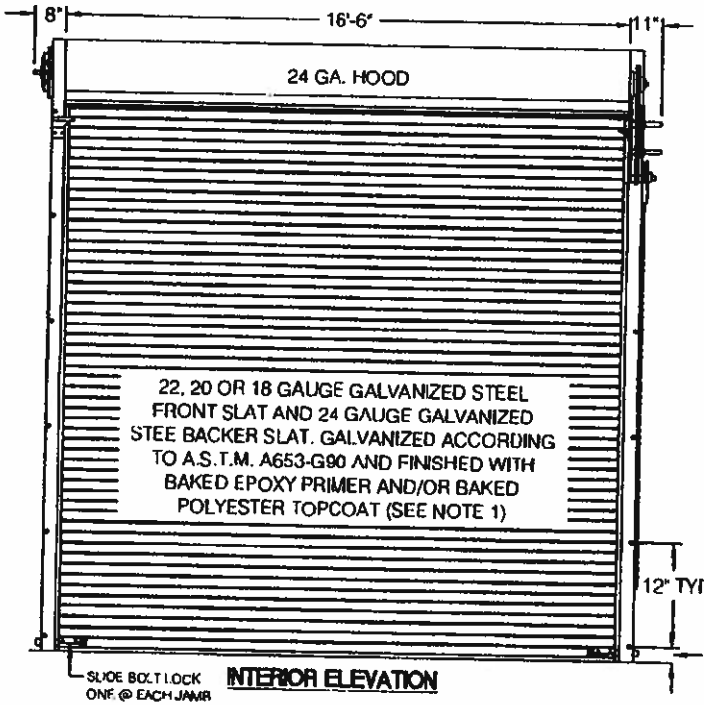
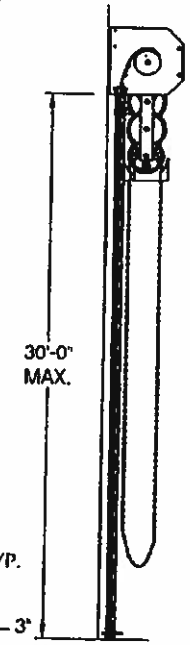
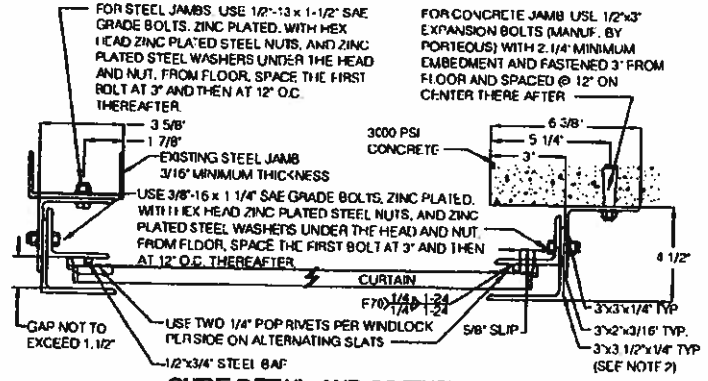


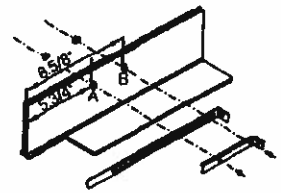
INTERIOR ELEVATION



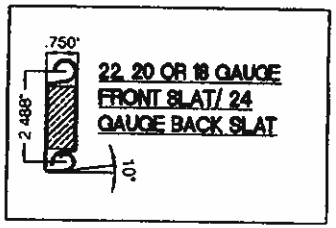
SIDE ELEVATION



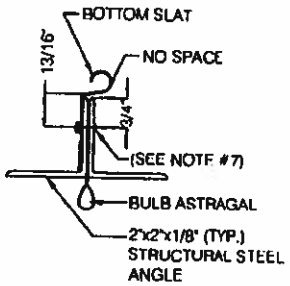
GUIDE DETAIL AND DIMENSIONS



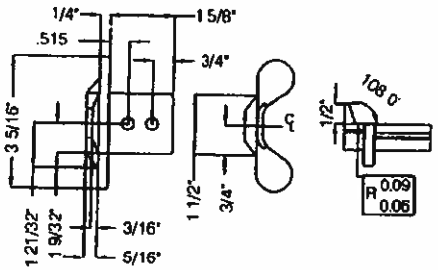
SLIDE BOLT LOCK



22, 20 OR 18 GAUGE FRONT SLAT/ 24 GAUGE BACK SLAT



BOTTOM BAR



MATERIAL: CAST IRON

WINDLOCK

STATE OF TEXAS
JOSEPH H. DIXON, JR.
18627
LICENSED
PROFESSIONAL ENGINEER

SEAL 4/30/13

ASTA Door Corporation
4255 McEver Industrial Dr.
Acworth, GA 30101
PH: (770) 924-2600/Fax (770) 974-1455
www.astadoor.com

