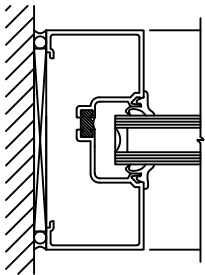
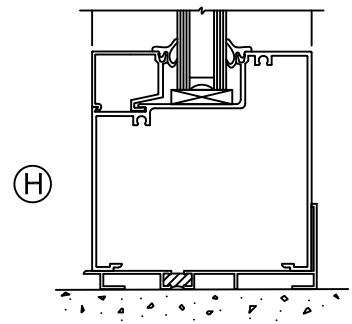
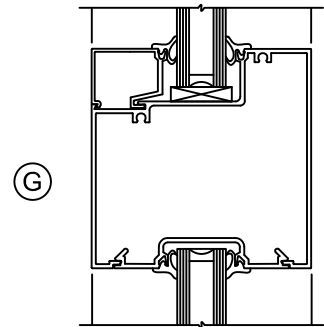
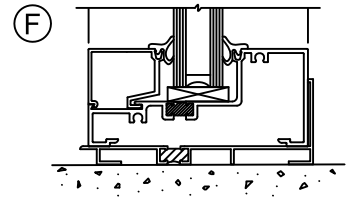
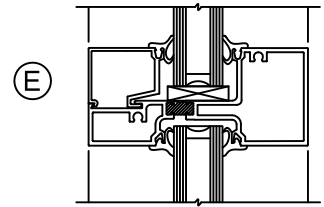
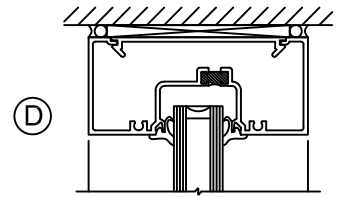
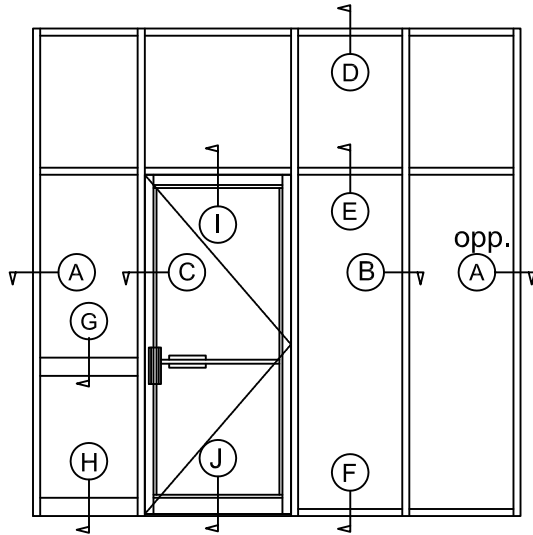


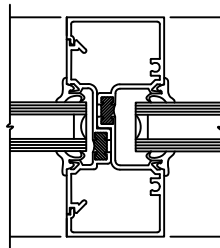
SERIES 4600

2" X 4-1/2" THERMAL FLUSHGLAZED FOR 1" GLAZING

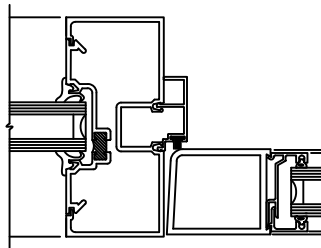
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ELEVATIONS:	2
JAMBS:	3
HORIZONTALS:	4
ALT. HORIZONTALS:	5
TRANSOM BARS:	6
CORNER POSTS:	7
SPECIFICATIONS & DESIGN DATA:	8



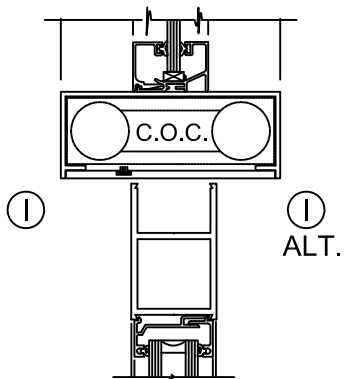
A



B

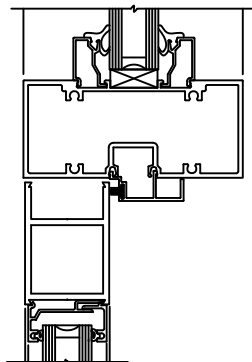


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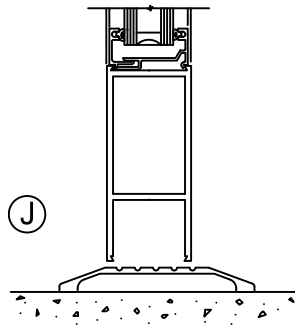


