



SWINGING FRENCH DOOR

SPECIFICATIONS - SERIES 430

General – Aluminum entry doors shown on plans and specifications shall be HERITAGE Medium Stile series 430 as manufactured by Tashco Industries, Inc of Gilbert, Arizona.

MATERIAL – HERITAGE French Doors shall be constructed of specially designed, extruded sections of 6063T5 tempered aluminum alloy, in accordance with HERITAGE engineering standards drawings. Minimum wall thickness to be .080 on all door frames and door leaf members. Snap in glazing stops to be .062 wall thickness.

PERIMETER FRAME - Consists of head, sill, jambs and vent stop. The head and jambs are the same hollow extrusion and provides 1.25" sightline. The sill is double hollow to accumulate and drain water out. Header and jambs can come with optional nail fins.

VENT – Consists of top and, bottom rail, lock and hinge stiles. Glass is held by extruded stops. Top rail is single hollow and stiles & bottom rail are double hollow. Minimum wall thickness is 0.080".

HARDWARE AND CONSTRUCTION – Door frames shall be constructed with the jambs running full height. Threshold and door frame header will be butt joined to the jambs and mechanically fastened with 2 each #8 screws at each end. Each jamb, the header and sill to have an automotive type seal that is a co-extrusion and EPDM + sponge based. It provides an exceptionally soft vent closing due to its high compression and memory capability. The door vent (leaf) will be made with the hinge and lock stiles running full height. Top and bottom rails shall butt between stiles. Top and bottom rails are closed by a closer extrusion to control water flow. Rails shall be joined to the stile ends by a special design extruded aluminum corner block, which is .375 thick. The corner block shall be fastened to each stile end with a 3/8-16 NC hex head bolt threaded into a 1/4" thick steel corner reinforcement plate. Top and bottom rails are to be fastened with #10 screws threaded into integral screw ports in the corner block. There will be 4 screws per corner. All joints and corners to be constructed free of unfinished metal edges.

All steel parts, bolts, screws to be zinc plated. Draw rods reinforce top and bottom rails. All doors to have European single point or multi point locks. Key cylinders run through finished plates. Handle levers are Martinelli (Italy). Solid brass channels cover Multi point hardware. Dead bolt throw is hardened steel and is supplemented by a mortise lock. Rods penetrate header and threshold. All HERITAGE French Doors are supplied with ROTON hinges standard.

GLAZING – Glass shall be held in place by the snap in extruded glazing stops. Glass is held between an exterior hard EPDM and interior EPDM sponge. Both vinyl shall be rolled into the aluminum glazing stops. There shall be no glass to metal contact. Glass will sit on 4" long and .220 thick 80 –90 durometer molded Delrin setting blocks. Same setting blocks will support the glass on jambs and head. Insulated glass shall be HERITAGE TOP-PANE™ and double sealed.

INSTALLATION - All units to be installed in prepared openings in accordance with manufacturer's recommendations and installation drawings. Frames must be securely fastened, set plumb and level without twisting, bowing, or distortion. Openings shall not vary in measurement from jamb to jamb or from head to sill by more than 3/8" and shall not vary more than 1/4" on corner to corner diagonal measurements. HERITAGE door frames shall be securely anchored in place, leaving no exposed installation screws. The product design shall permit reglazing easily and be cost effective laborwise. Manufacturer assumes no liability for damage by the installer or final cleaning of the glass or aluminum.

FINISH – Painted finishes are dry powder. In paint, aluminum sections are pre-treated with Amchem Alodine 4830-4831 paint base. Powder paint is then applied electrostatically, then oven cured.

SPECS – Since HERITAGE products are constantly being improved, HERITAGE reserves the right to change specifications and designs.

Title of AAMA Test	Measured	Allowed
Air Infiltration ASTM E 283-91 Test Pressure: 1.57 psf 25 mph	0.22 scfm/ft ²	0.3 scfm/ft ²
Water Penetration ASTM E 547-96 Test Pressure: 2.86 psf	Pass	No Leakage
Uniform Load-Structural Test- ASTM E 330-96 Test pressure: 45.0 psf	0.023 in. 0.103 in.	0.375 in. 0.375 in.

Door tested: Swinging door with glass
Size: 37.5" X 96.5"