

**CRITTALL WINDOWS NBS SPECIFICATION
CORPORATE 2000 PRISON WINDOW**

L10 - WINDOWS

318 STEEL WINDOWS:

- Manufacturer and reference: Crittall Windows Ltd, **Corporate 2000 range**
- Generally manufactured in accordance with BS 6510, exclusively designed sections (Patent No. 93/05514.3) and Home Office approved, specially formed with continuous weather/vision trip grooves 8 mm wide x 1.5 mm deep. Frame sections are flat-faced or enhanced surface quality of the metal.
- Weathertightness: To BS 6375: Part 1
Exposure category (Design wind pressure): 2000 Pa
Air permeability: < 16m³/h/m
Water-tightness: No gross leakage @ 300 Pa
Wind Resistance/Strength of Materials: N.P.D @ 2000 Pa.
Operation and Strength characteristics: To BS 6375: Part 2
- Construction: All frames have welded corners and are flat and square within normal manufacturing dimensional tolerances of +/- 1.5 mm. Intermediate bars will be hot tenon riveted. Multilight frames are constructed with welded butt-on fixed lights or hot tenon riveted intermediate bars.
- Galvanising: All components including steel attachments are hot-dipped after manufacture to BS EN ISO 1461:1999
- Glazing Details: Will accept double glazing up to 29mm in thickness.
- Glazing Mechanism:
Double Glazing: suited to factory glazing comprising mechanically retained clip in extruded aluminium glazing beads and a bonded silicone capping system.
Drained and ventilated dry glazing systems to be utilised.
Single glazing: is a solid looking extruded aluminium bead with tamper proof screws.
- Weatherstripping: Ventilators are pressure equalised and fitted with twin gaskets (external rainscreen/internal air seal) in a co-extrusion applied with hot melted adhesive. Gasket profiles are part cut at 150mm centres obviating ligature use of gaskets.
- Ironmongery/accessories: See clause 328
- Finish as delivered: Duralife (see clause 331)

325 STEEL WINDOWS:

- Generally all the foregoing [316-324 inclusive]
- Manufacturing undertaken in the Crittall factory by directly employed personnel.
- Design testing, manufacture and installation carried out under Quality Management Systems certified to BS EN ISO.9001

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328 IRONMONGERY/ACCESSORIES:

- Standard provisions: Frames fitted with shortened grip prison handle with shake proof screw and flat washer concealed by a stainless steel shroud. Handle plate restricts rotation to 50°. A restrictor at head and sill restricts opening to 35° (variable to suit requirements).
- Hinging: Manufactured from hot rolled steel profiles incorporating friction inserts adjustable by threaded stainless steel hinge bolts with friction grip-nuts.
- The ligature free ventilation system comprises a 2mm box construction of pressed steel, flat faced with equally spaced ventilation holes of 3mm diameter at 5mm pitch, in a set pattern to give variable air flow, the maximum free air being 22,354mm² for a window unit height of 1004mm. Designed to give the legislative air flow for a Home Office approved cell in conjunction with mechanical ventilation.
- Ventilation is controlled by a recessed, flush fitting rotary knob, controlling internal baffles. The unit houses an internal fly screen and is placed and retained within the housing unit from the exterior with the use of the Crittall Standard Glazing system that is Home Office approved. All fixings used within this ventilation system utilise Home Office approved security head screws.
- The system can be positioned horizontally or vertically within Corporate 2000 frame units of Home Office Standard configuration.
- All optional stainless steel grille is available for external mounting, as an anti-tamper device in ground floor locations.

331 FINISH COATING

- Type/reference: Epoxy free polyester powder coating using Interpon D36 powder, Duralife.
- To BS 6497
- Preparation: Following galvanising, windows are chemically cleaned and pre-treated to provide surface to which powder coating will adhere.
- Covering: Minimum 60 microns on all significant surfaces.
- Colours: Wide selection available. See Crittall Colour Selector.
- Process: Coating will be undertaken in the same manufacturing plant as the frame fabrication.