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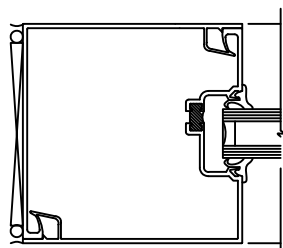
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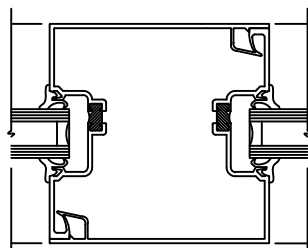
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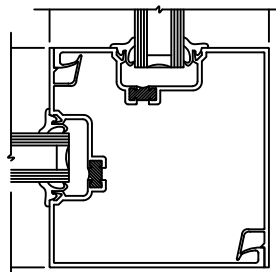
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K



L

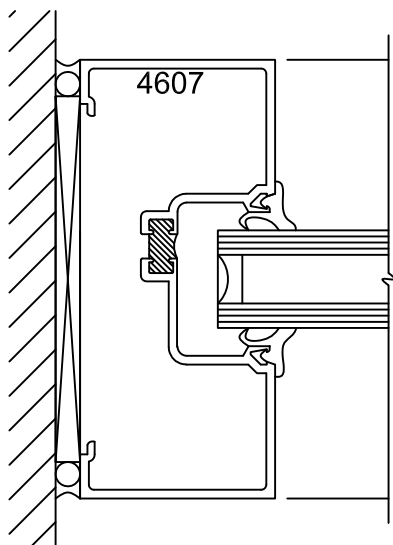


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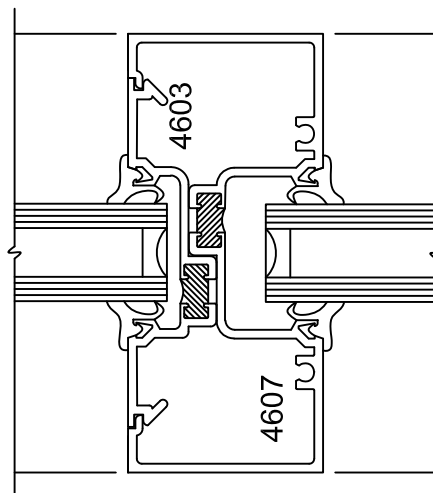


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10 TRACY DRIVE- AVON, MA. 02322

