

**SECTION 08 56 53**  
**BLAST RESISTANT WINDOWS**

**PART 1 - GENERAL**

**1.1 SUMMARY**

A. Section Includes:

1. Prefabricated fixed stainless steel aluminum, blast resistant forced entry resistant blast and forced entry resistances exterior window units.

**1.2 RELATED REQUIREMENTS**

- A. Deal trays for forced entry/ballistic resistant rating: Section 08 56 59, SERVICE AND TELLER WINDOW UNITS.
- B. Window Color: Section 09 06 00, SCHEDULE FOR FINISHES.
- C. Forced entry and ballistic rated glazing: Section 08 80 00, GLAZING.
- D. Guard Booths: Section 13 34 19, METAL BUILDING SYSTEMS.

**1.3 APPLICABLE PUBLICATIONS**

- A. Comply with references to extent specified in this Section.
- B. American Architectural Manufacturers Association (AAMA):  
AAMA/WDMA/CSA 101/I.S.2/A440-11 Windows, Doors, and Skylights
- C. American Welding Society (AWS):  
D1.1/D1.1M-15.....Structural Welding Code - Steel  
D1.3/D1.3M-08.....Structural Welding Code - Sheet Steel  
D1.6/D1.6M-07.....Structural Welding Code - Stainless Steel
- D. ASTM International (ASTM):  
A36/A36M-19.....Carbon Structural Steel  
A123/A123M-17.....Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products  
A320/A320M-18.....Alloy-Steel and Stainless Steel Bolting Materials for Low-Temperature Service  
A666-15.....Annealed or Cold-Worked Austenitic Stainless Steel Sheet, Strip, Plate and Flat Bar  
B221-14.....Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes  
B221M-13.....Aluminum and Aluminum-Alloy Extruded Bars, Rods, Wire, Profiles, and Tubes  
E283/A283M-18.....Standard Test Method for Determining Rate of Air Leakage Through Exterior Windows, Curtain

- Walls, and Doors Under Specified Pressure  
Differences Across the Specimen
- E331-00 (2016).....Standard Test Method for Water Penetration of  
Exterior Windows, Skylights, Doors, and Curtain  
Walls by Uniform Static Air Pressure Difference  
SPEC WRITER NOTE: Depending on the rating  
needed this reference can be used.
- F1233-08 (2019).....Standard Test Method for Security Glazing  
Materials and Systems
- F1642/F1642M-17.....Standard Test Method for Glazing and Glazing  
Systems Subject to Air blast Loadings
- E. National Association of Architectural Metal Manufactures (NAAMM):  
AMP 500-06.....Metal Finishes Manual
- F. UL LLC (UL):  
752-10 (R2013).....Bullet Resisting Equipment
- G. Department of Veterans Affairs:  
VA Physical Security and Resiliency Design Manual October 1, 2020

#### **1.4 PREINSTALLATION MEETINGS**

- A. Conduct preinstallation meeting at project site minimum 30 days before  
beginning Work of this Section.
1. Required Participants:
    - a. Contracting Officer's Representative.
    - b. Architect/Engineer.
    - c. Inspection and Testing Agency.
    - d. Contractor.
    - e. Installer.
    - f. Manufacturer's field representative.
    - g. Other installers responsible for adjacent and intersecting work.
  2. Meeting Agenda: Distribute agenda to participants minimum 3 days  
before meeting.
    - a. Installation schedule.
    - b. Installation sequence.
    - c. Preparatory work.
    - d. Protection before, during, and after installation.
    - e. Installation.
    - f. Transitions and connections to other work.

**ADDENDUM #3**

- g. Inspecting and testing.
  - h. Other items affecting successful completion.
3. Document and distribute meeting minutes to participants to record decisions affecting installation.

