

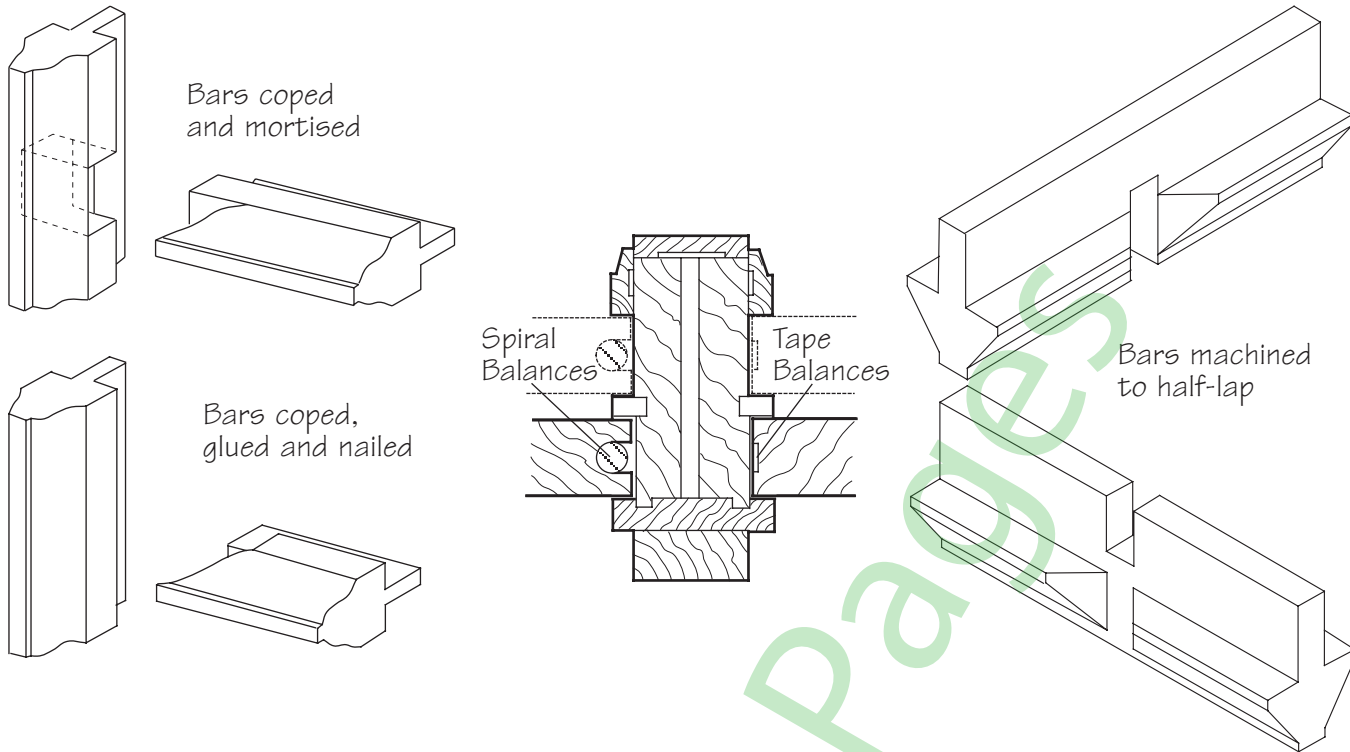
1000-T-4

Machining and Joinery Workmanship

In the absence of specifications, the following standards will apply. Where more than one method or material is listed for a Grade, woodworkers will supply their choice from the alternatives.

