_____] entrance doors] to provide architectural appearance and configuration shown on Drawings.
- C. Dimensions: Glass facade shall be nominal dimensions shown on Drawings. Minor

variations to accommodate manufacturer's design and components are acceptable provided overall concept is maintained.

******* Numerous methods of glazing and structural support can be used to accomplish the unique appearance and style desired by the architect and owner. Consult with LAMGLAS Skytec® Structural Glass, A.S. on available methods and their characteristics, features, cost, and limitations. Selection of method can be defined by design professional in consultation with LAMGLAS Skytec® Structural Glass, A.S. or determination of system can be delegated to manufacturer. *******

- D. Type of glass structure: [Perimeter metal framing with [front] [center] [back] glazing.] *** [Metal support framing with contact structural silicone sealant glazing such that no intermediate framing members are visible from exterior.] *** [Structural glass panels with top and bottom metal channel framing and butt glazed vertical joints.] *** [Glass panels with glass fin stabilizers and metal connector fittings.] *** [Glass panels with [vertical] [horizontal], tension truss supports and metal connector fittings.] *** [As determined by manufacturer to efficiently provide configuration and size of glass facade shown on Drawings.] *** [other method as determined in consultation with LAMGLAS Skytec® Structural Glass, A.S.]

1.4 DESIGN AND PERFORMANCE CRITERIA

******* LAMGLAS Skytec® Structural Glass, A.S. will provide structural engineering and design for support system, connections, anchors, seals, and other elements of glass facade. Edit this article to reflect project conditions and applicable codes. *******

A. Design Requirements:

1. Design Wind Load: [_____] pounds/square foot] [_____] kilograms/square meter]
2. Snow Load (if applicable): [_____] pounds/square foot] [_____] kilograms/square meter]
3. Seismic Zone: [_____]
4. Live load deflection of supporting structure (if any): [_____]

B. Design, size components, and install glass facade in accordance with ASTM E1300 to withstand these loads without breakage, loss, failure of seals, product deterioration, and other defects.

1. Dead and live loads: Determined by ASCE 7 and calculated in accordance with applicable codes.
2. Seismic loads: System shall be designed and installed to comply with applicable seismic requirements for Project location and Seismic Zone [0] [1] [2A] [2B] [3] [4] as defined by of ICC/IBC.

3. Movement and deflection of structural support framing.
 4. Effects of applicable wind load acting inward and outward normal to plane of wall in accordance with ASTM E330.
 5. Thermal loads and movement:
 - a. Ambient temperature range: [[120] [_____] degrees F.] [[48] [_____] degrees C.]
 - b. Material surfaces range: [[180] [_____] degrees F.] [[82] [_____] degrees C.]
- B. Provide and install exterior gaskets, sealants, and other glazing accessories to resist water and air penetration.
1. Air infiltration: Less than [[0.06] [_____] cubic feet/minute/square foot] [[1699] [_____] cubic centimeters/second] of fixed area tested in accordance with ASTM E283.
 2. Water infiltration: No penetration at [15] [_____] pounds/square foot] [[73] [_____] kilograms/square meter] test pressure and [[18] [_____] gallons/hour/square foot] [[203] [_____] liters/hour/square meter] water rate tested in accordance ASTM, EN, TSE.

1.5 SUBMITTALS

- A. Submit in accordance with Section [-----] [-----] - Submittal Procedures:
1. Product data for all proposed components, materials, products, and accessories.
 - a. For each type glass, provide maximum allowable stress in both horizontal and vertical directions.
 - b. Provide photographs or drawings for fittings and hardware.
 2. Shop drawings:

******* Edit the following list to reflect components required for glass facade. *******

- a. Plans, elevations, and sections illustrating shape, configuration, and dimensions. For complex structures provide perspectives, renderings, or models.
- b. Illustrate method of assembly, installation, and glazing.

