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**SECTION 05 50 00  
METAL FABRICATIONS**

**PART 1 - GENERAL**

**1.1 DESCRIPTION**

- A. This section specifies items and assemblies fabricated from structural steel shapes and other materials as shown and specified.
- B. Items specified.
1. Support for Wall and Ceiling Mounted Items: (SD055000-01, SD055000-02, SD102113-01, SD102600-01, SD123100-01 & SD123100-02)
  2. Frames
  3. Loose Lintels
  4. Safety Nosings
  5. Ladders
  6. Railings:
  7. Steel Pipe Bollards - See Civil

**1.2 RELATED WORK**

- A. Railings attached to steel stairs: Section 05 51 00, METAL STAIRS.
- B. Colors, finishes, and textures: Section 09 06 00, SCHEDULE FOR FINISHES.
- C. Prime and finish painting: Section 09 91 00, PAINTING.

**1.3 SUBMITTALS**

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Manufacturer's Literature and Data:

Steel frames	Loose Lintels
Ladders	Railings
Steel Bollards- See Civil	
Manhole Covers- See Civil	Safety nosing

- C. Shop Drawings:

1. Each item specified, showing complete detail, location in the project, material and size of components, method of joining various components and assemblies, finish, and location, size and type of anchors.

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2. Mark items requiring field assembly for erection identification and furnish erection drawings and instructions.
3. Provide templates and rough-in measurements as required.
- D. Manufacturer's Certificates:
  1. Anodized finish as specified.
  2. Live load designs as specified.
- E. Design Calculations for specified live loads including dead loads.
  1. Manufacturer shall provide calculations and drawings with Engineer's Stamp documenting the supplied products comply with loading requirements as indicated or per Code requirements.
- F. Furnish setting drawings and instructions for installation of anchors to be preset into concrete and masonry work, and for the positioning of items having anchors to be built into concrete or masonry construction.

#### **1.4 QUALITY ASSURANCE**

- A. Each manufactured product shall meet, as a minimum, the requirements specified, and shall be a standard commercial product of a manufacturer regularly presently manufacturing items of type specified.
- B. Each product type shall be the same and be made by the same manufacturer.
- C. Assembled product to the greatest extent possible before delivery to the site.
- D. Include additional features, which are not specifically prohibited by this specification, but which are a part of the manufacturer's standard commercial product.

#### **1.5 APPLICABLE PUBLICATIONS**

- A. The publications listed below form a part of this specification to the extent referenced. The publications are referenced in the text by the basic designation only.
- B. American Society of Mechanical Engineers (ASME):  
B18.6.1-97.....Wood Screws  
B18.2.2-87(R2010).....Square and Hex Nuts
- C. American Society for Testing and Materials (ASTM):  
A36/A36M-14.....Structural Steel  
A47-99(R2014).....Malleable Iron Castings  
A48-03(R2012).....Gray Iron Castings  
A53-12.....Pipe, Steel, Black and Hot-Dipped, Zinc-Coated  
Welded and Seamless

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DESIGN NEW EMERGENCY DEPARTMENT  
VA PROJECT NO. 528-809

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- A123-15.....Zinc (Hot-Dip Galvanized) Coatings on Iron and  
Steel Products
- A240/A240M-15.....Standard Specification for Chromium and  
Chromium-Nickel Stainless Steel Plate, Sheet  
and Strip for Pressure Vessels and for General  
Applications.
- A307-14.....Carbon Steel Bolts and Studs, 60,000 PSI  
Tensile Strength
- A391/A391M-07(R2015)....Grade 80 Alloy Steel Chain
- A786/A786M-15.....Rolled Steel Floor Plate
- C1107-13.....Packaged Dry, Hydraulic-Cement Grout  
(Nonshrink)
- F436-16.....Hardened Steel Washers
- F468-06(R2015).....Nonferrous Bolts, Hex Cap Screws, Socket Head  
Cap Screws and Studs for General Use
- F593-13.....Stainless Steel Bolts, Hex Cap Screws, and  
Studs
- F1667-15.....Driven Fasteners: Nails, Spikes and Staples
- D. American Welding Society (AWS):
- D1.1-15.....Structural Welding Code Steel
- D1.2-14.....Structural Welding Code Aluminum
- D1.3-18.....Structural Welding Code Sheet Steel
- E. National Association of Architectural Metal Manufacturers (NAAMM)
- AMP 521-01(R2012).....Pipe Railing Manual
- AMP 500-06.....Metal Finishes Manual
- MBG 531-09(R2017).....Metal Bar Grating Manual
- MBG 532-09.....Heavy Duty Metal Bar Grating Manual
- F. Structural Steel Painting Council (SSPC)/Society of Protective  
Coatings:
- SP 1-15.....No. 1, Solvent Cleaning
- SP 2-04.....No. 2, Hand Tool Cleaning
- SP 3-04.....No. 3, Power Tool Cleaning
- G. Federal Specifications (Fed. Spec):
- RR-T-650E.....Treads, Metallic and Nonmetallic, Nonskid