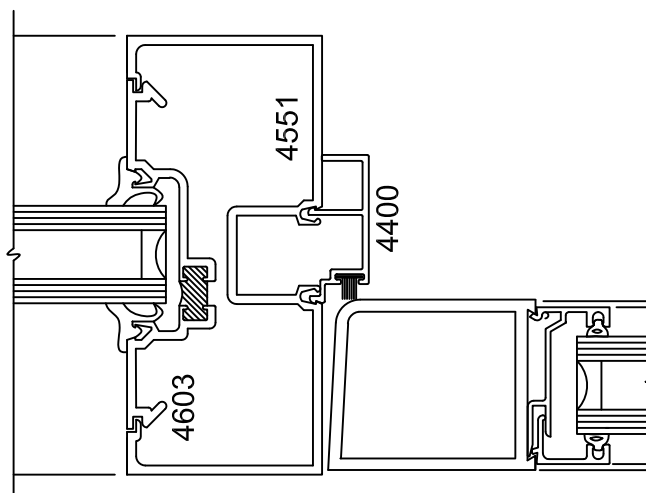
**SERIES
4600
Full size details**



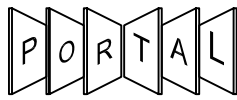
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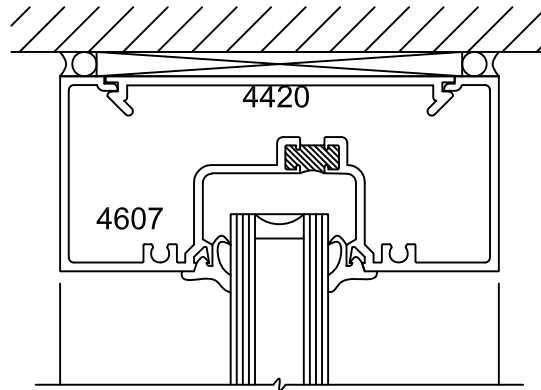
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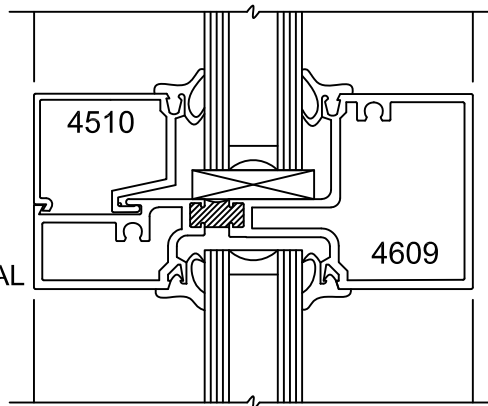
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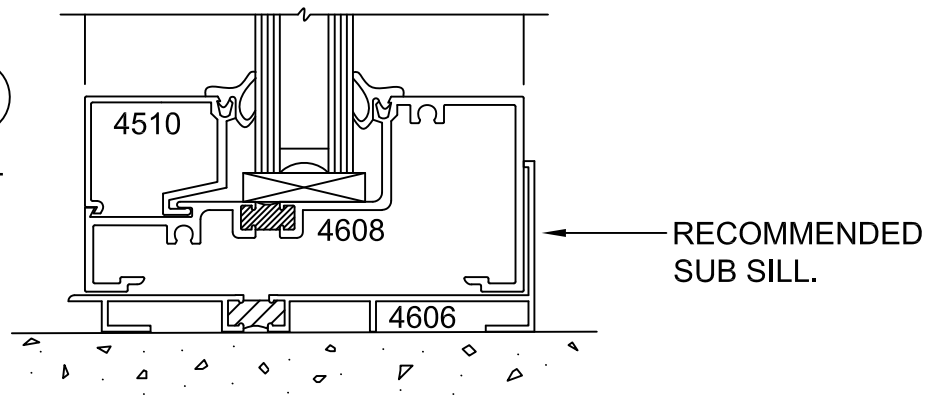
(D)
HEAD