- c. Provide details for support framing, reinforcement, connections, joints, anchors, and other fabrication and installation conditions.
 - d. Indicate required tolerances and coordination with adjacent elements and work of other trades.
3. Calculations: Show compliance with performance criteria and applicable loads with stamp of Licensed Professional Engineer registered in the State of [_____].
4. Samples:
 - a. [30 by 30 cm] minimum size for each type glass.
 - b. Glass fitting.
 - c. [152 mm] minimum length for [structural silicone sealant] [butt] [resilient gasket] [_____] glazed joint.
 - d. Metal finishes.
 - e. Sealant colors.
5. Manufacturer's installation and maintenance instructions.
6. Certificates or test reports demonstrating components and methods have been successfully tested by an independent laboratory in Turkey or wherever you want certifying that the proposed system has been tested and as defined by Paragraph [1.4] [_____].
7. Data showing compliance with manufacturer's and installer's qualifications specified in Paragraphs [1.6.A and 1.6.B] [_____]. Provide descriptions, locations, photographs, references, and completion dates for previous projects.
8. Copies of warranties required by Paragraph [1.11] [_____] for review by Architect. Included with warranty shall be a letter certifying the proposed system will be manufactured from one source. Glass cannot be supplied by one manufacturer and hardware from another manufacturer to comply with this warranty. Letters signed by the subcontractors or installers for this section are not acceptable.

1.6 QUALITY ASSURANCE

******* To ensure that completed glass facade is structurally sound, weathertight, functional, durable, and safe; specify that design, engineering, fabrication, and supply of all components, materials, and products be the sole responsibility of an experienced single entity such as LAMGLAS Skytec® Structural Glass, A.S. It is critical that unique glass**

structures be both designed and fabricated by a single, knowledgeable entity assuming complete responsibility. Piece-meal assemblies of products from numerous manufacturers and fabricators without a comprehensive design and engineered solution is not a method for achieving a functional, safe, glass structure.

- A. Single source responsibility: Design, structural engineering, and custom fabrication for glass facade and supply of all components, materials, and products shall be sole responsibility of single manufacturer. Provision of products from numerous sources for site assembly without complete single source design and supply responsibility is not acceptable. Components to be fabricated or supplied by single source are:

******* Edit the following list to reflect components required for glass skylight. *******

1. Support framing.
 2. Glass [as specified in Section - Glazing].
 3. Connectors, fittings, anchors, and installation accessories.
 4. Doors and frames.
 5. Door hardware [as specified in Section [] [] - Door Hardware].
 6. Gaskets, glazing tape, and sealants.
 7. All other components, products, and materials required for complete, functional glass facade.
- B. Single installation responsibility: All components listed in Paragraph [1.6.A] [] shall be installed by a single installer.
- C. Manufacturer qualifications: Company specializing in designing, engineering, and fabricating unique, custom designed, glass fin structures, entrances, storefronts, and other glazed structures. Glass cannot be supplied by one manufacturer and hardware from another manufacturer to comply with this warranty. Letters signed by the subcontractors or installers for this section are not acceptable.
1. Experience: 8 years minimum successful experience providing glass structures.
 2. Previous projects: Successfully completed 15 minimum glass structures of scope, type, and size as proposed Project.
- D. Installer qualifications: Company experienced in erecting custom designed, glass facades, entrances, storefronts, and other glazed structures and acceptable to manufacturer for installing proposed structure.
1. Experience: 5 years minimum successful experience erecting glass structures.

2. Previous projects: Successfully completed 5 minimum glass structures of scope, type, and size as proposed Project.
- E. Design structural components and develop shop drawings under direct supervision of professional structural engineer experienced in design of glass structures. Calculations and shop drawings shall bear engineer's seal.
- F. Safety glazing: Comply with Consumer Product Safety Commission 16 CFR 1201, ANSI Z97.1, and other applicable safety requirements. Each piece of safety glazing shall be permanently labeled with appropriate marking.

******* For large, more complicated structures it is appropriate that LAMGLAS Skytec® Structural Glass, A.S. send a field representative to oversee installation. Use the following paragraph to require manufacturer's field representative. *******

- G. Manufacturer's field representative:
 1. During installation, provide services of manufacturer's field representative knowledgeable of erection process for proposed glass facade.
 2. Manufacturer's representative shall observe installation, quality control, and certify work meets specified requirements.
 3. Manufacturer's representative shall submit report covering observations, procedures, noted deficiencies, corrective measures, and certification of proper installation.