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**PART 2 - PRODUCTS**

**2.1 DESIGN CRITERIA**

- A. 1. Manufacturer shall provide calculations and drawings with Engineer's Stamp documenting the supplied products comply with loading requirements as indicated or per Code requirements.
- B. In addition to the dead loads, design fabrications to support the following live loads unless otherwise specified.
- C. Ladders and Rungs: 120 kg (250 pounds) at any point.
- D. Railings and Handrails: 900 N (200 pounds) in any direction at any point.

**2.2 MATERIALS**

- A. Structural Steel: ASTM A36.
- C. Aluminum, Extruded: ASTM B221, Alloy 6063-T5 unless otherwise specified. For structural shapes use alloy 6061-T6 and alloy 6061-T4511.
- E. Steel Pipe (Bollard): ASTM A53.
  - 1. Galvanized for exterior locations.
  - 2. Type S, Grade A unless specified otherwise.
  - 3. NPS (inside diameter) as shown.
- F. Cast-Iron: ASTM A48, Class 30, commercial pattern.
- G. Malleable Iron Castings: A47.
- H. Primer Paint: As specified in Section 09 91 00, PAINTING.
- I. Stainless Steel Tubing: ASTM A269, type 302 or 304.
- J. Modular Channel Units:
  - 1. Factory fabricated, channel shaped, cold formed sheet steel shapes, complete with fittings bolts and nuts required for assembly.
  - 2. Form channel within turned pyramid shaped clamping ridges on each side.
  - 3. Provide case hardened steel nuts with serrated grooves in the top edges designed to be inserted in the channel at any point and be given a quarter turn so as to engage the channel clamping ridges. Provide each nut with a spring designed to hold the nut in place.
  - 4. Factory finish channels and parts with oven baked primer when exposed to view. Channels fabricated of ASTM A525, G90 galvanized steel may have primer omitted in concealed locations. Finish screws and nuts with zinc coating.

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5. Fabricate snap-in closure plates to fit and close exposed channel openings of not more than 0.3 mm (0.0125 inch) thick stainless steel.

K. Grout: ASTM C1107, pourable type.

## **2.3 HARDWARE**

### **A. Rough Hardware:**

1. Furnish rough hardware with a standard plating, applied after punching, forming and assembly of parts; galvanized, cadmium plated, or zinc-coated by electro-galvanizing process. Galvanized G-90 where specified.
2. Use G90 galvanized coating on ferrous metal for exterior work unless non-ferrous metal or stainless is used.

### **B. Fasteners:**

1. Bolts with Nuts:
  - a. ASME B18.2.2.
  - b. ASTM A307 for 415 MPa (60,000 psi) tensile strength bolts.
  - c. ASTM F468 for nonferrous bolts.
  - d. ASTM F593 for stainless steel.
2. Screws: ASME B18.6.1.
3. Washers: ASTM F436, type to suit material and anchorage.
4. Nails: ASTM F1667, Type I, style 6 or 14 for finish work.

## **2.4 FABRICATION GENERAL**

### **A. Material**

1. Use material as specified. Use material of commercial quality and suitable for intended purpose for material that is not named or its standard of quality not specified.
2. Use material free of defects which could affect the appearance or service ability of the finished product.

### **B. Size:**

1. Size and thickness of members as shown.
2. When size and thickness is not specified or shown for an individual part, use size and thickness not less than that used for the same component on similar standard commercial items or in accordance with established shop methods.

### **C. Connections**

1. Except as otherwise specified, connections may be made by welding, riveting or bolting.

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2. Field riveting will not be approved.
3. Design size, number and placement of fasteners, to develop a joint strength of not less than the design value.
4. Holes, for rivets and bolts: Accurately punched or drilled and burrs removed.
5. Size and shape welds to develop the full design strength of the parts connected by welds and to transmit imposed stresses without permanent deformation or failure when subject to service loadings.
6. Use Rivets and bolts of material selected to prevent corrosion (electrolysis) at bimetallic contacts. Plated or coated material will not be approved.
7. Use stainless steel connectors for removable members machine screws or bolts.