**1.5 SUBMITTALS**

- A. Submittal Procedures: Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA AND SAMPLES.
- B. Submittal Drawings:
  - 1. Show dimensioned details of window units, including intended metal and glazing materials. 1: 20 (Three quarter inch equals 1 foot) scaled elevations showing interior and exterior. Indicated how window units can be replaced or removed, including replacement of glazing. Shop drawings shall be submitted for review and approval prior to fabrication. The contractor is responsible for all field verification of existing conditions and dimensions for new construction that is being conducted adjacent to or integral with existing construction. The field verification shall be conducted and incorporated in the submitted shop drawings and calculations prior to submission. Blast calculations and or testing data shall be submitted with the shop drawings.
  - 2. Show detailed sections at 1: 5 (3 inch equal 1 foot) scale for members; indicating construction, size, and thickness of components, together with connections, fasteners, and means of separating dissimilar metals.
  - 3. Provide final submittal drawings as DWG AutoCAD files.
- C. Manufacturer's Literature and Data:
  - 1. Description of each product, metal, and alloy when applicable.
  - 2. Indicate manufacturer's recommendations for fasteners, welding, applied finishes, hardware and accessories.
  - 3. Installation instructions.
  - 4. Standard color chart.
- D. Certificates: Indicate each product complies with specifications.
  - 1. Window forced entry resistance.
  - 2. Window blast resistance.
- E. Calculations: Submit calculations for review and approval prepared by qualified blast consultant, with a minimum of 5 years of experience in design of blast resistant window systems, verifying window and glazing

**ADDENDUM #3**

assembly including anchors comply with specified blast resistance performance given in Section 2.1.a of this specification. The magnitudes of the design threats W1, W2 and GP1, GP2 are defined in the Physical Security and Resiliency Design Standards Data Definitions which is a document separate from the referenced VA Security and Resiliency Design Manual. The Physical Security and Resiliency Design Standards Data Definitions are provided on a need to know basis by the structural blast specialist performing the blast design on VA projects. It is the responsibility of the delegated engineer responsible for the design of blast resistant windows to request and obtain the Physical Security and Resiliency Design Data Standard Data Definitions from the VA Office of Construction and Facilities Management (CFM). Any associated delays or increased costs due to failure to obtain this information will be borne by the contractor.

- F. Qualifications: Substantiate qualifications comply with specifications.
1. Manufacturer with project experience list demonstrating a minimum of 5 years of experience manufacturing blast resistant windows.
  2. Installer with project experience list demonstrating a minimum of 5 years of experience installing blast resistant windows.
  3. Welders and welding procedures.

**1.6 QUALITY ASSURANCE**

- A. Manufacturer and Installer Qualifications:
1. Regularly manufactures and installs specified products.
  2. Manufactured and installed specified products with satisfactory service on five similar installations for minimum five years.
    - a. Provide contact names and addresses for completed projects when requested by Contracting Officer's Representative.
- B. Welders and Welding Procedures Qualifications:
1. Stainless Steel: AWS D1.6/D1.6M.
  2. Steel: AWS D1.1/D1.1M.
  3. Sheet Steel: AWS D1.3/D1.3M.

**1.7 DELIVERY**

- A. Deliver prefabricated unit in manufacturer's original sealed packaging.
- B. Mark packaging, legibly. Indicate manufacturer's name or brand, unit type, and manufacture date.
- C. Before installation, return or dispose of products within distorted, damaged, wet, or opened packaging.

### **1.8 STORAGE AND HANDLING**

- A. Store products indoors in dry, weathertight facility.
- B. Protect products from damage during handling and construction operations.

### **1.9 FIELD CONDITIONS**

- A. Field Measurements: Verify field conditions affecting window fabrication and installation. The field verification shall be conducted and incorporated in the submitted shop drawings and calculations prior to submission. Show field measurements on Submittal Drawings.
  - 1. Coordinate field measurement and fabrication schedule to avoid delay.

### **1.10 WARRANTY**

- A. Construction Warranty: FAR clause 52.246-21, "Warranty of Construction."

## **PART 2 - PRODUCTS**

### **2.1 SYSTEM PERFORMANCE**

- A. Design windows complying with specified performance:
  - 1. Comply with VA Physical Security and Resiliency Design Manual
    - a. Standoff Distance: 25 feet (Life Safety Protected) 50 feet (Mission Critical Protected).
    - b. Design Threat W1 at the standoff distance not to exceed pressure and impulse associated with GP1 threat for Life Safety Protected Buildings W1 at the standoff not to exceed pressure and impulse associated with GP2 threat for Mission Critical Protected Buildings.
    - c. Mullion deformation not to exceed deformation limits shown in Table 6-4 of the referenced Physical Security and Resiliency Design Manual.
    - d. Glazing performance condition shall not exceed those shown in Table 6-3 of the referenced Physical Security and Resiliency Design Manual.
    - e. Glass shall be restrained within the mullions with ½" bite and 3/8" wide continuous bead of structural silicone adhesive attaching the inner lite of the glass to the frame.
    - f. ASTM F1642, ASTM F1233 and AAMA/WDMA/CSA 101/I.S.2/A440.
  - 2. Provide indicated levels of resistance for forced entry blast resistant forced entry and blast resistances window assemblies.