1.7 MOCK-UP

******* For larger projects or complicated conditions a mock-up may be important to establish workability and performance of proposed glass facade. Include this article to request mock-up constructed on site separate from actual construction. *******

- A. In accordance with Section [-----] [-----] - Quality Requirements, prepare separate mock-up illustrating construction method for glass facade. Mock-up shall demonstrate performance and establish workmanship quality standard.
- B. Provide concrete slab as mock-up base.
- C. Mock-up shall be wall segment with [corner] [door] [intersection with adjacent construction] [_____]. Construct with all anchors, fasteners, sealants, and other components proposed for actual installation.
- D. Approximate size: [3 by 3 m] [_____].
- E. Test mock-up with [water hose to verify weathertightness] [[other test]] to verify [type of performance].

- F. Submit report describing tests, results, and any modifications made to correct deficiencies or to improve performance.
- G. Do not proceed with installation until mock-up has been inspected and accepted by Architect.
- H. Retain approved mock-up during construction as quality standard. Completely remove when work is accepted.

1.8 PRE-INSTALLATION CONFERENCE

******* Depending on project size, complexity of glass structure, and number of coordination items, a pre-installation conference maybe important. Include this article to specify pre-installation conference. *******

- A. In accordance with Section [01 31 00] [01310] - Project Management and Coordination, convene a pre-installation conference at site prior to commencing work of this Section.
- B. Require attendance of entities directly concerned with glass facade [including manufacturer's field representative].
- C. Review at meeting:

******* Add to and edit the following list to reflect project conditions. *******

1. Construction of foundation and preparation of rough opening to receive glass facade.
2. Schedule, sequence, and method for installing glass facade and coordination with other work.
3. Safety procedures.
4. Availability of system materials.
5. Chemical compatibility of metal framing, glass panels, sealants, and other glazing materials.
6. Protection of adjacent items and finishes.
7. Approved mock-up to be used a measure of acceptance.
8. Other items related to successful execution of work.

1.9 PRODUCT HANDLING

- A. Protect glass and other components during delivery, storage, and handling in accordance with manufacturer's instructions. Prevent edging chipping and other damage.
- B. Insulating glass units: Comply with fabricator's instructions for venting and sealing units exposed to substantial altitude changes.
- C. Do not store glass panels on site for extended time.

1.10 ENVIRONMENTAL REQUIREMENTS

- A. Do not install solvent curing sealants in enclosed building spaces without proper ventilation.
- B. During glazing, maintain [4 degrees C] minimum temperature.

1.11 WARRANTIES

- A. Provide under provisions of Section [-----] [-----] - Closeout Procedures:
 - 1. Manufacturer's 2 years warranty to cover design, fabrication, and materials against defects and failure to perform and remain watertight. Warranty to provide for replacement of defective components.
 - 2. Glass warranties:
 - a. 10 years warranty to cover replacement of insulating sealed glass units: in event of seal failure and interpane dusting, misting, and filming.
 - b. 5 years warranty to cover replacement of laminated glass units in event of delamination, edge separation, and blemishes.
 - 3. Installer's 5 years warranty to cover installation against defects and failure to perform and remain weather tight. Warranty to provide for required repairs.

PART 2 - PRODUCTS

2.1 ACCEPTABLE DESIGNER-MANUFACTURER

- A. Glass structure shall be designed and fabricated by **LAMGLAS** Skytec® Structural Glass, A.S.

- 1. Address: Kagithane Cad. Ugur Sk. No:48/1 Caglayan 34403
- 2. Phone: 0090 212 210 48 55 / Fax: 0090 212 222 10 67 .

3. Website: www.lamglas.com

- B. Requests to use design services and products of another manufacturer must be submitted in accordance with Section [-----] [-----] - Product Substitution Procedures.