Workmanship	Premium	Custom	Economy
Plant Machining Considerations			
Sash parts	Moulded profiles (sticking) shall be at the option of the woodworker, unless full size details are shown in bid documents. Involve your woodwork manufacturer in the design.		
Joinery and Assembly Considerations			
Sash parts	Joined with haunched blind mortise and tenon, or slot mortise and tenon, or doweled; coped and glued with adhesive suitable for exterior use under pressure and pinned. Half-lap joints permitted at intersecting muntins.	Joined with mortise and tenon, or slot mortise and tenon, or doweled; coped and assembled under pressure and pinned. Half-lap joints permitted at intersecting muntins.	Mill option
Frames	Frame members to be dadoed, rabbeted, and plant assembled, with exterior trim applied.	Frame members to be dadoed, rabbeted, and plant assembled, with exterior trim applied.	Mill option
Alignment of bars and muntins	Must be at right angles to each other and to the sash members; align with each other vertically and horizontally; and must be aligned with similar members on adjoining sash		
Sash Thicknesses	44 mm [1-3/4"] minimum	35 mm [1-3/8"] minimum	35 mm [1-3/8"] minimum
NOTE: 44 mm [1-3/4"] is a common sash thickness, but consideration must be given to the size of the window and relation to local codes. There may be conditions for which the minimum thickness must be less than the standard.			
Glazing Considerations			
The woodwork manufacturer shall furnish glass and glazing only when specified. When the woodworker does the glazing, glass must be bedded in a proven glazing compound prior to application of face compound or wood bead.			
Unless specified otherwise, glazing materials and method of glazing shall be at the option of the woodworker.			
Hardware Considerations			
Operating hardware and finish must be specified, as it dictates the details of the construction. The woodworker shall machine for operating hardware, provided template or physical sample is furnished prior to the preparation of shop drawings. Unless specified, woodwork manufacturer does not supply or install operating hardware. Unless specified, woodworker does not supply or install locking devices, pulls, lifts, etc. (not considered operating hardware).			
Weatherstripping & Sash Balances			
Type and manufacturer must be specified. Unless specified, woodworker does not machine for, supply, or install weatherstripping or sash balances.			

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Machining and Joinery Details - Figure 1000-03

1000-T-5

Glass and Glazing

In the absence of specifications, the following standards will apply. Where more than one method or material is listed for a Grade, woodworkers will supply their choice from the alternatives.

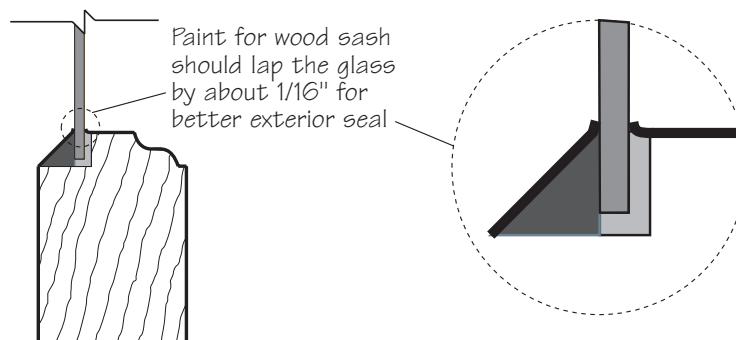
Glass/Glazing	Premium	Custom	Economy
Wood Moulding Glass Stop	Plant prepared, one side installed or solid sticking, other side tacked in place	Plant prepared and bundled in sets appropriately labeled for the jobsite	Shipped loose without preparation

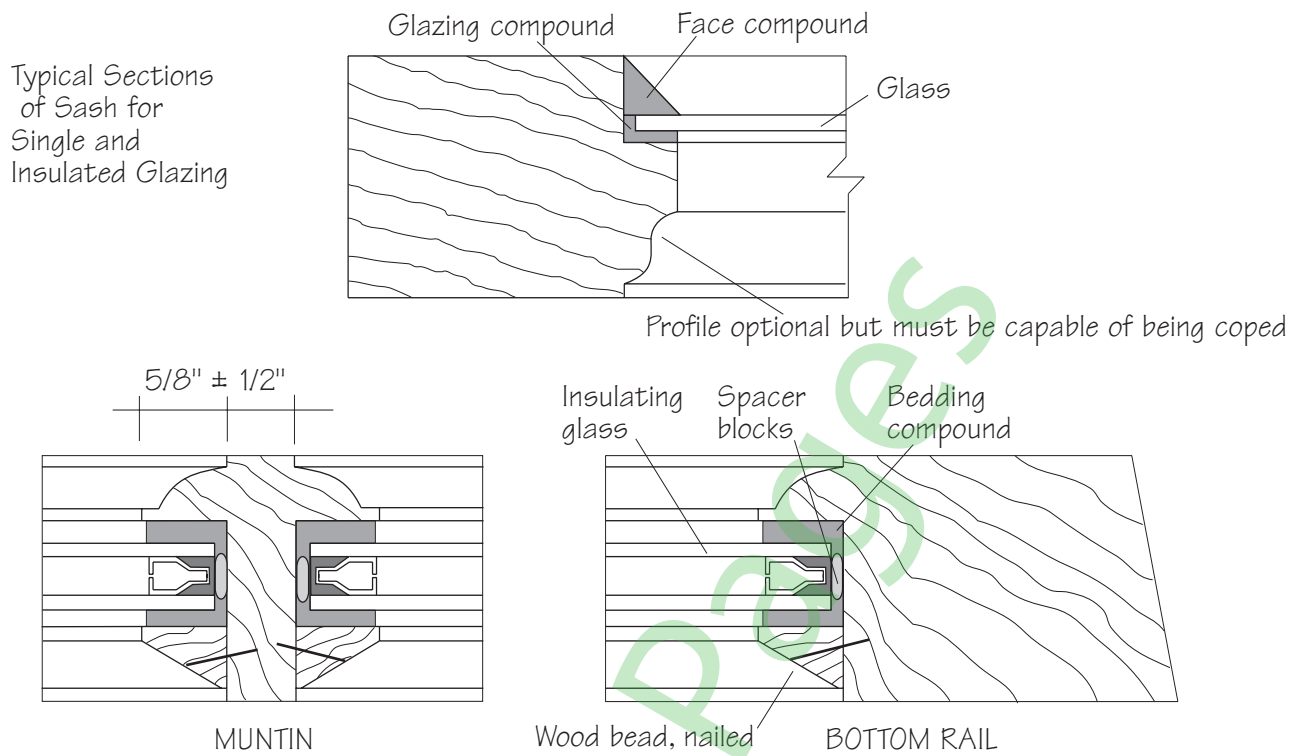
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Type, thickness, and manufacturer of glass, particularly insulated glass, must be specified as its construction dictates details of the receiving members. Specifications regarding code compliance are the responsibility of the design professional.