D. Fasteners and Anchors

1. Use methods for fastening or anchoring metal fabrications to building construction as shown or specified.
2. Where fasteners and anchors are not shown, design the type, size, location and spacing to resist the loads imposed without deformation of the members or causing failure of the anchor or fastener, and suit the sequence of installation.
3. Use material and finish of the fasteners compatible with the kinds of materials which are fastened together and their location in the finished work.
4. Fasteners for securing metal fabrications to new construction only, may be by use of threaded or wedge type inserts or by anchors for welding to the metal fabrication for installation before the concrete is placed or as masonry is laid.
5. Fasteners for securing metal fabrication to existing construction or new construction may be expansion bolts, toggle bolts, power actuated drive pins, welding, self-drilling and tapping screws or bolts.

E. Workmanship

1. General:
  - a. Fabricate items to design shown.
  - b. Furnish members in longest lengths commercially available within the limits shown and specified.

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- c. Fabricate straight, true, free from warp and twist, and where applicable square and in same plane.
  - d. Provide holes, sinkages and reinforcement shown and required for fasteners and anchorage items.
  - e. Provide openings, cut-outs, and tapped holes for attachment and clearances required for work of other trades.
  - f. Prepare members for the installation and fitting of hardware.
  - g. Fabricate surfaces and edges free from sharp edges, burrs and projections which may cause injury.
2. Welding:
- a. Weld in accordance with AWS.
  - b. Welds shall show good fusion, be free from cracks and porosity and accomplish secure and rigid joints in proper alignment.
  - c. Where exposed in the finished work, continuous weld for the full length of the members joined and have depressed areas filled and protruding welds finished smooth and flush with adjacent surfaces.
  - d. Finish welded joints to match finish of adjacent surface.
3. Joining:
- a. Miter or butt members at corners.
  - b. Where frames members are butted at corners, cut leg of frame member perpendicular to surface, as required for clearance.
4. Anchors:
- a. Where metal fabrications are shown to be preset in concrete, weld 32 x 3 mm (1-1/4 by 1/8 inch) steel strap anchors, 150 mm (6 inches) long with 25 mm (one inch) hooked end, to back of member at 600 mm (2 feet) on center, unless otherwise shown.
  - b. Where metal fabrications are shown to be built into masonry use 32 x 3 mm (1-1/4 by 1/8 inch) steel strap anchors, 250 mm (10 inches) long with 50 mm (2 inch) hooked end, welded to back of member at 600 mm (2 feet) on center, unless otherwise shown.
5. Cutting and Fitting:
- a. Accurately cut, machine and fit joints, corners, copes, and miters.
  - b. Fit removable members to be easily removed.
  - c. Design and construct field connections in the most practical place for appearance and ease of installation.

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- d. Fit pieces together as required.
- e. Fabricate connections for ease of assembly and disassembly without use of special tools.
- f. Joints firm when assembled.
- g. Conceal joining, fitting and welding on exposed work as far as practical.
- h. Do not show rivets and screws prominently on the exposed face.
- i. The fit of components and the alignment of holes shall eliminate the need to modify component or to use exceptional force in the assembly of item and eliminate the need to use other than common tools.

F. Finish:

- 1. Finish exposed surfaces in accordance with NAAMM AMP 500 Metal Finishes Manual.
- 2. Aluminum: NAAMM AMP 501.
  - a. Mill finish, AA-M10, as fabricated, use unless specified otherwise.
  - b. Clear anodic coating, AA-C22A41, chemically etched medium matte, with Architectural Class 1, 0.7 mils or thicker.
  - d. Painted: AA-C22R10.
- 3. Steel and Iron: NAAMM AMP 504.
  - a. Zinc coated (Galvanized): ASTM A123, G90 unless noted otherwise.
  - b. Surfaces exposed in the finished work:
    - 1) Finish smooth rough surfaces and remove projections.
    - 2) Fill holes, dents and similar voids and depressions with epoxy type patching compound.
  - c. Shop Prime Painting:
    - 1) Surfaces of Ferrous metal:
      - a) Items not specified to have other coatings.
      - b) Galvanized surfaces specified to have prime paint.
      - c) Remove all loose mill scale, rust, and paint, by hand or power tool cleaning as defined in SSPC-SP2 and SP3.
      - d) Clean of oil, grease, soil and other detrimental matter by use of solvents or cleaning compounds as defined in SSPC-SP1.
      - e) After cleaning and finishing apply one coat of primer as specified in Section 09 91 00, PAINTING.



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2) Nonferrous metals: Comply with MAAMM-500 series.

4. Stainless Steel: NAAMM AMP-504 Finish No. 4.

G. Protection:

1. Insulate aluminum surfaces that will come in contact with concrete, masonry, plaster, or metals other than stainless steel, zinc or white bronze by giving a coat of heavy-bodied alkali resisting bituminous paint or other approved paint in shop.
2. Spot prime all abraded and damaged areas of zinc coating which expose the bare metal, using zinc rich paint on hot-dip zinc coat items and zinc dust primer on all other zinc coated items.