**ADDENDUM #3**

- Resistance level applies to anchorages, interfaces with adjoining substrates, glass retention, and hardware.
3. Would be attackers cannot penetrate through secure closed window assembly.
  4. Provide combined performances within rating limitations knowing certain attacks can result in severe damage to unit and require replacement.
- B. Forced-Entry (FE) Resistant Assemblies: Manufacturer's window unit assembled with panels, inserts, hardware, glazing and framing.
1. Provide FE rated units where shown or scheduled:
    - a. No FE resistance rating.
    - b. Resistance of 5 minutes for forced entry, using basic hand tools.
    - c. Resistance of 15 minutes for forced entry, using basic hand tools.
- C. Blast Resistant (BR) Assemblies: Manufacturer's window unit assembled with panels, inserts, glazing and framing.
1. Provide BR rated units where shown or scheduled:
    - a. No BR resistance rating.
    - b. As required to meet the blast performance requirements listed in this specification
- D. Thermal Movement: Assembly capable of withstanding thermal movements resulting from ambient range of 67 degrees C (150 degrees F) to 82 degrees C (180 degrees F).
- E. Design Performance: Comply with structural performance, air infiltration, and water penetration requirements indicated in AAMA/WDMA/CSA 101/I.S.2/A440 for AW Class.
1. Wind Load Resistance: ASCE/SEI 7; Design criteria as indicated on Drawings.
  2. Water Infiltration: ASTM E331; no uncontrolled penetration at 300 Pa (6.2 psf), minimum, pressure differential.
  3. Air Infiltration: ASTM E283; Maximum 6 liter/second/square meter (0.1 cubic feet/minute/square foot.) at static pressure difference of 300 Pa (6.2 pound square foot).

**2.2 MATERIALS**

- A. Stainless Steel: ASTM A666, Type 304; formed stainless steel members.
- B. Aluminum Extrusions: ASTM B221.

**ADDENDUM #3**

01-01-21

1. Framing Members: Alloy 6063-T5, -T6, or -T52, or alloy 6061-T6; 5 mm (3/16 inch) minimum thickness.
2. Trim and Stops not exposed to forced entry attack: Alloy 6063-T5, -T6, or -T52; 1.5 mm (1/16 inch) minimum thickness.
- C. Steel Shapes/Plates/Bars: ASTM A36/A36M, except where another designation is indicated.
- D. Bolts and Fasteners: ASTM A320/A320M; Type 300-series stainless steel screws, bolts, nuts, and washers. Non-removable type where accessible from attack side.
- E. Window Cleaner's Bolts: Nonmagnetic stainless steel, complying with safety regulations for window cleaning equipment.
- F. Glazing Materials: Rated laminated assembly as specified in Section 08 80 00, GLAZING.

**2.3 PRODUCTS - GENERAL**

- A. Provide blast resistant windows from one manufacturer.

**2.4 FABRICATION**

- A. Assemblies: Shop fabricate matching profiles indicated on Drawings. Make welds that comply with AWS standards; exposed welds ground smooth. Provide welded-in-place reinforcements and anchorage devices.
  1. Removable Glazing Stops: Applied to room side of window.
    - a. Miter and weld removable stops at corners.
    - b. Secure removable stops to frames with countersunk screws, spaced as required for specified performance requirements.
  2. New Building: Frame system with inner frame, outer frame, and fasteners to connect frames together.
    - a. Fabricate continuous outer frame for masonry concrete embedment as exterior wall is constructed.
    - b. Preassemble inner frame with glazing for bolting to outer frame.
    - c. Provide both frames shall be supplied by one manufacturer.
    - d. Anchorage: Provide anchors as required to meet the project loading requirements.
  3. Existing Buildings: Fabricate continuous frame for anchoring to supporting structural elements shown on the drawings.
    - a. Provide both inner and outer frames by one manufacturer.
    - b. Anchorage: Provide anchors as required to meet the project loading requirements