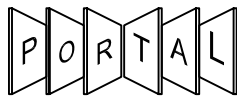


(E)
HORIZONTAL



(F)
SILL

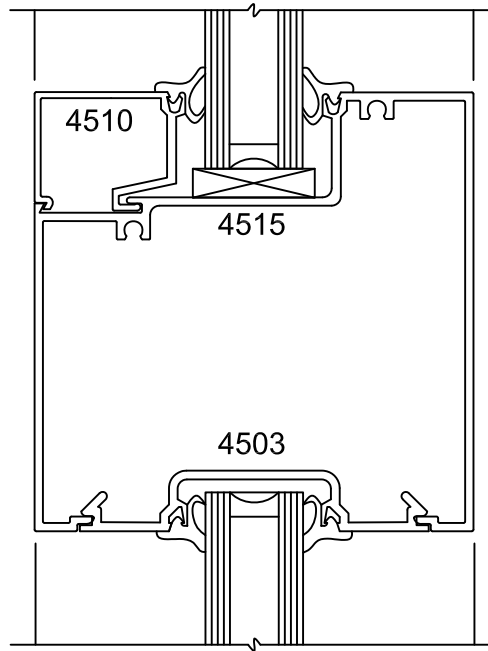




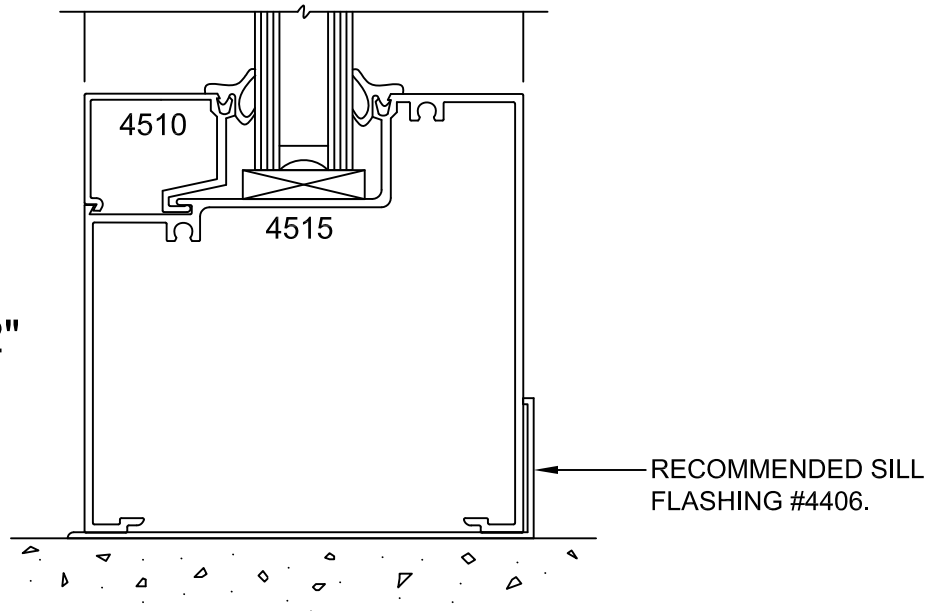
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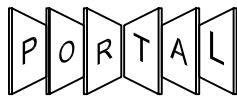
**SERIES
4600
Full size details**

(G)
4-1/2" X 4-1/2"
HORIZONTAL



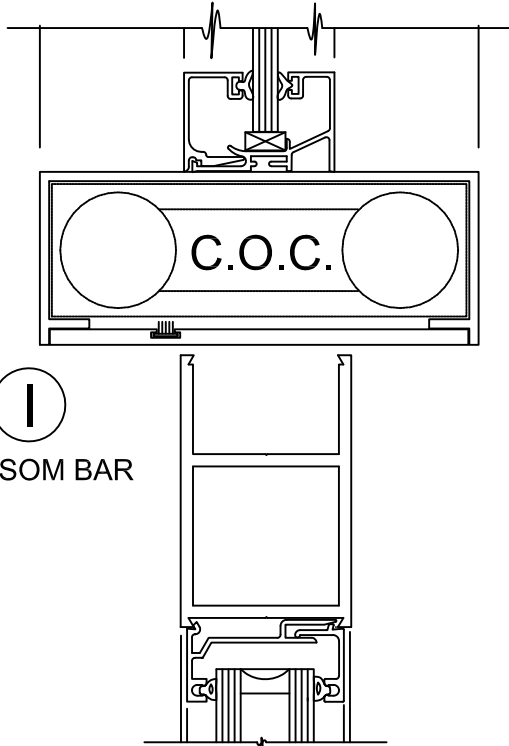
(H)
4-1/2" X 4-1/2"
SILL



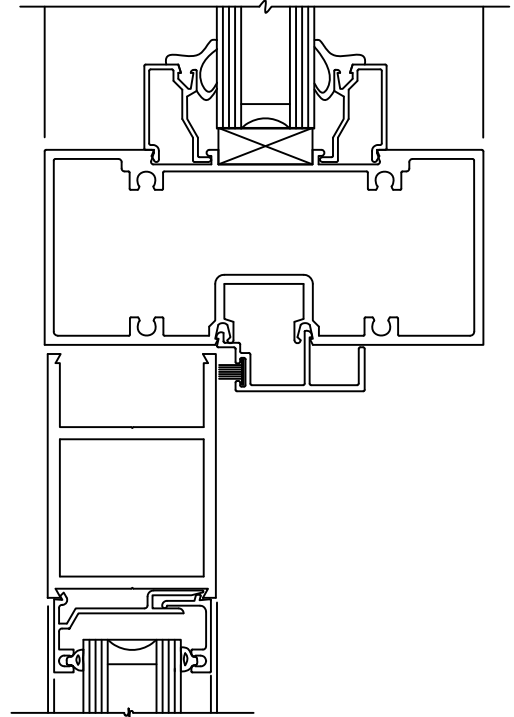


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**SERIES
4600
Full size details**