Trim glazed openings with wood mouldings of the profile indicated in the contract documents, removable one side. In the absence of specifications, profile shall be mill option. Removable stop to be placed on the exterior face of the fixed glazed frame when mounted in exterior openings.

It is recommended that the following be included in the painting section of the specifications: "To create the proper seal against weather, wind, and rain, the finish coats of all windows and sash shall be allowed to flow onto the glass area at least 1.6 mm [1/16"]. When cleaning the glass, a razor blade shall not be used to scrape the glass. This will destroy the seal. A broad blade putty knife shall be used to protect the seal between the glass and the wood."





Glazing Details - Figure 1000-04

1000-T-6

Smoothness of Exposed Surfaces (Minimum Requirements)

Smoothness Table	Premium		Custom		Economy	
	Transparent	Opaque	Transparent	Opaque	Transparent	Opaque
Sharp edges (Arris)	Eased with fine abrasive		Eased with fine abrasive		Mill option	
Top flat surfaces	150 grit		120 grit		100 grit or 15 KCPI	
Moulded surfaces	120 grit		minimum 20 KCPI			
Shaped surfaces	120 grit		minimum 20 KCPI			
Turned surfaces	120 grit		100 grit			
Sanding cross scratches	None allowed	Not to exceed 6.4 mm [.25"]	None allowed	Not to exceed 6.4 mm [.25"]		

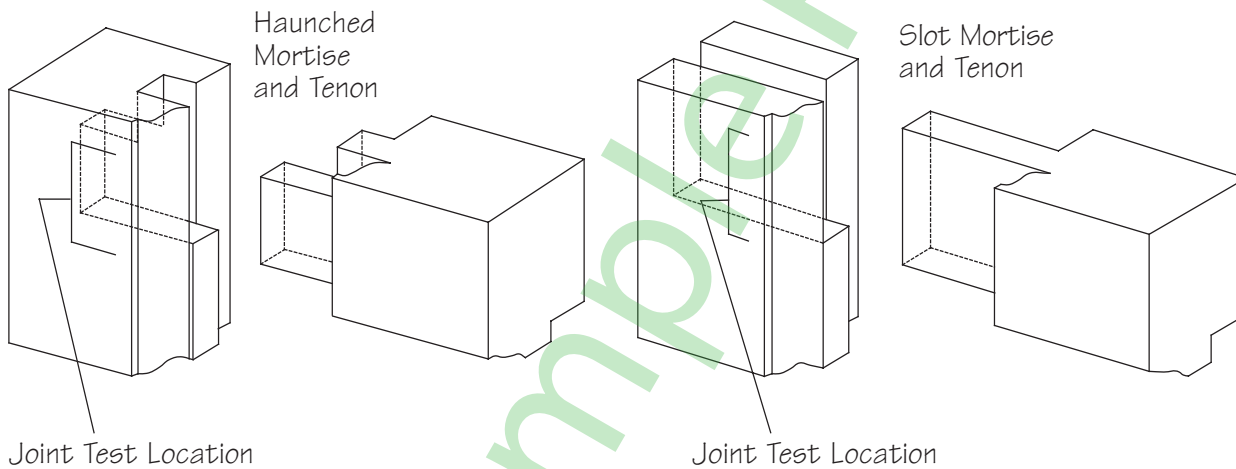
NOTE: No tearouts, knife nicks, or hit-or-miss finish allowed. No knife marks allowed where sanding is required. Surface variations as a result of multiple tool passes treated as turned surfaces above. Glue and filler, if used, must be inconspicuous and sanded as smoothly as the surrounding surface. Sanding before final stain and/or finish should be a consistent grit and scratch pattern, as it influences blend of color and sheen between components. Top Flat Surfaces are those which which can be sanded with a drum or wide belt sander. Turnings are customarily sanded on the lathe, and will exhibit cross scratches.

