



ASTA Door Corporation



The Model 622 Heavy Duty Insulated Rolling Steel Service Door

ASTA Door Model 622 (22 gauge front/24 gauge back) Insulated Rolling Steel Service Door is produced with the highest quality and durability in the industry. The Model 622 consists of 3" 22 gauge flat slat with 24 gauge backer that encloses a 5/8" insulation strip between the two slats. The Model 622 has two finish options - White Topcoat or Prime Gray. The Model 622 is available in sizes up to 24 x 20. Standard features include enclosed hood with baffle, reduction gear chain hoist, 3 piece structural steel guides with weatherseal, and a double angle bottom bar with weatherseal. The Model 622 is the perfect choice for industrial, commercial, or climate controlled applications.

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Specifications:

Standard Features:

Slats (1) ... 22 gauge (front) and 24 gauge (back) galvanized steel roll formed in continuous lengths. Galvanized according to ASTM A653-G90, and finished with baked epoxy primer and/or baked polyester topcoat.

*Insulation ... to be 5/8" polystyrene foam. Effective insulating value to be R=5.0.

Endlocks (2) ... 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.

Bottom Bar (3) ... Curtain to be reinforced with a bottom bar consisting of two 2" x 1 1/2" x 1/8" structural steel angles with P.V.C. bulb astragal.

Hand Chain Lock (4) ... Lockable bracket mounted on guide angle or wall suitable for padlocking (padlock by others).

Drum Assembly (5) ... Barrel to be a steel pipe of diameter and wall thickness to restrict maximum deflection to .03" per foot door width.

Springs to be oil tempered grease packed helical torsion type designed to cycle 20,000 times with an overload factor of 25%. Springs are to be mounted on a cold rolled steel inner shaft.

End Bearing to be self-lubricating ball bearings.

Bracket Assembly (6) ... Bracket Plates to be 1/4" minimum thickness steel plate and enclose ends of barrel assembly.

Drive End Bracket Plate to be filled with a self-aligning sealed ball bearing.

Operation (7) ... Drive to consist of roller chains and sprockets.

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

Guide Assembly (8) ... Wall Angles to be 3/16" minimum thickness structural steel.

Guide Angles to be 3/16" minimum thickness structural steel with removable headstops. Guide Depth to provide slat penetration adequate to satisfy specified windloading.

Guide Weatherseal (9) ... One piece vinyl weather seal attached to door guide on the non-coil side (brush seal with retainer available upon request).

Hoods (10) ... Hoods to be 24 gauge galvanized steel with baked epoxy primer and/or baked polyester topcoat and designed to enclose door coil.

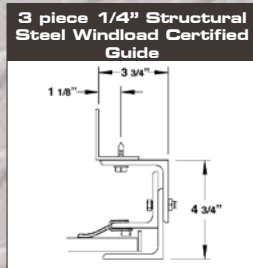
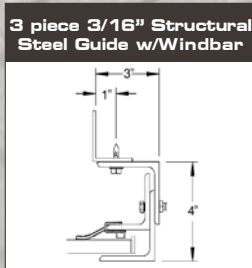
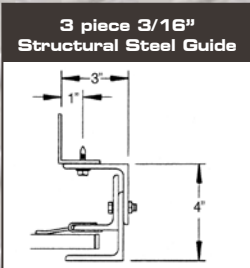
Reinforcing to be 1/4" thick steel brackets for door over 16'0" wide.

Hood Baffle (11) ... 8" wide pvc rubber riveted to the inside of the hood.

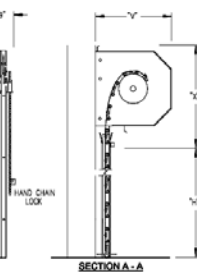
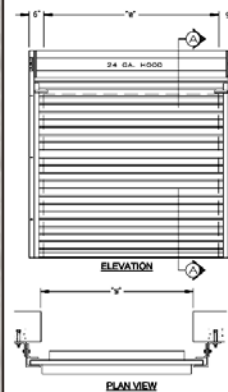


Options:

- Electric Operation - Easy fast motorized operation at a push of a button (motor mounting plates available on request).
- Slide Bolt Locks - Dual 1/4" steel slide bolt locks attached to bottom suitable for padlocks (padlocks by other) (standard for manual/push-up operation).
- Vision Panels - 5" x 3/4" cut out spaced approximately 3" apart and covered with clear Lexan.
- Windload - Available design to +/- 45 PSF up to 16' wide, tested to +/- 67.5 PSF based on ASTM E-330 test method to meet Florida Building Code requirements. +/- 31 PSF for up to 20' wide also available.
- Gauges - For 20 gauge refer to Model 620
 For 18 gauge refer to Model 618



Clearance Requirements



Dimension Options:

Headplate Size	X	V
14"	19"	15"
16"	21"	17"
22"	28"	23"

Sideroom:

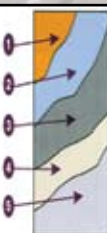
Drive Side: 9"

Non Drive: 6"

Dura-Finish Paint Process

The ASTA process is designed to give a longer life, with less maintenance and much better protection against the elements such as weather and dust. Our method produces one of the best systems in our industry for a longer lasting and more maintenance free finish. Our system produces one of the thickest top coat finishes in our industry.

- 1 Strip steel per ASTM A-526.
- 2 Hot dip galvanized-G90 coating per ASTM A-653.
- 3 Bonderized for prime coat adhesion.
- 4 Corrosion inhibiting primer-minimum thickness (.2) mils on each side.
- 5 Dura finish (white polyester top coat minimum thickness 1.0 mill front side, .5 mill back side.)



* ASTA Door Corporation reserves the right to change engineering specifications without prior notice.

* Illustrations shown are for general reference and should be verified for construction purposes.