**2.5 SUPPORTS**

A. General:

1. Fabricate ASTM A36 structural steel shapes as shown.
2. Use clip angles or make provisions for welding hangers and braces to overhead construction.
3. Field connections may be welded or bolted.

C. For Wall Mounted Items:

1. For items supported by metal stud partitions.
2. Steel strip or hat channel minimum of 1.5 mm (0.0598 inch) thick.
3. Steel strip minimum of 150 mm (6 inches) wide, length extending one stud space beyond end of item supported.
4. Steel hat channels where shown. Flange cut and flattened for anchorage to stud.
5. Structural steel tube or channel for grab bar at water closets floor to structure above with clip angles or end plates formed for anchors.
6. Use steel angles for thru wall counters. Drill angle for fasteners at ends and not over 100 mm (4 inches) on center between ends.

**D. FOR TRAPEZE BARS:**

1. Construct assembly above ceilings as shown and design to support not less than a 340 kg (750 pound) working load at any point.
2. Fabricate trapeze supports as shown, with all exposed members, including screws, nuts, bolts and washers, fabricated of stainless steel.
3. Fabricate concealed components of structural steel shapes unless shown otherwise.
4. Stainless steel ceiling plate drilled for eye bolt.

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5. Continuously weld connections where welds shown.
6. Use modular channel where shown with manufacturers bolts and fittings.
  - a. Weld ends of steel angle braces to steel plates and secure to modular channel units as shown. Drill plates for anchor bolts.
  - b. Fabricate eye bolt, special clamp bolt, and plate closure full length of modular channel at ceiling line and secure to modular channel unit with manufacturers standard fittings.
- E. For Intravenous Track and Cubical Curtain Track:
  1. Fabricate assembly of steel angle as shown.
  2. Drill angle bent ends for anchor screws to acoustical suspension system and angle for hanger wires.
  3. Provide pipe sleeve welded to angle.
- F. Supports at Ceiling for Imaging Equipment:
  1. Fabricate hangers braces, and track of modular channel units assembly as shown.
  2. Fabricate steel plates for anchor to structure above.
  3. Drill bent plates for bolting at mid height at concrete beams.
- I. Supports for Items at Various Conditions at Suspended Ceilings:
  1. Fabricate of structural steel shapes as shown.
  2. Drill for anchor bolts of suspended item.

## **2.6 FRAMES**

- B. Door Frames:
  1. Fabricate of structural steel sections of size shown.
  2. Miter and weld frames at corners.
  3. Where anchored to masonry or embedded in concrete, weld to back of frame at each jamb, 5 mm (3/16 inch) thick by 44 mm (1-3/4 inch) wide steel strap anchors with ends turned 50 mm (2 inches), and of sufficient length to extend at least 300 mm (12 inches) into wall. Space anchors 600 mm (24 inches) above bottom of frame and 600 mm (24 inches) o.c. to top of jamb. Weld clip angles to bottom of jambs and provide holes for expansion bolts.
  4. Where anchored to concrete or masonry in prepared openings, drill holes at jambs for anchoring with expansion bolts. Weld clip angles to bottom of frame and provide holes for expansion bolt anchors as shown. Drill holes starting 600 mm (24 inches) above bottom of frame

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and 600 mm (24 inches) o.c. to top of jamb and at top of jamb.

Provide pipe spacers at holes welded to channel.

5. Where closure plates are shown, continuously weld them to the channel flanges.
6. Weld continuous 19 x 19 x 3 mm (3/4 x 3/4 x 1/8 inch) thick steel angles to the interior side of each channel leg at the head and jambs to form a caulking groove.
7. Prepare frame for installation of hardware specified in Section 08 71 00, DOOR HARDWARE.
  - a. Cut a slot in the lock jamb to receive the lock bolt.
  - b. Where shown use continuous solid steel bar stops at perimeter of frame, weld or secure with countersunk machine screws at not more than 450 mm (18 inches) on center.

D. Frames for Lead Lined Doors:

1. Obtain accurate dimensions and templates from suppliers of lead lined doors, finish hardware, and hollow steel door frames.
2. Fabricate as shown for use in connection with lead lined doors.
3. Deliver assembled frames with removable shipping spreaders at top and bottom.
4. Extend angles at jambs from floor to structural slab above. At floors of interstitial spaces, terminate jamb sections and provide anchors as shown.
5. Continuously weld plates and reinforcements to frame members and head members of angle frames between jambs.
6. Weld strap anchors, not over 600 mm (24 inches) on centers, to the back of angles for embedment in masonry or concrete unless shown otherwise.
7. Type 15 Door Frames:
  - a. Structural steel angle frames with plate or bar full height to heads. Extend reinforcing at hinge cutouts two inches beyond cutout.
  - b. Fabricate top anchorage to beam side at mid height.
  - c. Weld clip angles to both legs of angle at top and bottom.
  - d. Drill clips and plates, at top and bottom for anchoring jamb angles with two 9 mm (3/8 inch) expansion bolts at each location.
  - e. Cut rabbet for pivot hinges and lock strike.

