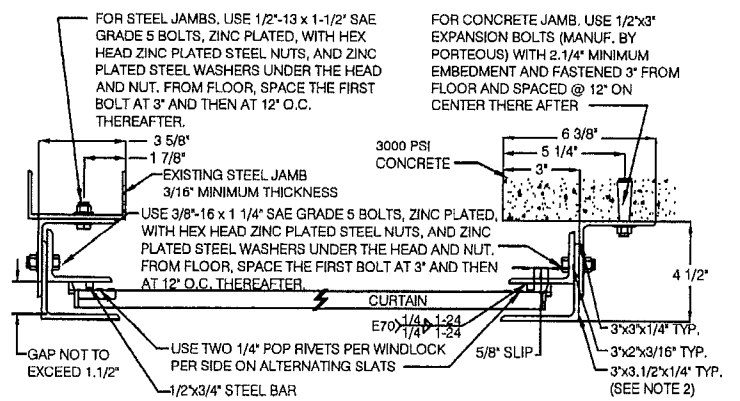
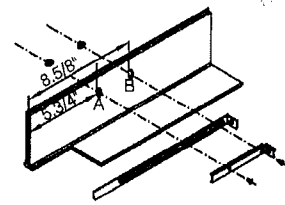


SLIDE BOLT LOCK ONE @ EACH JAMB
INTERIOR ELEVATION

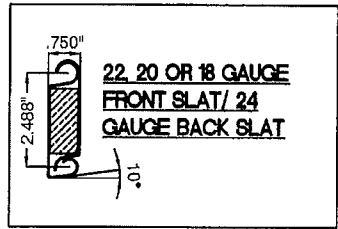
SIDE ELEVATION



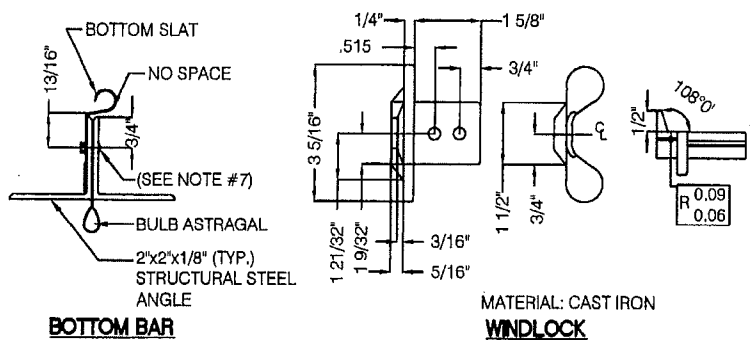
GUIDE DETAIL AND DIMENSIONS



SLIDE BOLT LOCK

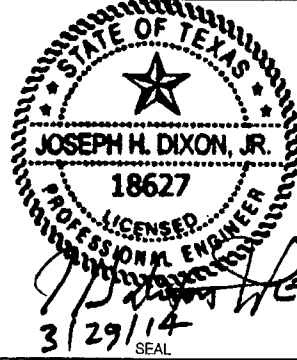


22, 20 OR 18 GAUGE FRONT SLAT/ 24 GAUGE BACK SLAT



BOTTOM BAR

MATERIAL: CAST IRON
WINDLOCK



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

600 SERIES INSULATED SLAT CERTIFIED WINDLOAD ROLLING STEEL SERVICE DOOR

SCALE: VARIES (DO NOT SCALE DRAWINGS)	TEST SIZE 16'-6"W x 10'H	DESIGN PRESSURE +50.0/-45.0 Psf	TEST PRESSURE +75.0/-67.50 Psf
TOLERANCES FRACTION = +/- 1/32 .X = +/- .032 .XX = +/- .015 .XXX = +/- .005 < +/- .5	MODELS 622M-22 GAUGE 620M-20 GAUGE 618M-18 GAUGE	TEST LOCATION ELEMENT-ORLANDO 124 PREMIER ROAD ORLANDO, FL 32822	TEST REPORT #ESP010181P-2 REPORT DATED: 8/17/12
DRAWN BY: BCLLC ISSUE: 02-11-14	DRAWING #607-8-600M-2		SHEET 1 OF 3

Summary of Welded Jamb Connections
E-Guide to Steel Jamb

all weld spacings are maximums***

Series	Door ID	Slat gage	Tested Door* 16'-6" wide	Design Wind Load		slip in	Slot size	Weld in Slot Only		Weld in Slot plus Fillet Weld at Toe	
				Pos psf	Neg psf			min. 3/16" jamb in slot only	3/16" jamb in slot	at toe	
1/4" Standard Wall Angle									slot and toe welds staggered		
600	618M	18		50.0	45.0	0.625	9/16" x 3/4"	1/4" fillet weld**	1/4" fillet weld**	1/4 x 1-1/2	
	620M	20		50.0	45.0	0.625	9/16" x 3/4"	12" o.c.	12" o.c.	12" o.c.	
	622M	22	Test	50.0	45.0	0.625	9/16" x 3/4"				

