

Steam Transom Specifications

A. UNIT FEATURES

1. All frame members shall be extruded aluminum.
2. Pivot jambs shall have vertical woven pile seal.
3. Transom shall have offset pivot position to allow the panel to remain open when desired.
4. Latch and stops shall be clear extruded dual durometer pvc.
5. Panels to be adjustable in width for precise fit to wall conditions. Optional wall jamb fillers are available for extreme out-of-plumb wall conditions.
6. Pivot is adjustable for precise fit to latch mechanism.
7. Transom is adaptable for use on any Alumax unit using an SC-505 header providing size limitations are observed.
8. Detailed instruction sheets and cross sections with custom unit fabrication formulas.
9. 24 hour product information and support via the **Alumax Bath Enclosures Website** (www.alumag.com).

B. UNIT VALIDITY

1. Wet test: All joints, seams, and seals are tested and evaluated for leaks in a wet test module.
2. Mechanical test: Moving parts or components subject to wear are cycle tested to simulate 20 years of use.
3. Artificial aging: Plastic components are selectively tested by artificial aging. This process subjects the parts to ultraviolet light, heat, and humidity to test the resistance of the material to these conditions.
4. Quality: Alumax Bath Enclosures are produced in accordance with procedures specified by ISO 9000.

C. MATERIALS AND CONSTRUCTION

1. Size Limitations:

Maximum allowable width of unit = 60”

Maximum allowable height of unit = 24”

2. Alloy and Temper: Extruded aluminum shall be 6463-T6 alloy per ASTM B 221. This alloy is designed to accept a bright finish after anodizing. Used for decorative trim applications, machineable, polished, and anodized - also heat treatable.

MECHANICAL PROPERTIES OF 6463-T6 (b)					
Thickness in inches (b)	Tensile Strength - ksi				Elongation percent min. in 2 in. or 4D
	Ultimate		Yield		
	min.	max.	min.	max.	
Up thru 0.124	30	..	25.0	..	8
0.125 - 1.000	30	..	25.0	..	10

- a. Hardness of 6463-T6 on Rockwell B scale: 20-50.
- b. T6 temper designates a material that is thermally treated to produce stable tempers then solution heat treated and artificially aged. For complete temper designation consult technical publications ANSI 35.1 or the Aluminum Association publication, Aluminum Standards and Data.
- c. The thickness of the cross-section from which the tension test specimen is taken determines the applicable mechanical properties. The data base and criteria upon which these mechanical property limits are established are outlined in the Aluminum Association publication Aluminum Standards and Data (ASD) Section 6, "Mechanical Properties".

3. Metal Gauge: The nominal wall thickness of individual aluminum extruded components for this unit varies with structural needs.

Component	Description	Nominal Wall Thickness
SC-508	Wall Jambs	.062"
SC-553	Wall Jamb Fills	.050"
SC-618	Pivot Jambs	.062
67346	Pivot Rails	.062
67423	Panel Top & Bottom Rail	.086" - .093"
SC-505A	Header	.062"

4. Tolerances: Tolerances on all aluminum extruded components shall comply with Aluminum Association requirements unless otherwise specified.

5. Hardware: All hardware parts that are incorporated in the product shall be of aluminum, stainless steel, or other corrosion resistant material(s) compatible with aluminum. Cadmium or zinc-plated parts, where used, shall be in compliance with ASTM A 164-71 or 165-74. Nickel or chrome-plated parts, where used, shall be in

compliance with ASTM B 456.71, SC2. Stainless material should have a preference of a 310 alloy with a 410 alternative.