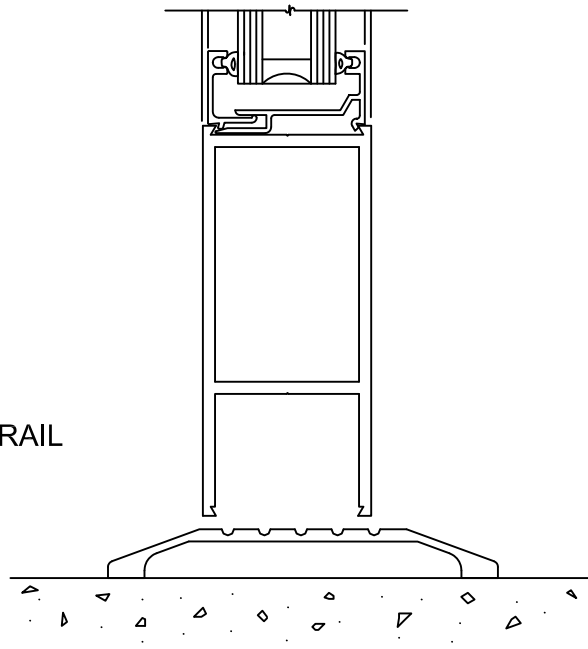


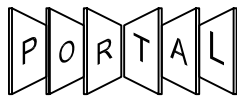
I
TRANSOM BAR



I
ALT.
TRANSOM BAR

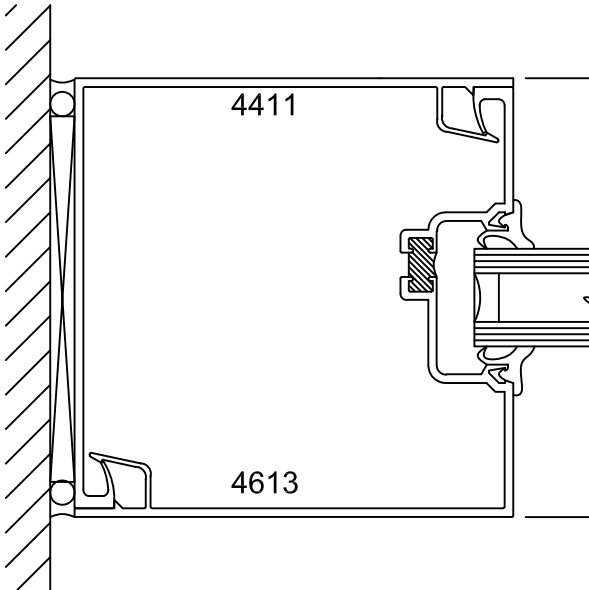
J
BOTTOM RAIL





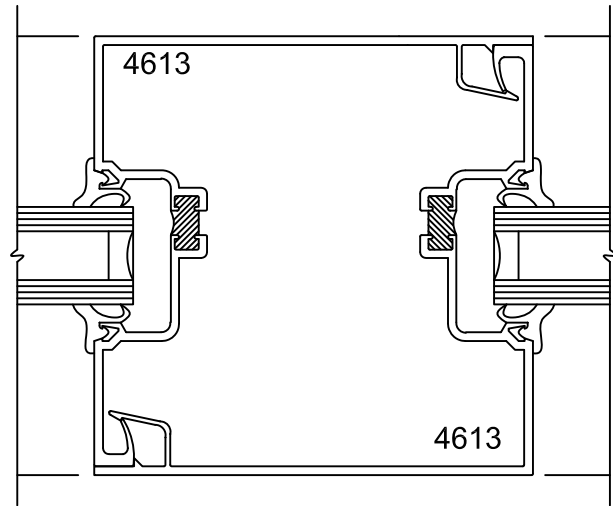
PORTAL INC.
10 TRACY DRIVE- AVON, MA. 02322