**ADDENDUM #3**

- B. Unit Anchorages: Fabricate metal anchorage system complying with performance requirements.
- C. Unit Glazing: Laminated glass assembly meeting VA Physical Security and Resiliency Design Manual. Testing shall be in accordance with ASTM F1642, as specified in Section 08 80 00, GLAZING. Where tested glazed systems do not match the project dimensional requirements, submit calculations prepared by a qualified blast consultant using accepted dynamic methods that demonstrate the submitted system meets the project requirements.

**2.5 FINISHES**

- A. General: Finish fabricated units including framing, sub-framing, hardware, and accessories.
  - 1. Color: Refer to Section 09 06 00, SCHEDULE FOR FINISHES.
- B. Steel Surfaces: ASTM A123/A123M galvanized.
- C. Stainless Steel: NAAMM AMP 500; No. 4 polished finish, except retain manufacturer's standard mill finish on exposed fasteners and similar devices.
- D. Blend welds to match adjacent finish.
- E. Aluminum Anodized Finish: NAAMM AMP 500.
  - 1. Clear Anodized Finish: AA-C22A41; Class I Architectural, 0.018 mm (0.7 mil) thick.
  - 2. Color Anodized Finish: AA-C22A42 or AA-C22A44; Class I Architectural, 0.018 mm (0.7 mil) thick.
- F. Aluminum Paint Finish:
  - 1. Fluorocarbon Finish: AAMA 2605; 70 percent fluoropolymer resin, 2-coat system.

**2.6 ACCESSORIES**

- A. Bituminous Paint: SSPC Paint 12 (cold-applied asphalt mastic).
- B. Welding Materials: Type to suit application for color match, strength and compatibility in fabricated item.
  - 1. Stainless Steel: AWS D1.6/D1.6M, TIG using rods made from alloyed Type 308 stainless steel.
  - 2. Steel: D1.1/D1.1M.
  - 3. Steel Sheet: D1.3/D1.3M-08.
- C. Galvanizing Repair Paint: MPI No. 18.



### **PART 3 - EXECUTION**

#### **3.1 PREPARATION**

- A. Examine and verify substrate suitability for product installation.
  - 1. Verify opening is correctly sized and located.
  - 2. Verify substrate is prepared to receive frame anchors.
- B. Protect existing construction and completed work from damage.
- C. Apply bituminous coating approximately 30 mils dry film thickness, or other suitable permanent separator, on surfaces of dissimilar metals, and metal surfaces in contact with concrete.
  - 1. Where the metals are exposed to view, provide a plastic or neoprene separator between dissimilar metals.

#### **3.2 INSTALLATION**

- A. Install products according to manufacturer's instructions and approved submittal drawings.
- B. Install window units according to manufacturer's installation instructions.
- C. Set units accurately, plumb, and level.
- D. Securely anchor to masonry concrete partition framing as shown on approved submittal drawings to withstand specified performance.
- E. Anchorage to Existing Building:
  - 1. Spacing: Maximum 300 mm (12 inch) on center through pre drilled bolt holes in structural frame//Install anchorage per reviewed and approved shop drawings.
  - 2. Anchor Diameter: 10 mm (3/8 inch) minimum.
  - 3. Minimum Embedment and Edge Distances:
    - a. Embedment in Concrete: 88 mm (3-1/2 inches).
    - b. Embedment in Solid Masonry: 150 mm (6 inches).
    - c. Edge Distance: 75 mm (3 inches).
  - 4. Do not cut rebar during concrete anchor installation without approval of the Contracting Officer's Representative (COR).
- F. Touch up damaged factory finishes.
  - 1. Repair galvanized surfaces with galvanized repair paint.

#### **3.3 CLEANING**

- A. Clean exposed window surfaces. Remove temporary labels, contaminants, and stains.
- B. Clean glazing according to Section 08 80 00, GLAZING.

**ADDENDUM #3**

01-01-21

**3.4 PROTECTION**

- A. Protect window units from construction operations.
- B. Remove protective materials immediately before acceptance.
- C. Repair damage.

- - E N D - -