2.2 GLASS PRODUCTS

******* Various glass types can be used for glass facades. Selection will be influenced by structural criteria, functional requirements, codes, aesthetics, and cost. Attributes such as visible and ultra violet light transmittance, U-value, shading coefficient, and solar heat gain coefficient will also influence glass types used for a specific project. Information and values for these attributes can be found in literature published by glass manufacturers.**

As previously noted, glass products can be specified in this section or in Section (.....) - Glazing with a reference in this section. Edit the following to indicate where glass is specified. *****

- A. Glass type and thickness shall be determined by glass facade manufacturer to accommodate Project design and performance requirements specified in Paragraph [1.4] [_____]. Types of glass shall [be as specified in Section [.....] [.....] - Glazing.] [include the following.]

******* If glass is being specified in this section, select types from the following paragraphs:**

- B. Primary glass products:

******* Clear, color tinted, reflective, and low-E glass products can be used to fabricate the tempered, laminated, and insulating glass panels typically used for glass facades. Select required primary glass products from the following, *******

1. Clear glass: Clear, transparent, flat, annealed, float glass, conforming to ASTM, EN, TSE , Quality
2. Color tinted glass: [Blue] [Light green] [Dark green] [Light gray] [Medium gray] [Dark gray] [Bronze] [_____] color tinted, annealed, float glass conforming to ASTM, EN, TSE Quality

******* Metallic oxide coatings can be deposited onto color tinted glass during production provide a reflective appearance and increase solar control. *******

3. Reflective coated tinted glass: [_____] color tinted float glass with metallic oxide coating deposited during production and conforming to ASTM, EN, TSE.

******* Low emissivity (low-E) glass products are produced by applying a neutral coating which blocks a significant percentage of solar energy and greatly improves energy efficiency. *******

4. Low emissivity (low-E) glass: Clear glass with neutral coating pyrolytically applied to improve thermal performance and reduce solar heat gain.

C. Fabricated glass panels:

****** Primary glass products can be heat treated to increase strength and resistance to thermal stress. There are two types of heat treatment - heat strengthened and fully tempered. Heat strengthened glass is approximately twice as strong as annealed glass of equal thickness. However, it does not qualify as safety glass. ******

1. Heat strengthened glass: Heat strengthened, annealed glass conforming to ASTM, EN, TSE .

******* Fully tempered glass is approximately four times as strong as annealed glass of equal thickness. Tempered glass does qualify as safety glass and tends to break into small cubical pieces. Fully tempered glass is used for most glass structures fabricated by LAMGLAS Skytec® Structural Glass, A.S. *******

2. Fully tempered glass: Heat strengthened safety glass complying with ASTM, EN, TSE .

******* Laminated glass is fabricated by bonding two or more glass panes with a transparent, flexible interlayer material. Laminated glass does qualify as safety glass. When broken, laminated glass tends to remain in place with glass particles adhered to interlayer. *******

3. Laminated glass: Fabricated by bonding two or more glass panes with transparent, flexible interlayer material in accordance with ASTM, EN, TSE. Laminated glass shall meet requirements of ANSI, EN, TSE to qualify as safety glass.

******* Insulating glass is fabricated using two glass panes, referred to as lites, separated by an air space with the interpane space purged with dry hermetic air and sealed. The air space provides insulation and reduces heat transfer as well as limiting condensation and sound transmission. *******

4. Insulating glass units: Fabricate insulating glass units with two lites separated by air space. Seal edge and purge interpane space with dry hermetic air. Comply with ASTM, EN, TSE.

******* For glass fin and tension truss glass facades glass is mechanical installed with stainless steel connectors and fittings. Mechanical attachment with fittings can also be used for installing glass panels directly to support substrate. These devices require accurately drilled holes in glass to receive fitting pins. Holes must be drilled prior to tempering glass panels. Include this paragraph if mechanically installed glass panels are required. *******

- D. For glass panels to be installed with mechanical connectors and fittings, provide holes to receive bolts and fitting pins. Holes shall be drilled prior to tempering glass.