**SERIES
4600
Full size details**



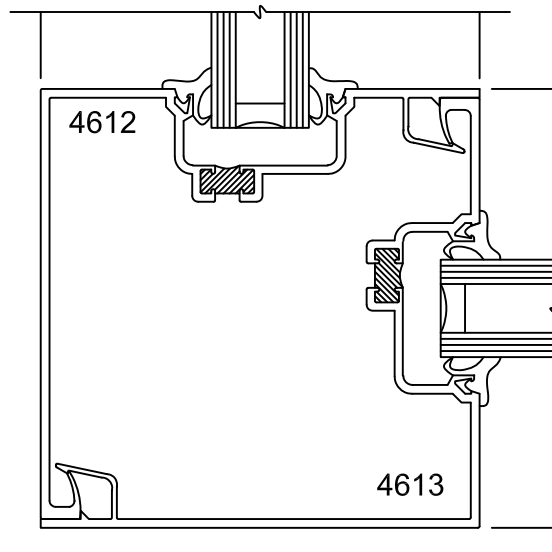
(K)

4-1/2" X 4-1/2" JAMB



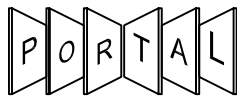
(L)

4-1/2" X 4-1/2" MULLION



(M)

4-1/2" X 4-1/2" CORNER



SPECIFICATIONS

SERIES 4600

1" THERMAL FLUSH GLAZING SYSTEM

1. GENERAL

DESCRIPTION:

WORK INCLUDED: Furnish all necessary materials, labor and equipment for the complete installation of aluminum framing as shown on the drawings and herein specified.

WORK NOT INCLUDED: Non-integrated structural support of the framing system, adjoining interior and / or exterior trim or flashing.

RELATED WORK SPECIFIED ELSEWHERE

QUALITY ASSURANCE:

Drawings and specifications are based on series #4600 as manufactured by Portal, Inc. Whenever substitute products are to be considered, supporting technical literature, samples, drawings and performance data shall be submitted for comparison prior bid date.

PERFORMANCE:

air infiltration shall be tested in accordance with ASTM 283, infiltration shall not exceed .06 CFM per square foot of fixed area. Water infiltration shall be tested in accordance with ASTM E 331. No water shall penetrate at test pressure of 6.25 PSF.

Structural performance shall be based on a maximum deflection of $\frac{1}{175}$ of the span when subjected to windload of 25 PSF.

2. PRODUCTS

MATERIALS:

Extrusions shall be of 6063 T5 aluminum alloy and temper per (ASTM B221 alloy G.S. 10A-T5) Exposed fasteners shall be aluminum, stainless steel or zinc plated steel in accordance with ASTM A164. Perimeter anchors shall be aluminum or steel properly isolated from the aluminum. Glazing Gaskets shall be either EPDM elastomeric or vinyl extrusions.

FINISH:

All exposed framing surfaces shall be free from scratches or other serious blemishes. Aluminum shall be given a caustic etch followed by an anodic oxide treatment to obtain (specify one of the following);

- . an architectural class 1 anodic coating conforming to Aluminum Association standard AA-M12 C22 A44 Dark bronze
- or
- . a #100 clear anodic coating conforming to Aluminum Association standard AA-M12 C22 A31.

FABRICATION:

Horizontal heads, sills and intermediates shall be cut between two-piece interlocking vertical mullions and fastened to them with stainless steel screws into integral screw grooves in a concealed manner. One-piece vertical mullions shall have concealed shear blocks attached, to support horizontals when so specified. All cuts shall be made smooth square and true. Glazing beads shall snap in place and be flush. Nominal dimensions of framing members shall have a 1-3/4" face and depth of 4-1/2" with $\frac{5}{8}$ " wide glazing pockets for $\frac{1}{4}$ " glass.

3. EXECUTION

INSTALLATION:

All framing for glass shall be set in locations as shown in the details and shall be level, plumb, square and in alignment with other work in accordance with the manufacturers installation instructions and/or approved shop drawings. All joints between the framing and the building shall be securely sealed for a watertight installation.

PROTECTION:

After installation, the general contractor shall adequately protect exposed aluminum surfaces from damage by grinding and polishing compounds, plaster, lime, acid cement or other contaminants. The general contractor shall be responsible for final cleaning.