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## **2.10 LOOSE LINTELS**

- A. Furnish lintels of sizes shown. Where size of lintels is not shown, provide the sizes specified.
- B. Fabricate lintels with not less than 150 mm (6 inch) bearing at each end for nonbearing masonry walls, and 200 mm (8 inch) bearing at each end for bearing walls.
- C. Provide one angle lintel for each 100 mm (4 inches) of masonry thickness as follows except as otherwise specified or shown.
  - 1. Openings 750 mm to 1800 mm (2-1/2 feet to 6 feet) - 100 x 90 x 8 mm (4 x 3-1/2 x 5/16 inch).
  - 2. Openings 1800 mm to 3000 mm (6 feet to 10 feet) - 150 x 90 x 9 mm (6 x 3-1/2 x 3/8 inch).
- D. For 150 mm (6 inch) thick masonry openings 750 mm to 3000 mm (2-1/2 feet to 10 feet) use one angle 150 x 90 x 9 mm (6 x 3-1/2 x 3/8 inch).
- E. Provide bearing plates for lintels where shown.
- F. Weld or bolt upstanding legs of double angle lintels together with 19 mm (3/4 inch bolts) spaced at 300 mm (12 inches) on centers.
- G. Insert spreaders at bolt points to separate the angles for insertion of metal windows, louver, and other anchorage.
- H. Where shown or specified, punch upstanding legs of single lintels to suit size and spacing of anchor bolts.

## **2.11 SHELF ANGLES**

- A. Fabricate from steel angles of size shown.
- B. Fabricate angles with horizontal slotted holes for 19 mm (3/4 inch) bolts spaced at not over 900 mm (3 feet) on centers and within 300 mm (12 inches) of ends.
- C. Provide adjustable malleable iron inserts for embedded in concrete framing.

## **2.13 SAFETY NOSINGS**

- A. Fed. Spec. RR-T-650, Type C.
  - 1. Aluminum: Class 2, Style 2.
  - 2. Cast iron: Class 4.
- B. Fabricate nosings for exterior use from cast aluminum, and nosings for interior use from either cast aluminum or cast iron. Use one Class throughout.
- C. Fabricate nosings approximately 100 mm (4 inches) wide with not more than 9 mm (3/8 inch) nose.

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- D. Provide nosings with integral type anchors spaced not more than 100 mm (4 inches) from each end and intermediate anchors spaced approximately 375 mm (15 inches) on center.
- E. Fabricate nosings to extend within 100 mm (4 inches) of ends of concrete stair treads except where shown to extend full width.
- F. Fabricate nosings to extend full width between stringers of metal stairs and full width of door openings.
- G. On curved steps fabricate to terminate at point of curvature of steps having short radius curved ends.

#### **2.14 LADDERS**

##### **A. Steel Ladders:**

- 1. Fixed-rail type with steel rungs shouldered and headed into and welded to rails.
- 2. Fabricate angle brackets of 50 mm (2 inch) wide by 13 mm (1/2 inch) thick steel; brackets spaced maximum of 1200 mm (4 feet) apart and of length to hold ladder 175 mm (7 inches) from wall to center of rungs. Provide turned ends or clips for anchoring.
- 3. Provide holes for anchoring with expansion bolts through turned ends and brackets.
- 4. Where shown, fabricate side rails curved, twisted and formed into a gooseneck.
- 5. Galvanize exterior ladders after fabrication, ASTM A123, G-90.

##### **C. Ladder Rungs:**

- 1. Fabricate from 25 mm (one inch) diameter steel bars.
- 2. Fabricate so that rungs will extend at least 100 mm (4 inches) into wall with ends turned 50 mm (2 inches), project out from wall 175 mm (7 inches), be 400 mm (16 inches) wide and be designed so that foot cannot slide off end.
- 3. Galvanized after fabrication, ASTM A123, G-90.

#### **2.15 RAILINGS**

- A. In addition to the dead load design railing assembly to support live load specified.

##### **B. Fabrication General:**

- 1. Provide continuous welded joints, dressed smooth and flush.
- 2. Standard flush fittings, designed to be welded, may be used.
- 3. Exposed threads will not be approved.
- 4. Form handrail brackets to size and design shown.