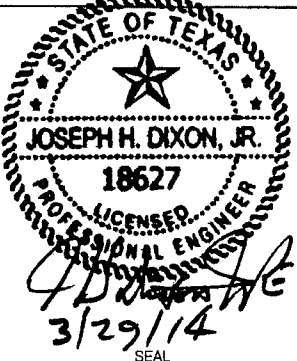

* doors tested with 1/2" bolts @ 12" o.c. connecting to 3/16" steel jamb per drawing

** 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 YIELD STRENGTH OF 36 KSI.
- INSULATION TO BE 5/8" POLYSTYRENE FOAM. EFFECTIVE INSULATING VALUE R= 5.0.
- THE WINDLOCKS ARE ATTACHED TO EVERY OTHER SLAT BEGINNING AT THE BOTTOM SLAT. WINDLOCKS ARE ATTACHED USING TWO - 1/4" 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 +50.0 & -45.0 PSF
-REFERENCE ELEMENT-ORLANDO, TEST REPORT #ESP010181P-2, DATED: 8/17/12.
- BOTTOM BAR ASSEMBLY FASTENED 5 3/4" FROM EACH END AND 12" O.C. FROM CENTER USING 5/16" x 1" CARRIAGE BOLTS.

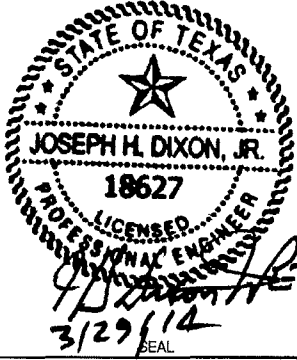

				4255 McEver Industrial Dr. Acworth, GA 30101 PH: (770) 974-2600/Fax: (770) 974-1455 www.astadoor.com
	600 SERIES INSULATED SLAT CERTIFIED WINDLOAD ROLLING STEEL SERVICE DOOR			
SCALE: VARIES (DO NOT SCALE DRAWINGS) TOLERANCES FRACTION = +/- 1/32 .X = +/- .032 .XX = +/- .015 .XXX = +/- .005 < +/- .5	TEST SIZE 16'-6" W x 10'H	DESIGN PRESSURE +60.0/-45.0 PSF	TEST PRESSURE +76.0/-67.50 PSF	
DRAWN BY: BCLLC ISSUE: 02-11-14	MODELS 622M-22 GAUGE 620M-20 GAUGE 618M-18 GAUGE	TEST LOCATION ELEMENT-ORLANDO 124 PREMIER ROAD ORLANDO, FL 32822 TEST REPORT #ESP010181P-2 REPORT DATED: 8/17/12		
DRAWING #607-8-600M-2				SHEET 2 OF 3

622M Insulated Slat Door
also 620M and 618M

Summary of Catenary Forces for alternative doors
Compared to Element Materials Technology Report No.: ESP010181P-2, dated 08/17/12
Rolling Steel Slat Door (Insulated Slat)
Test Door: 16'-6" wide x 10' high, Design Windload +50 / -45 psf
Static air pressure test conducted in accordance with ASTM E330-02 and DASMA 108-05

	Width	Design Windload		Insulated Slat Door	
	ft	Pos psf	Neg psf	Model	gage in
16'-6" x 10'-0" Test Door	16.5	50	45	622M 620M 618M	.029 / .022
Calibration calculations for test door					
Comparative forces by calculation to determine maximum design pressure					
Max Door Size					
8 x 30	8	85.6	78.1	622M	.029 / .022
9 x 30	9	85.6	78.1	622M	.029 / .022
10 x 30	10	85.6	78.1	622M	.029 / .022
11 x 30	11	85.6	78.1	622M	.029 / .022
12 x 30	12	85.6	78.1	622M	.029 / .022
12'-6" x 30	12.5	85.6	78.1	622M	.029 / .022
13 x 30	13	79.1	72.0	622M	.029 / .022
14 x 30	14	68.3	61.9	622M	.029 / .022
15 x 30	15	59.8	54.0	622M	.029 / .022
16 x 30	16	52.9	47.7	622M	.029 / .022
16'-6" x 30	16.5	50.0	45.0	622M	.029 / .022
17 x 30	17	47.4	42.6	622M	.029 / .022
18 x 30	18	42.7	38.3	622M	.029 / .022
19 x 30	19	38.8	34.7	622M	.029 / .022
20 x 30	20	35.4	31.6	622M	.029 / .022
20'-6" x 30	20.5	33.9	30.3	622M	.029 / .022

Design wind forces are calculated to produce catenary forces at the guides equal to or less than those calculated for the test door. This indicates that the curtain, windlocks, windlock connections, guide angles, and jamb anchorages will all be stressed to approximately the same as those in the test door, provided that the door is constructed the same for all opening widths.