2.3 METAL SUPPORT FRAMING

******* Glass panels and doors can be supported and framed with metal framing such as aluminum, steel, stainless steel, and bronze. Material selection can be made by design professional in conjunction with LAMGLAS Skytec® Structural Glass, A.S. or determination can be delegated to manufacturer. Resilient gaskets are typically used for glazing. This article can be used as a format to be edited and completed to specify metal support framing. Contact LAMGLAS Skytec® Structural Glass, A.S. for assistance in planning, designing, selecting options, and detailing custom metal support framing. *******

- A. Framing sections: Provide metal perimeter framing to support glass panels [and doors] as detailed on Drawings and approved shop drawings.

******* Tubular or solid sections and either cold-formed, extruded, and hot-rolled members can be used as framing. Various finishes are also available. Edit the following paragraph to indicated type of metal support framing. *******

- B. Material: [Cold-formed from low carbon, hot dipped galvanized steel complying with TSE and finished with [electrostatically applied powder paint coating] [____].]
*** [Cold-formed from stainless steel complying with TSE Type 304 with [brushed satin finish] [reflective polished finish] [____].] *** [Cold-formed from bronze alloy sheet complying with TSE with [brushed satin finish] [reflective polished finish] [____].] *** [Extruded aluminum complying with TSE with [[clear] [bronze] [black] anodized finish.] [fluoropolymer colored paint coating[____].]]
*** [Hot rolled solid steel shapes with integral glazing flanges with [electrostatically applied powder paint coating] [____].]
- C. Material minimum thickness: As determined by manufacturer to meet performance requirements specified in Paragraph [1.4] [____].
- D. Size, shape, and configuration: [As indicated on Drawings and approved shop drawings.] [As designed by manufacturer to efficiently frame glass structure and meet design criteria specified in Paragraph [1.4] [____].]
- E. Corner joints: [Coped, mechanically fastened, and sealed to prevent water leakage.] [Mitered, welded, and finished smooth and flush with adjacent surfaces.]
- F. Glazing beads: Cold formed metal applied from interior or exterior, and designed for snap-in installation.

2.4 TENSION TRUSS SUPPORTS

******* One method of supporting the glass facade is with tension trusses installed perpendicular to the glass surface. These trusses can be placed vertically, horizontally, or**

in a combination of vertical and horizontal members. Include this article if tension truss supports are to be used for glass facade. *****

A. Support glass facade with tension trusses consisting of:

******* Tension members can be either stainless steel rope (cable) or stainless steel rods. *******

1. Tension members: [Stainless steel wire rope.] [Stainless steel solid rods complying with TSE with [brushed satin finish.] [reflective polished finish.]] Type, diameter, tensile strength determined by manufacturer to meet design criteria specified in Paragraph [1.4] [_____].
 2. Hardware: Provide connectors, turnbuckles, studs, and other hardware as shown on approved shop drawings and as required for fabrication of tension trusses.
 3. Tubing: Stainless steel complying with TSE with [brushed satin finish.] [reflective polished finish.]
 4. Fittings to join glass panels to tension trusses: Stainless steel complying with TSE with [brushed satin finish.] [reflective polished finish.]
- B. Placement: Trusses shall be installed perpendicular to glass surface and extend [vertically] [and] [horizontally] between supports.
- C. Truss configuration, dimensions, spacing, and component sizes: As designed by manufacturer and indicated on shop drawings to efficiently support glass structure and meet performance criteria specified in Paragraph [1.4] [_____].

2.5 FITTINGS

******* LAMGLAS Skytec® Structural Glass, A.S. designs and fabricates a broad range of stainless steel fittings for connecting glass panels together and to metal, concrete, masonry, and other support systems and substrates. It is important that fittings be designed for specific project conditions and loadings and be provided by entity responsible for glass facade design. Stresses induced in glass panels by fittings must be compatible with glass strength LAMGLAS Skytec® Structural Glass fittings have been independently tested to ensure quality and structural performance. *******

- A. Provide structurally engineered and independently tested fittings for connecting glass panels together and for attachment to supporting substrates.
- B. Material: Stainless steel complying with TSE , Type 316 with [brushed satin finish] [reflective polished finish].]
- C. Types: Configuration, number of points, size, and spacing shall be determined by manufacturer and scheduled on shop drawings to accommodate project design and

meet performance criteria specified in Paragraph [1.4] [_____]. Ensure that fitting-induced stresses do not exceed glass strength.