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5. Exterior Post Anchors.

- a. Fabricate tube or pipe sleeves with closed ends or plates as shown.
- b. Where inserts interfere with reinforcing bars, provide flanged fittings welded or threaded to posts for securing to concrete with expansion bolts.
- c. Provide heavy pattern sliding flange base plate with set screws at base of pipe or tube posts.

6. Interior Post Anchors:

- a. Provide flanged fittings for securing fixed posts to floor with expansion bolts, unless shown otherwise.
- b. Weld or thread flanged fitting to posts at base.
- c. For securing removable posts to floor, provide close fitting sleeve insert or inverted flange base plate with stud bolts or rivets concrete anchor welded to the base plate.
- d. Provide sliding flange base plate on posts secured with set screws.
- e. Weld flange base plate to removable posts set in sleeves.

C. Handrails:

1. Close free ends of rail with flush metal caps welded in place except where flanges for securing to walls with bolts are shown.
2. Make provisions for attaching handrail brackets to wall, posts, and handrail as shown.

D. Steel Pipe Railings:

1. Fabricate of steel pipe with welded joints.
2. Number and space of rails as shown.
3. Space posts for railings not over 1800 mm (6 feet) on centers between end posts.
4. Form handrail brackets from malleable iron.
5. Fabricate removable sections with posts at end of section.
6. Removable Rails:
  - a. Provide "U" shape brackets at each end to hold removable rail as shown. Use for top and bottom horizontal rail when rails are joined together with vertical members.
  - b. Secure rail to brackets with 9 mm (3/8 inch) stainless steel through bolts and nuts at top rail only when rails joined with vertical members.

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- c. Continuously weld brackets to post.
  - d. Provide slotted bolt holes in rail bracket.
  - e. Weld bolt heads flush with top of rail.
  - f. Weld flanged fitting to post where posts are installed in sleeves.
7. Opening Guard Rails:
- a. Fabricate rails with flanged fitting at each end to fit between wall opening jambs.
  - b. Design flange fittings for fastening with machine screws to steel plate anchored to jambs.
  - c. Fabricate rails for floor openings for anchorage in sleeves.

## **2.16 STEEL PIPE BOLLARD**

Provide bollard in accordance with ASTM A53 with dimensions as shown in standard detail SD320523-04. Anchor posts in concrete and fill solidly with concrete with a minimum compressive strength of 17 MPa 2500psi.

## **2.17 PREMANUFACTURED METAL CANOPY**

- A. Basis of Design: The design is based on Super Lumideck Flat Soffit Hanger Rod extruded aluminum overhead hanger rod style canopy as manufactured by Mapes Architectural Canopies.
- 1. Materials: Lumideck Flat
    - a. Decking: 3-inched extruded flat soffit
      - 1) Material thickness: .078-inch alloy 6063-T6 aluminum.
    - b. Fascia: 8-inches extruded "J" style.
      - 1) Material thickness: 125 alloy 6063-T6 aluminum.
    - c. Decking and fascia shall be extruded aluminum, alloy 6063-T6, in profile and thickness shown in current Mapes brochures.
  - 2. Finishes: As selected by the Architect from manufacturer's full range.
    - a. Hanger rods and attachment hardware shall be powder coated to match canopy.

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b. Fabrication:

All connections shall be mechanically assembled utilizing 3/16" stainless steel fasteners with a minimum shear stress of 350

lb. Pre-welded or factory-welded connections are not acceptable.

- B. Decking shall be designed with interlocking extruded aluminum members with mechanical fasteners field applied to provide structural integrity for the completed assembly.
- C. Concealed drainage. Water shall drain from covered surfaces into integral fascia gutter and directed to either the front for front drainage or to the rear for ground level discharge via one or more designated downspouts.

**PART 3 - EXECUTION**

**3.1 INSTALLATION, GENERAL**

- A. Set work accurately, in alignment and where shown, plumb, level, free of rack and twist, and set parallel or perpendicular as required to line and plane of surface.
- B. Items set into concrete or masonry.
1. Provide temporary bracing for such items until concrete or masonry is set.
  2. Place in accordance with setting drawings and instructions.
  3. Build strap anchors, into masonry as work progresses.
- C. Set frames of gratings, covers, corner guards, trap doors and similar items flush with finish floor or wall surface and, where applicable, flush with side of opening.
- D. Field weld in accordance with AWS.
1. Design and finish as specified for shop welding.
  2. Use continuous weld unless specified otherwise.
- E. Install anchoring devices and fasteners as shown and as necessary for securing metal fabrications to building construction as specified. Power actuated drive pins may be used except for removable items and where members would be deformed or substrate damaged by their use.