600 SERIES INSULATED SLAT CERTIFIED WINDLOAD AND IMPACT RATED ROLLING STEEL SERVICE DOOR

SCALE: VARIES (DO NOT SCALE DRAWINGS)

TOLERANCES
FRACTION = +/- 1/32
.X = +/- .032
.XX = +/- .015
.XXX = +/- .005 < = +/- 5

DRAWN BY: BCLLC
ISSUE: 08-23-12

TEST SIZE	DESIGN PRESSURE	TEST PRESSURE
16'-6"W x 10'H	+60.0/-45.0 PSF	+75.0/-67.50 PSF

MODELS
622IV-22 GAUGE
620IV-20 GAUGE
618IM-18 GAUGE

TEST LOCATION
ELEMENT-ORLANDO
124 PREMIER ROAD
ORLANDO, FL 32822

TEST REPORT #ESP0101B1P
TEST DATES: 7/16/12 - 7/18/12

DRAWING #607-7-600M

SHEET 1 OF 2

Summary of Welded Jamb Connections
E-Guide to Steel Jamb

Series	Door ID	Slat gage	Tested Door* 16'-6" wide	Design Wind Load Pos psf	Design Wind Load Neg psf	Job No.	slip in	maximum P1pf catenary plf	P1nf catenary plf	Slot size	all weld spacings are maximums*** Weld in Slot Only min. 3/16" jamb in slot only	Weld in Slot plus Fillet Weld at Toe 3/16" jamb in slot	Weld in Slot plus Fillet Weld at Toe 3/16" jamb at toe
	1/4" Standard Wall Angle											slot and toe welds staggered	
400	418FIM	18		55.0	55.0	32022	0.625	2000	2000	9/16" x 3/4"	1/4" fillet weld** 12" o.c.	1/4" fillet weld** 12" o.c.	1/4 x 1-1/2 12" o.c.
	420FIM	20		55.0	55.0	"	0.625	2000	2000	9/16" x 3/4"			
	422FIM	22	Test	55.0	55.0	"	0.625	2000	2000	9/16" x 3/4"			
600	618IM	18		50.0	45.0	32022	0.625	1881	1663	9/16" x 3/4"	1/4" fillet weld** 12" o.c.	1/4" fillet weld** 12" o.c.	1/4 x 1-1/2 12" o.c.
	620IM	20		50.0	45.0	"	0.625	1881	1663	9/16" x 3/4"			
	622IM	22	Test	50.0	45.0	"	0.625	1881	1663	9/16" x 3/4"			

* doors tested with 1/2" bolts @ 12" o.c. connecting to 3/16" steel jamb per drawing
** fillet weld around full perimeter of slot
*** no spacings exceed the fastener spacing of the test

GENERAL NOTES:

1. STEEL USED FOR SLATS IS ASTM-A653 WITH MINIMUM YIELD OF 50 KSI AND TENSILE OF 60 KSI.
2. GUIDES COMPOSED OF STRUCTURAL STEEL ANGLES WITH MINIMUM .1875" THICKNESS.
3. INSULATION TO BE 5/8" POLYSTYRENE FOAM. EFFECTIVE INSULATING VALUE R= 5.0.
4. THE WINDLOCKS ARE ATTACHED TO EVERY OTHER SLAT BEGINNING AT THE BOTTOM SLAT. WINDLOCKS ARE ATTACHED USING TWO - 1/4" RIVETS.
5. THIS DOOR HAS BEEN DESIGNED AND TESTED IN ACCORDANCE WITH THE FLORIDA BUILDING CODE AND THE INTERNATIONAL BUILDING CODE. THE DESIGN WIND PRESSURES REQUIRED FOR ANY DOOR SHALL BE DETERMINED USING THE APPROPRIATE SECTION OF THE CODE HAVING JURISDICTION WHERE THE BUILDING IS LOCATED.
6. THIS DOOR HAS BEEN SUCCESSFULLY TESTED TO:
   -THE UNIFORM STATIC AIR PRESSURE TEST PER ASTM E-330 AND ANSI/DASMA 108 TO A DESIGN LOAD OF +50.0 & -45.0 PSF
   -THE LARGE MISSILE IMPACT TEST PER TAS 201 AND ANSI/DASMA 115 WITH THE IMPACT DIRECTION TOWARD THE EXTERIOR FACE OF THE SLATS.
   -THE CYCLIC WIND PRESSURE TEST PER TAS 203 AND ANSI/DASMA 115.
   -REFERENCE ELEMENT-ORLANDO, TEST REPORT #ESP010181P, TESTING DATES: 7/16/12 - 7/18/12.
7. BOTTOM BAR ASSEMBLY FASTENED 5 3/4" FROM EACH END AND 12" O.C. FROM CENTER USING 5/16" x 1" CARRIAGE BOLTS.

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DRAWN BY: BCI LC
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TEST LOCATION
ELEMENT-ORLANDO
124 PREMIER ROAD
ORLANDO, FL 32822

TEST REPORT #ESP010181P
TEST DATES 7/16/12 - 7/18/12

DRAWING #607-7-600IM
SHEET 2 OF 2