- D. Providing fittings with countersunk stainless steel bolts, Delrin bushings, and resilient gaskets.

2.6 DOOR ASSEMBLIES

***** **LAMGLAS Skytec® Structural Glass, A.S. can design and custom fabricate all-glass and metal framed full glazed, swinging, doors. In addition revolving, horizontal sliding, and other types of door assemblies manufactured by other companies can be provided to insert in glass entrances and storefronts. Contact LAMGLAS Skytec® Structural Glass, A.S. for assistance in planning, designing, selecting options, and detailing door assemblies. *******

- A. Provide complete entry door assemblies including door panels, frames, and hardware for locations indicated on Drawings.
- B. Type: [Swinging, full glazed doors fabricated from cold formed [aluminum] [steel] [stainless steel] [bronze] sections.] *** [Center pivoted, fully tempered, all-glass doors.] *** [Automatic [horizontal sliding] [swinging] door assemblies specified in Section [08 42 30] [08460] - Automatic Entrance Doors.] *** [Revolving door assemblies specified in Section [08 42 33] [08470] - Revolving Entrance Doors.]
- C. Size, shape, and configuration: As indicated on Drawings and approved shop drawings.

***** **Door hardware can be specified in this section or in Section ----- (-----) - Door Hardware with a reference in this section. *******

- D. Hardware: [As specified in Section [08 71 00] [08710] - Door Hardware.] [Provided as part of [automatic] [revolving] door assembly.]

***** **If hardware is specified in this section, list items and indicated type required. Consult LAMGLAS Skytec® Structural Glass, A.S. for specific door hardware recommendations. *******

1. Hinges: [Full mortise, ball bearing, hinge. Provide [3] [_____] hinges per door leaf] [Continuous geared hinge] [_____].
2. Pivots: [_____].
3. Lockset: [_____].
4. Exit device: [_____].

5. Closer: [_____].
6. Threshold: [_____].
7. Weatherstripping: [_____].
8. [_____].

2.7 ACCESSORIES

- A. Provide glazing accessories, anchors, and fasteners of type recommended by glass facade manufacturer and as required for complete, functional, weathertight installation.
- B. Anchorage devices: Clips, anchors, fasteners, and shims required for secure installation of glass facade. Type, size, and spacing as recommended by glass facade manufacturer.
- C. Cleaners and primers: Recommended by manufacturer to be compatible with substrate and glazing materials.
- D. Setting blocks: Neoprene or EPDM complying with ASTM, EN, TSE .
- E. Edge blocks: Elastomeric material of hardness required to limit lateral movement of glass.
- F. Gaskets: Molded or extruded elastomeric type of profile and hardness required to maintain weathertight seal and complying with ASTM, EN, TSE.
- G. Glazing tape: Preformed butyl compound, non-staining, non-migrating in contact with non-porous surfaces, coiled on release paper, complying with ASTM, EN, TSE.
- H. Glazing sealant: Chemically curing type complying with ASTM, EN, TSE, compatible with materials and conditions, and capable of anticipated joint movement without watertight seal failure.
- I. Contact structural sealant: High performance, two component, non-sag, neutral cure, ultraviolet resistant, silicone sealant designed for structural glazing and complying with ASTM, EN, TSE.

PART 3 - EXECUTION

******* Edit this article to reflect type of glass facade and components being installed. Delete non-applicable items and requirements. *******

3.1 COORDINATION

- A. Coordinate provision of glass facade with casting of concrete [footings] [floor slabs] [walls] [structural framing] specified in Section [-----] [-----] - Cast-in-Place Concrete. Ensure that [sleeves,] [inserts,] [anchor bolts,] [reglets,] [_____] and other embedded items are provided in sufficient time for embedment in cast concrete. Ensure that blockouts and pockets for glass facade components are provided, accurately placed, and properly sized.
- B. Coordinate provision of glass facade with structural framing specified in [Section [--- ---] [-----] - Precast Concrete] [Section [-----] [-----] - Masonry Assemblies.] [Section [-----] [-----] - Structural Steel.] Ensure that provision is made for attachments and transfer of calculated loads.