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- F. Spot prime all abraded and damaged areas of zinc coating as specified and all abraded and damaged areas of shop prime coat with same kind of paint used for shop priming.
- G. Isolate aluminum from dissimilar metals and from contact with concrete and masonry materials as required to prevent electrolysis and corrosion.
- H. Secure escutcheon plate with set screw.

### **3.2 INSTALLATION OF SUPPORTS**

- A. Anchorage to structure.
  - 1. Secure angles or channels and clips to overhead structural steel by continuous welding unless bolting is shown.
  - 2. Secure supports to concrete inserts by bolting or continuous welding as shown.
  - 3. Secure supports to mid height of concrete beams when inserts do not exist with expansion bolts and to slabs, with expansion bolts. unless shown otherwise.
  - 4. Secure steel plate or hat channels to studs as detailed.
- C. Supports for Wall Mounted items:
  - 1. Locate center of support at anchorage point of supported item.
  - 2. Locate support at top and bottom of wall hung cabinets.
  - 3. Locate support at top of floor cabinets and shelving installed against walls.
  - 4. Locate supports where required for items shown.
- D. Support at Ceiling for Diagnostic Equipment:
  - 1. Bolt modular steel channel frames to hangers as shown, anchored to structure above.
  - 2. Fasten frames with modular channel manufacturers fittings, bolts, and nuts. Space modular channel supports and hangers as shown and as required to suit equipment furnished.
  - 3. Install closure plates in channels at ceiling where channel opening is visible. Coordinate and cut plates to fit tight against equipment anchors after equipment anchors are installed.
- F. Supports for intravenous (IV) Track and Cubicle Curtain Track:
  - 1. Install assembly where shown after ceiling suspension grid is installed.
  - 2. Drill angle for bolt and weld nut to angle prior to installation of tile.

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G. Support for cantilever grab bars:

1. Locate channels or tube in partition for support as shown, and extend full height from floor to underside of structural slab above.
2. Anchor at top and bottom with angle clips bolted to channels or tube with two, 9 mm (3/8 inch) diameter bolts.
3. Anchor to floors and overhead construction with two 9 mm (3/8 inch) diameter bolts.
4. Fasten clips to concrete with expansion bolts, and to steel with machine bolts or welds.

H. Supports for Trapeze Bars:

1. Secure plates to overhead construction with fasteners as shown.
2. Secure angle brace assembly to overhead construction with fasteners as shown and bolt plate to braces.
3. Fit modular channel unit flush with finish ceiling, and secure to plate with modular channel unit manufacturer's standard fittings through steel shims or spreaders as shown.
  - a. Install closure plates in channel between eye bolts.
  - b. Install eyebolts in channel.

**3.4 FRAMES FOR LEAD LINED DOORS**

- A. Secure jamb angle clips and plates, at top and bottom with two, 9 mm (3/8 inch) expansion bolts to concrete.
- B. Secure 150 x 90 x 13 mm (6 x 3-1/2 x 1/2 inch) angle to steel framing for anchorage when expansion bolts to concrete is not possible.
- C. Secure clips by welding to steel.
- D. At interstitial spaces, anchor jamb angles as shown.

**3.5 DOOR FRAMES**

- A. Secure clip angles at bottom of frames to concrete slab with expansion bolts as shown.
- B. Level and plumb frame; brace in position required.
- C. At masonry, set frames in walls so anchors are built-in as the work progresses unless shown otherwise.
- D. Set frames in formwork for frames cast into concrete.
- E. Where frames are set in prepared openings, bolt to wall with spacers and expansion bolts.

**3.6 OTHER FRAMES**

- A. Set frame flush with surface unless shown otherwise.

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B. Anchor frames at ends and not over 450 mm (18 inches) on centers unless shown otherwise.

C. Set in formwork before concrete is placed.

### **3.9 STEEL LINTELS**

A. Use lintel sizes and combinations shown or specified.

B. Install lintels with longest leg upstanding, except for openings in 150 mm (6 inch) masonry walls install lintels with longest leg horizontal.

C. Install lintels to have not less than 150 mm (6 inch) bearing at each end for nonbearing walls, and 200 mm (8 inch) bearing at each end for bearing walls.

### **3.10 SHELF ANGLES**

A. Anchor shelf angles with 19 mm (3/4 inch) bolts unless shown otherwise in adjustable malleable iron inserts, set level at elevation shown.

B. Provide expansion space at end of members.

### **3.12 SAFETY NOSINGS**

A. Except as specified and where preformed rubber treads are shown or specified install safety nosings at the following:

1. Exterior concrete steps.
2. Door sills of areaway entrances curbs.
3. Exposed edges of curbs of door sills at transformer and service rooms.
4. Interior concrete steps, including concrete filled treads of metal stairs of service stairs.