	 4255 McEver Industrial Dr. Acworth, GA 30101 PH: (770) 974-2600/Fax: (770) 974-1455 www.astadoor.com		
	600 SERIES INSULATED SLAT CERTIFIED WINDLOAD ROLLING STEEL SERVICE DOOR		
SCALE: VARIES (DO NOT SCALE DRAWINGS) TOLERANCES FRACTION = +/- 1/32 .X = +/- .032 .XX = +/- .015 .XXX = +/- .005 < =/- 5	TEST SIZE 16'-6"W x 10'H	DESIGN PRESSURE +50.0/-45.0 PSF	TEST PRESSURE +75.0/-67.50 PSF
DRAWN BY: BCLLC ISSUE: 02-11-14	MODELS 622M-22 GAUGE 620M-20 GAUGE 618M-18 GAUGE	TEST LOCATION ELEMENT-ORLANDO 124 PREMIER ROAD ORLANDO, FL 32822 TEST REPORT # ESP010181P-2 REPORT DATED: 8/17/12	
DRAWING #607-8-600M-2			SHEET 3 OF 3

ASTA Door Corp
Job No. 34003

622M Insulated Slat Door
also 620M and 618M

Joseph H. Dixon, Jr. P.E.
FL 7768, TX 18627
02/02/14

Summary of Catenary Forces for alternative doors for TDI (TEXAS)
Compared to Element Materials Technology Report No.: ESP010181P-2, dated 08/17/12
Rolling Steel Slat Door (Insulated Slat)
Test Door: 16'-6" wide x 10' high, Design Windload +50 / -45 psf
 Static air pressure test conducted in accordance with ASTM E330-02 and DASMA 108-05

	Width	Design Windload		Insulated Slat Door		Catenary Force		Slip	Remarks
	ft	Pos psf	Neg psf	Model	gage in	Pos wind plf	Neg wind plf	in	
16'-6" x 10'-0" Test Door	16.5	50	45	622M	.029 / .022				Test Door Design test pressure: +50 / -45 psf Max test pressure: +75 / -67.5 psf
Calibration calculations for test door						1773	1554	0.625	
Comparative forces by calculation to determine maximum design pressure									All doors constructed same as test door
Max Door Size									
8 x 30	8	85.6	78.1	622M	.029 / .022	≤1771	≤1552	0.375	Forces ≤ test door, OK
9 x 30	9	85.6	78.1	622M	.029 / .022	≤1771	≤1552	0.375	Forces ≤ test door, OK
10 x 30	10	85.6	78.1	622M	.029 / .022	≤1771	≤1552	0.375	Forces ≤ test door, OK
11 x 30	11	85.6	78.1	622M	.029 / .022	≤1771	≤1552	0.625	Forces ≤ test door, OK
12 x 30	12	85.6	78.1	622M	.029 / .022	≤1771	≤1552	0.625	Forces ≤ test door, OK
12'-6" x 30	12.5	85.6	78.1	622M	.029 / .022	1771	1552	0.625	Forces ≤ test door, OK
13 x 30	13	79.1	72.0	622M	.029 / .022	1772	1552	0.625	Forces ≤ test door, OK
14 x 30	14	68.3	61.9	622M	.029 / .022	1772	1553	0.625	Forces ≤ test door, OK
15 x 30	15	59.8	54.0	622M	.029 / .022	1773	1554	0.625	Forces ≤ test door, OK
16 x 30	16	52.9	47.7	622M	.029 / .022	1771	1553	0.625	Forces ≤ test door, OK
16'-6" x 30	16.5	50.0	45.0	622M	.029 / .022	1773	1554	0.625	Test Door
17 x 30	17	47.4	42.6	622M	.029 / .022	1774	1555	0.625	Forces ≤ test door, OK
18 x 30	18	42.7	38.3	622M	.029 / .022	1774	1555	0.625	Forces ≤ test door, OK
19 x 30	19	38.8	34.7	622M	.029 / .022	1774	1554	0.625	Forces ≤ test door, OK
20 x 30	20	35.4	31.6	622M	.029 / .022	1774	1555	0.625	Forces ≤ test door, OK
20'-6" x 30	20.5	33.9	30.3	622M	.029 / .022	1774	1555	0.625	Forces ≤ test door, OK

Design wind forces are calculated to produce catenary forces at the guides equal to or less than those calculated for the test door. This indicates that the curtain, windlocks, windlock connections, guide angles, and jamb anchorages will all be stressed to approximately the same as those in the test door, provided that the door is constructed the same for all opening widths. Slat thicknesses for Models 620M and 618M are 0.036"/0.022" and 0.045"/0.033" respectively