******* Include the following paragraph if electrically operated door assemblies, glass facade illumination, signage, or other electrical systems are being installed in conjunction with glass facade. *******

- C. Coordinate electrical requirements for [automatic door assemblies] facade illumination] [signage] [_____] to ensure proper power source, conduit, wiring, and boxes.
- D. Field verify dimensions prior to fabricating glass facade components.

3.2 INSPECTION

- A. Prior to delivery of glass panels to site, verify that wall openings, support framing, and substrates are ready to receive glass facade. Verify alignment, support dimensions, and tolerances are correct.
- B. Report unacceptable conditions and deficiencies. Do not proceed with installation until corrective action has been performed.
- C. Inspect glass panels for chipped edges, scratches, abrasions, and other damage. Remove damaged panels from site and replace.

3.3 GENERAL INSTALLATION

- A. Site assemble and erect glass facade in accordance with approved shop drawings, manufacturer's installation instructions, and GANA Glazing Manual.
- B. Damaged glass: Do not install glass with edge damage or other imperfections.
- C. Allow for settling, expanding, and contracting to occur without breaking glass.
- D. Do not field cut or alter structural framing without written approval from manufacturer and Architect.

3.4 METAL FRAMING

******* Include this article if glass panels are installed with metal perimeter support framing. *******

- A. Use anchorage devices to securely attach metal framing to structure and to accommodate construction tolerances and irregularities.
- B. Insulate dissimilar metals to prevent electrolysis and other forms of corrosion with bituminous paint or non-absorptive gasket to prevent contact.
- C. Align framing plumb, level, and free of warp or twist.

3.5 GLAZING

******* If several types and thicknesses of glass are required for glass facade, a glazing schedule either in this section or on drawings may be required. *******

- A. Glazing schedule: Install types and thickness of glass in locations scheduled [below] [on Drawings] [on approved shop drawings].
 - 1. Type 1: [thickness], [glass type], [color tint] glass installed in [location].
 - 2. Type 2: [thickness], [glass type], [color tint] glass installed in [location].
- B. Protect adjacent surfaces sealants and glazing materials with masking tape or other means.
- C. Install setting blocks and spacers as recommended by glass facade manufacturer and indicated on approved shop drawings.
 - 1. Place setting blocks at quarter points. Maintain [6 inches] [152 mm] space from corners.
 - 2. Set blocks in sealant.
- D. Provide edge blocking as required to prevent sideways movement of glass in glazing channel.
- E. Ensure glazing channels and stops provide required bite on glass, minimum edge and face clearances, and adequate sealant thickness.

******* Various glazing methods can be used depending on type of glass facade. Typical methods are tape glazing, gasket glazing, wet sealant glazing, and structural sealant glazing. Glazing methods can be selected and specified by editing the following options or methods can be determined by glass facade manufacturer. *******

- F. Glazing methods: [Type as determined by manufacturer and indicated on approved shop drawings.] [Use the following methods for applications indicated on Drawings.]
1. Tape glazing:
 - a. Cut glazing tape to length and set continuously against permanent stops and projecting slightly above sightline.
 - b. Tape joints: Butt joints. Do not overlap tape. Seal joints with compatible sealant.
 - c. Rest glass on setting blocks and push against tape for full contact at perimeter of lite.
 - d. Remove tape release paper immediately prior to placing glass.
 - e. Install compressible gasket against glass and secure with removable glazing stop.
 - f. Knife trim protruding edge of glazing tape.
 2. Gasket glazing:
 - a. Fabricate two piece compression gaskets to exactly fit openings.
 - b. Install soft compression gasket against permanent stops. Miter cut and bond together corners.
 - c. Rest glass on setting blocks. Insert dense compression gasket to press glass against soft gasket and lock in place against removable stop.
 - d. Apply sealant to gasket joints.
 - e. Install gaskets to protrude slightly beyond glazing stops.
 3. Wet sealant glazing:
 - a. Install spacers and sealant backing between glass and stops. Position to control depth and width of sealant.
 - b. Apply sealant to glazing channels without voids. Ensure complete bond of sealant to glass and channel surfaces.
 - c. Tool exposed sealant surfaces to provide wash away from glass.

