

STATE OF TEXAS  
 JOSEPH H. DIXON, JR.  
 18627  
 LICENSED PROFESSIONAL ENGINEER  
 SEAL  
 4/30/13

**AGC**  
 4255 McEver Industrial Dr.  
 Acworth, GA 30101  
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 ASTA Door Corporation www.astador.com

**400 SERIES FLAT 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: 3CLLC  
 ISSUF: 08-23-12

TEST SIZE	DESIGN PRESSURE	TEST PRESSURE
10'-0" W x 10'H	+/- 550	+/- 82.5
MODELS	TEST LOCATION	
422FIM-22 GAUGE 420FIM-20 GAUGE 416FIM-18 GAUGE	ELEMENT-ORLANDO 124 PREMIER ROAD ORLANDO, FL 32822	
	TEST REPORT #ESP010181P TEST DATES: 6/18/12 - 6/21/12	

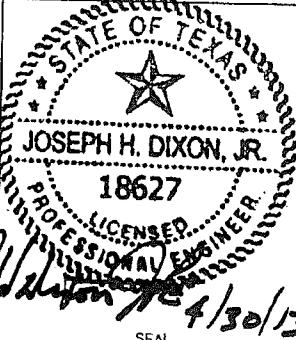

Summary of Welded Jamb Connections  
E-Guide to Steel Jamb

Series	Door ID	Slat gage	Tested Door* 16'-6" wide	Design Wind Load		Job No.	slip in	maximum		Slot size	all weld spacings are maximums***		
				Pos psf	Neg psf			P1pf catenary plf	P1nf catenary plf		Weld in Slot Only		Weld in Slot plus Fillet Weld at Toe
											min. 3/16" jamb in slot only	3/16" jamb in slot	at toe slot and toe welds staggered
<b>1/4" Standard Wall Angle</b>													
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:**

- STEEL USED FOR SLATS IS ASTM-A653 WITH MINIMUM YIELD OF 50 KSI AND TENSILE OF 60 KSI.
- GUIDES COMPOSED OF STRUCTURAL STEEL ANGLES WITH MINIMUM .1875" THICKNESS.
- THE WINDLOCKS ARE ATTACHED TO EVERY OTHER SLAT BEGINNING AT THE BOTTOM SLAT. WINDLOCKS ARE ATTACHED USING TWO - 1/4" x 15/32" STEEL, ZINC PLATED RIVETS.
- 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.
- 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 +/- 55.0PSF  
 -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: 6/18/12 - 6/21/12.
- 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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	<b>400 SERIES FLAT SLAT CERTIFIED WINDLOAD AND IMPACT RATED ROLLING STEEL SERVICE DOOR</b>		
SCALE: VARIES (DO NOT SCALE DRAWINGS) TOLERANCES FRACTION = +/- 1/32 .X = +/- .032 .XX = +/- .015 .XXX = +/- .005 < +/- 5	<b>TEST SIZE</b> 18'-6" W x 10'H	<b>DESIGN PRESSURE</b> +/- 65.0	<b>TEST PRESSURE</b> +/- 62.5
DRAWN BY: BCLLC ISSUE: 08-23-12	MODELS 422FIM-22 GAUGE 420FIM-20 GAUGE 418FIM-18 GAUGE	TEST LOCATION ELEMENT-ORLANDO 124 PREMIER ROAD ORLANDO, FL 32822 TEST REPORT #ESP010181P TEST DATES: 6/18/12 - 6/22/12	
DRAWING # 607-5-400FIM			SHEET 2 OF 2