Before finishing, all exposed portions of architectural woodwork shall have handling marks or effects of exposure to humidity or moisture removed by a thorough uniform final sanding. The sanded surface shall then be cleaned and dust free, prior to proceeding with the first step in the finishing process. Veneer sand-through, with veneer sanded to the point where cross banding or core is visible, and/or core telegraphing (variation from a true plane in excess of 0.25 mm [0.010"] in any 76 mm [3"] span) is not allowed in any Grade.

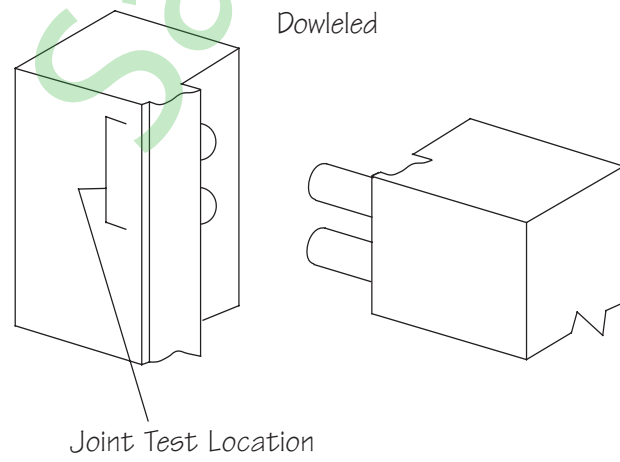
1000-T-7

Tightness of Plant Assembled Joints

Plant Assembled Joint Table	Premium		Custom		Economy	
	Interior	Exterior	Interior	Exterior	Interior	Exterior
Maximum gap: Test A	0.4 mm [.015"] wide by 20% of joint length	0.6 mm [.025"] wide by 30% of joint length	0.6 mm [.025"] wide by 20% of joint length	1.3 mm [.050"] wide by 30% of joint length	1.3 mm [.050"] wide by 20% of joint length	1.9 mm [.075"] wide by 30% of joint length
Maximum gap: Test B	0.4 mm [.015"] x 76 mm [3"], and no gap may occur within 1829 mm [72"] of a similar gap	0.6 mm [.025"] x 152 mm [6"], and no gap may occur within 762 mm [30"] of a similar gap	0.6 mm [.025"] x 152 mm [6"], and no gap may occur within 1524 mm [60"] of a similar gap	1.3 mm [.050"] x 203 mm [8"], and no gap may occur within 660 mm [26"] of a similar gap	1.3 mm [.050"] x 203 mm [8"], and no gap may occur within 1219 mm [48"] of a similar gap	1.9 mm [.075"] x 254 mm [10"], and no gap may occur within 610 mm [24"] of a similar gap
Maximum gap: Test C	0.4 mm [.015"]	0.6 mm [.025"]	0.6 mm [.025"]	1.3 mm [.050"]	1.3 mm [.050"]	1.9 mm [.075"]
Maximum gap between fixed components shall be tested at points designed to join; where members connect or touch.						
Flushness Variation	0.03 mm [.001"]	0.4 mm [.015"]	0.1 mm [.005"]	0.6 mm [.025"]	0.6 mm [.025"]	1.3 mm [.050"]



Joint Test A or B shall be applied, whichever is more restrictive. Joint Test C is not used here.



Test Locations - Figure 1000-05



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