

## 600 Series – Insulated Rolling Steel Door Laid in Place Polystyrene (LIP) & Foamed in Place Urethane (FIP)

### PART 1 – GENERAL

#### 1.01 DESCRIPTION

- A. Type:** Insulated Doors to be manufactured by Asta Door Corporation.  
**B. Operation:** standard chain hoist operated using gear reduction, motor operation optional.  
**C. Mounting:** to be interior face mounted on a prepared opening, between jamb under lintel, between jamb face of wall or exterior.

#### 1.02 RELATED WORK

- A. Opening preparation, access panels, finish or field painting are in the scope of the work of other sections or trades.

### PART 2 - PRODUCT

#### 2.01 CURTAIN

**A. Slats:** galvanized steel cold roll formed in continuous lengths. Galvanized according to A.S.T.M. A653- and finished with baked epoxy primer and baked polyester topcoat.

1. Model 624 - 24 gauge (front) and 24 gauge (back) up to 24' (7.32m) wide x 16' (4.88m) high
2. Model 622 - 22 gauge (front) and 24 gauge (back) up to 24' (7.32m) wide x 16' (4.88m) high
3. Model 620 – 20 gauge (front) and 24 gauge (back) up to 26' (7.92m) wide x 26' (7.92m) high or 32' (9.75m) x 20' (6.1m)
4. Model 618 – 18 gauge (font) and 24 gauge (back) up to 26' (7.92m) wide x 26' (7.92m) high or 31' (9.45m) x 24' (7.32m)

*Note 1: Optional 22-gauge back slat available only on front slats that are 22, 20 or 18 gauge doors.*

*Note 2: For larger sizes not listed please contact customer service*

*Note 3: Model 624 (24ga/24ga) is available in Foamed in Place (FIP) urethane only, laid in place not available.*

**B. Endlocks / Windlocks:** each end of alternate slats to be fitted with endlocks to provide a wearing surface in the guides and to maintain slat alignment, Fastened with 1/4" rivets.

**C. Windload (standard):** door construction designed to meet or exceed a windload of 20 PSF or 90 M.P.H. Consult factory for available sizes.

#### Optional Windload-

1. Windload Certified
2. Impact Rated

**D. Bottom Bar:** curtain to be reinforced with a bottom bar consisting of two steel angles bolted back-to-back with bottom astragal, painted black (powder coat optional).

#### **E. Insulation:**

1. to be 3/4" laid in place polystyrene (LIP) to flat slat. (R = 5 and U = .25)
2. to be 3/4" foamed in place urethane (FIP) to flat slat. (R = 7.2 and U = .139)

**F. Vision Lites:** (Optional): 5" x 3/4"

#### 2.02 BARREL ASSEMBLY

**A. Barrel:** to be a steel pipe of diameter and wall thickness to restrict maximum deflection to .03" per foot (2.5 mm/m) of door width.

**B. Springs:** to be oil tempered, grease packed helical torsion type designed to cycle 25,000 times. Springs are to be mounted on a cold rolled steel inner shaft. Optional 50,000 or 100,000 cycle springs. Cycle counter required for warranty.

**C. End Bearing:** to be self-lubricating ball bearings or oil impregnated bronze bushings.

#### 2.03 BRACKET PLATES

**A. Bracket Plates:** to be 1/4" (6.35mm) minimum thickness steel plate and enclose ends of barrel assembly.

**B. Drive End Bracket Plate:** to be fitted with a self-aligning sealed ball bearing.

#### 2.04 OPERATION

**A. Chain Hoist:** to consist of roller chains and sprockets.

**B. Hand Chain:** to be galvanized machine link. Pull not to exceed 35 lbs. (156 N).

**C. Electric Motor Operation:** to be front of hood mount or wall mounted.

#### 2.05 GUIDE ASSEMBLY

**A. Wall Angles:** to be 3/16" (4.76mm) minimum thickness structural steel angles.

**B. Guides:** to be structural steel angles 3/16" (4.76mm) minimum thickness with removable headstops and 30"(762mm) service cutout on both sides.

**C. Guide Depth:** to provide slat penetration adequate to satisfy specified windloading.

**D. Weather Seal:** non-coil side to be clip on vinyl weather seal (optional aluminum retainer with brush seal).

## **2.06 HOODS**

**A. Hoods:** to be 24 gauge galvanized steel with baked epoxy primer and baked polyester top coat and enclose coil. 8" P.V.C. baffle to be riveted to inside of hood.

**B. Reinforcing:** to be 1/4" (6.35mm) thick steel brackets for doors over 16'0" (4877mm) wide.

## **2.07 LOCKING**

**A. Hand Chain Lock:** lockable bracket, mounted on guide angle or wall, suitable for padlocking (padlock by others).

## **2.08 FINISH**

**A. Ungalvanized Surfaces:** to be shop coated with rust reducing black prime paint, except malleable Endlocks.

**Curtain finish options:**

1. Satin White topcoat
2. Gray topcoat
3. Tan topcoat
4. Galvanized

## **PART 3 - EXECUTION**

### 3.01 INSTALLATION

**A. Installation:** to be by Asta Door Corporation authorized representative according to Asta Door Corporation standards and instructions.