B. Install flush with horizontal and vertical surfaces.

C. Install nosing to within 100 mm (4 inches) of ends of concrete stair treads, except where shown to extend full width.

D. Extend nosings full width of door openings.

E. Extend nosings, full width between stringers of metal stairs, and terminate at point of curvature of steps having short radius curved ends.

### **3.13 LADDERS**

A. Anchor ladders to walls and floors with expansion bolts through turned lugs or angle clips or brackets.

C. Ladder Rungs:

1. Set ladder rungs into formwork before concrete is placed. Build ladder rungs into masonry as the work progresses.
2. Set step portion of rung 150 mm (6 inches) from wall.

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3. Space rungs approximately 300 mm (12 inches) on centers.
4. Where only one rung is required, locate it 400 mm (16 inches) above the floor.

### **3.14 RAILINGS**

#### **A. Steel Posts:**

1. Secure fixed posts to concrete with expansion bolts through flanged fittings except where sleeves are shown with pourable grout.
2. Install sleeves in concrete formwork.
3. Set post in sleeve and pour grout to surface. Apply beveled bead of urethane sealant at perimeter of post or under flange fitting as specified in Section 07 92 00, JOINT SEALANTS—on exterior posts.
4. Secure removable posts to concrete with either machine screws through flanged fittings which are secured to inverted flanges embedded in and set flush with finished floor, or set posts in close fitting pipe sleeves without grout.
5. Secure sliding flanged fittings to posts at base with set screws.
6. Secure fixed flanged fittings to concrete with expansion bolts.
7. Secure posts to steel with welds.

#### **C. Anchor to Walls:**

1. Anchor rails to concrete or solid masonry with machine screws through flanged fitting to steel plate.
  - a. Anchor steel plate to concrete or solid masonry with expansion bolts.
  - b. Anchor steel plate to hollow masonry with toggle bolts.
2. Anchor flanged fitting with toggle bolt to steel support in frame walls.

#### **G. Handrails:**

1. Anchor brackets for metal handrails as detailed.
2. Install brackets within 300 mm (12 inches) of return of walls, and at evenly spaced intermediate points not exceeding 1200 mm (4 feet) on centers unless shown otherwise.
3. Expansion bolt to concrete or solid masonry.
4. Toggle bolt to installed supporting frame wall and to hollow masonry unless shown otherwise.

### **3.15 STEEL COMPONENTS FOR MILLWORK ITEMS**

Coordinate and deliver to Millwork fabricator for assembly where millwork items are secured to metal fabrications.

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### 3.16 INSTALLATION OF STEEL PIPE BOLLARD

Set bollards vertically in concrete piers. Compressive strength of concrete piers shall be 21MPa 3000psi. For dimensions of concrete piers See standard detail SD320523-04.

### 3.17 METAL ROOF PANEL INSTALLATION

- A. General: Provide metal roof panels of full length from eave to ridge, unless otherwise indicated or restricted by shipping limitations.
- B. Field-Assembled, Standing-Seam Metal Roof Panels: Fasten metal roof panels to supports with concealed clips at each standing-seam joint at location, spacing, and with fasteners recommended by manufacturer.
1. Install clips to supports with self-tapping fasteners.
  2. Snap Joint: Nest standing seams and fasten together by interlocking and completely engaging factory-applied sealant.
  3. Seamed Joint: Crimp standing seams with manufacturer-approved motorized seamer tool so clip, metal roof panel, and factory-applied sealant are completely engaged.
  4. Rigidly fasten eave end of metal roof panels and allow ridge end free movement due to thermal expansion and contraction. Predrill panels for fasteners.
  5. Provide metal closures at each side of ridge caps.
- C. Metal Fascia Panels: Align bottom of metal panels and fasten with blind rivets, bolts, or self-tapping screws. Flash and seal metal panels with weather closures where fasciae meet soffits, along lower panel edges, and at perimeter of all openings.

### 3.18 METAL SOFFIT PANEL INSTALLATION

- A. Provide metal soffit panels full width of soffits. Install panels perpendicular to support framing.
- B. Flash and seal metal soffit panels with weather closures where panels meet walls and at perimeter of all openings.

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**3.19 CLEAN AND ADJUSTING**

- A. Adjust movable parts including hardware to operate as designed without binding or deformation of the members centered in the opening or frame and, where applicable, contact surfaces fit tight and even without forcing or warping the components.
- B. Clean after installation exposed prefinished and plated items and items fabricated from stainless steel, aluminum and copper alloys, as recommended by the metal manufacture and protected from damage until completion of the project.

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