

Curtain (Doors)

Galvanized steel strip per ASTM A653, CS-B
Stainless steel strip per ASTM A240, T-304
Aluminum strip per ASTM B209, A5005-H34

Curtain (Grilles and Closures)

Extruded shapes per ASTM B221, 6061-T6 or 6063-T5 (depending on profile)
Stainless steel links, spacer tubes per ASTM A240, T-304
Stainless steel rods per ASTM A580, T-304

Insulation

Flame spread / smoke development per ASTM E84
EPS (non-fire rated doors) <75 / <450
Mineral wool (fire rated doors) 0 / 0

Bottom bar

Steel angle per ASTM A36
Stainless steel angle per ASTM A276, T-304
Extruded aluminum shapes per ASTM B221, 6061-T6 or 6063-T5 (depending on profile)

Guides

Steel angle per ASTM A36
Steel shapes formed from plate per ASTM A36
Stainless steel shapes formed from plate per ASTM A240, T-304
Extruded aluminum shapes per ASTM B221, 6061-T6 or 6063-T5 (depending on profile)

Barrel

Steel pipe per ASTM A53, Grade B [A500]
Cold finished steel shaft per ASTM A108, C1018
Torsion springs per ASTM A229, Class II
Iron castings per ASTM A48, Class 35
Steel discs cut from plate per ASTM A36

Brackets

Steel plate per ASTM A36

Gears

Iron castings per ASTM A48, Class 35

Hood

Galvanized steel sheet per ASTM A653, CS-B
Stainless steel sheet per ASTM A240, T-304
Aluminum sheet per ASTM B209, A5005-H34

Assembly bolts

Steel bolts per ASTM A307, Grade A

Electrical

Motor operator assembly UL labeled and listed per UL325 (and UL1203 for N79 rated units)
Motor and gearbox per NEMA MG1
Control equipment per NEMA ICS 1, 2
Control enclosures per NEMA ICS 6, Type 1 [4(12), 4X, 7/9]

Curtain (Doors)

Steel – G60 galvanized [AZ40 Zinc alum]
Stainless steel – brush finish (“No. 4”)
Aluminum – clear anodized

Curtain (Grilles and Closures)

Aluminum rods, links, tubes – mill finish [clear anodized]
Aluminum panels – clear anodized
Stainless steel rods – as-rolled
Stainless steel links, tubes – 2B

Bottom bar

Steel – shop applied rust inhibiting primer
Stainless steel – mill finish (brush finish on C-Series doors)
Aluminum – mill finish (on doors), clear anodized (on grilles and closures)

Guides

Steel – shop applied rust inhibiting primer
Stainless steel – mill finish (brush finish on C-Series doors)
Aluminum – clear anodized

Brackets

Steel – shop applied rust inhibiting primer

Hood

Steel – G60 galvanized [AZ40 Zinc alum]
Stainless steel – brush finish (“No. 4”)
Aluminum – clear anodized

Assembly bolts, misc. hardware

Zinc plate

Paint

Galvanized steel slats and hoods – thermo-setting primer and grey polyester top coat, combined dry film thickness of 1.0 mil per side
Other steel components – one coat shop applied low VOC rust inhibiting primer, air dried

Powder coat

TGIC polyester, Tiger Drylac RAL Series 49 or equivalent, typical average dry film thickness of 3 mils

Anodizing

Commercial clear anodized per AAMA Specification A212