For detailed technical information about stainless steel download the following files from the Alumax Bath Enclosures website at www.alumag.com:

STAINLES.ZIP, S_STEEL.ZIP

- a. Fasteners to follow International Fasteners Institute standard B18.6.3 for Slotted and Recessed Head Machine Screws and Metallic Drive Screws or B18.6.4 for Slotted and Recessed Head Tapping Screws and Metallic Drive Screws.
- b. Pivot Block – Cast Metal Alloy VN5-Z33522 (also Alloy #7) ASTM-A-640A or equivalent.
- c. Pivot Pin – Stainless Steel ASTM A276 TY 302 Passivated.

d. MECHANICAL PROPERTIES OF DUAL DUROMETER VINYL LATCH & SEAL (Flexible Component) Plasticized, filled with Shore A Durometer Hardness of 65	
Tensile Break Strength	1100 psi
Ultimate Elongation	360%
Specific Gravity 23/23 C	1.39
Shore "A" Hardness Initial @ 10 sec.	65 61
Brittleness Point, F 50% Failure @	-33

e. DUAL DUROMETER VINYL LATCH AND SEALS Mechanical Properties of Rigid Component			
Property	ASTM Method	Units	
Specific Gravity	D792	---	1.34
Hardness Durometer D	D2240	---	85
Rockwell R	D785	---	107
Tensile Strength	D638	psi	6,350
Flexural Strength	D790	psi	12,400
Izod Impact, 1/8" Notched	D256	ft lb/in	15
Optical Clarity – Transmittance Haze (.65 mil)	D1003	% %	74 5
All data obtained at 73 deg. F from injection molded Test specimens prepared per ASTM D647 and D1897			

- 6. Glazing Vinyls: Vinyls and other glazing seal materials shall be of material compatible with aluminum, be resistant to water and common household chemicals and shall create a water-tight seal between the glass and its surrounding frame.

a. MECHANICAL PROPERTIES OF GLAZING VINYL Plasticized, filled with Shore A Durometer Hardness of 60	
Tensile Break Strength	920 psi
Ultimate Elongation	600%
Specific Gravity 23/23 C	1.28
Shore "A" Hardness Initial @ 10 sec.	61 58
Brittleness Point, F 50% Failure @	-6

7. Glazing Materials: All glazing materials to be safety tempered glass with a nominal thickness of .156"/.188" on obscure or clear framed panels, or other safety glazing materials to conform to Federal Standard CPSC 16 CFR 1201 Category 1 and 2, Safety Standard for Architectural Glazing Materials. Dimensional tolerances shall conform to ASTM C 1036-85 and ASTM C 1048-85.

For detailed information concerning the mechanical properties of tempered glass download the following files from the Alumax Bath Enclosures website at www.alumag.com:

TECHGLAS.ZIP, GLASPROP.ZIP

8. Finish Specifications (Anodized): The finish on anodized aluminum components shall conform to the following Aluminum Association Specifications:
- Silver: AA-M21-C31-A21 for buffed, clear, bright anodized aluminum.
 - Gold: AA-M21-C31-A23 for buffed, colored, bright anodized aluminum.

Anodized aluminum components are tested or inspected for thickness of anodic coating (.00015" min.\.00030" max.), color range variation, and integrity of the anodic seal.

NOTE: The finished surface of anodized aluminum parts can be damaged by harsh cleansers. In particular, glass cleaners or other cleaning products with a PH of less than 7 or more than 9 can damage the anodized finish with prolonged exposure.

9. Finish Specifications (Painted)

Painted components shall conform to AAMA 603.8, Voluntary Performance Requirements and Test Procedures For Pigmented Organic Coatings On Extruded Aluminum.

- White powder coating shall conform to Aluminum Association standard AA-M10-C40-R1X.

Material used is polyurethane powder coating.

TYPICAL PROPERTIES OF TRANSOM POWDER COATING		
Property	ASTM Method	
Specific Gravity, PCI #4	---	1.2 – 1.9
Gloss	D523	5 – 95+
Pencil Hardness	---	H – 2H
Impact	D2794	To 160 Inch lbs
Mandrel Bend	D522	1/8 Inch
Cross Hatch Adhesion	D5339	Excellent
MFK resistance, PCI #8	---	50 Double Rubs
Abrasion resistance	D1044	Good
Salt Spray	D8117	500 Hrs. Min
Film Thickness	D1186	1.0 – 4.0 Mils