4. Structural silicone glazing: Use for [butt glass joints] [adhering panels directly to metal support framing such that framing members are not visible from exterior].
 - a. Cleaning: Thoroughly clean all joints and glazing areas immediately prior to sealant application. Remove oil, dust, grease, water, surface dirt, contaminants, and other foreign matter. Vacuum or blow out dust and loose particles from joints. Do not use water cleaning treatments.
 - b. Use primers only as recommended by sealant manufacturer. Field test with and without primer before actual application.
 - c. Mask areas adjacent to joints to insure neat sealant line. Do not allow tape to touch surfaces to which sealant will be applied.
 - d. Install sealant back-up spacers as indicated on Drawings and approved shop drawings.
 - e. Apply silicone structural sealant in continuous operation. Tool sealant immediate before skin forms. Tool concave to ensure complete contact.
 - f. Post application test: After structural sealant has cured 14 to 21 days, conduct field test as prescribed by manufacturer to test sealant adhesion. Replace sealant not passing test.

3.6 MECHANICAL ASSEMBLED GLASS UNITS

******* In addition to tape, gasket, and sealant type glazing, glass panels can be mechanically attached to each other and to supporting structure with stainless fittings. Glass fin and tension truss glass structures require mechanical connections with fittings. Include this article if glass panels are to be mechanically installed with fittings. *******

- A. Mechanically install glass facade panels with stainless steel fittings as designed by manufacturer and indicated on approved shop drawings.
- B. Glass fins: Mechanically join glass fins to facade panels with connector fittings to provide stabilization and support.
- C. Tension trusses: Tension truss members shall be mechanically joined to multiple glass panels to provide structural support and bracing.
- D. Glass panels shall be mechanically attached directly to supporting substrate with fittings and anchors.
- E. Secure glass panels to fittings with bolts. Torque bolt to amount specified on approved shop drawings using calibrated tool. Lock torqued bolt into position to prevent backoff. Reset calibrations regularly to ensure accurate torquing.

3.7 DOOR ASSEMBLIES

******* Edit this article to reflect type of door assembly being provided. Delete non-applicable items. *******

- A. [Install swinging door assemblies in accordance with manufacturer's instructions and approved shop drawings.] *** [Install automatic [horizontal sliding] [swinging] door assemblies in accordance with Section [-----] [-----] - Automatic Entrance Doors.] *** [Install revolving door assemblies in accordance with Section [-----] [-----] - Revolving Entrance Doors.]
- B. Placing [frames] [assemblies]: Center in opening, plumb, square and level and secure with manufacturer recommended anchors. Provide alignment attachments and shims required to fasten system to structure. Align assembly plumb and level, free of warp or twist. Use anchorage devices to securely attach frame assembly to structure. Seal joints around frames.
- C. Hardware: Install door hardware in accordance with Section [-----] [-----] - Door Hardware. Ensure gaskets and weather-stripping are provided for all exterior openings.
- D. Door installation: Fit doors accurately in frames in accordance industry standard clearances. Adjust hardware for smooth operation.
- E. After installation, test each assembly. [Cycle automatic door assemblies through all required functions. Verify speed, operation, and controls.]
- F. Correct deficiencies and make necessary adjustments and modifications. Retest.
- G. Demonstrate operation and maintenance of automatic door assemblies to Owner's representatives.

3.8 CLEANING

- A. Clean excess sealant from glass and other surfaces immediately after application. Use solvents or other cleaners recommended by manufacturer.
- B. Remove protective material from prefinished surfaces.
- C. Wash exposed surfaces using a solution of mild detergent in warm water, applied with soft, clean cloths. Do not use abrasives. Take care to remove dirt from corners. Wipe surfaces clean.

END OF SECTION