

	TECHNICAL SPECIFICATION FOR ROLLING STEEL SHUTTERS/GRILLS	SPECIFICATION NO. PE-TS-999-600-C016	
		VOLUME - II B	
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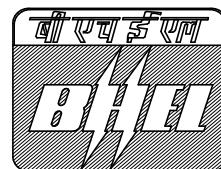
VOLUME – II B
CIVIL, STRUCTURAL & ARCHITECTURAL WORKS

SPECIFICATION NO. PE-TS-999-600-C016

SECTION - D

GENERAL TECHNICAL SPECIFICATION

ROLLING STEEL SHUTTERS/GRILS



Bharat Heavy Electricals Limited
Project Engineering Management
PPEI Building, Power Sector,
Plot No. 25, Sector 16A,
Noida (U.P.)-201301

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**TECHNICAL SPECIFICATION
FOR
ROLLING STEEL SHUTTERS/GRILLS**

1.0.0 SCOPE

This specification covers the design, supply of materials, fabrication, delivery and erection of Rolling Shutters/Grills with motor drive and/or manual operation including all accessories as hereinafter specified.

2.0.0 INSTALLATION

2.1.0 Components

- a) Slats for rolling shutters shall be made from tested bright cold rolled, annealed M.S. strips, not less than 0.9 mm thick for shutters upto 4.5 M wide and not less than 2.25 mm thick for shutters 5.5 M wide and above, machine rolled at 75 mm rolling centres, interlocking with each other. The profile will be such as to prevent excessive deflection under specified wind load.
- b) Rolling grills shall be constructed out of 6 mm dia. rods at 35 mm on centres running horizontally flexible connected with vertical links spaced not more than 200 mm centres. Alternatively, rolling grills shall be made from perforated slats of approved design reinforced with 6 mm dia rods.
- c) End locks shall be heavy type M.C.I./C.I. and shall be provided at each end of alternate slats unless specified otherwise in the Schedule.
- d) Bottom bars shall be finished with two angles not less than 6 mm thick for external shutters. When shown on drawings, a flexible weather strip shall be applied to make tight contact with the floor.
- e) Guides shall be of such depth as to retain the shutter under a wind pressure of 100 Kg/Sq.M or as specified in Schedule.
- f) Shafts shall be of steel pipe of sufficient size to carry the torsion load with a maximum deflection of 1/360th of span.

Grease packed ball bearings or bushings shall be provided for smooth trouble free operation.

- g) Hoods shall be formed of not less than 20 gauge steel, suitable reinforced to prevent sag.
- h) Locks shall be slide bolt and hasp, or cylinder lock operable from one or both sides. Provision securing hand chain with pad-lock, provision for removable handle for hand cranks etc. shall be made as described

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in Schedule or as described by the Engineer.

- i) Power unit shall be suitable for 3 phase, 50 cycle, 400 volt A.C. power supply and shall be either floor or wall mounted unit. The motor shall be of sufficient capacity to move the shutter in either direction at a speed of 0.3 metres per second. In addition to the gear motor each standard power unit shall include a magnetic brake, a reversing starter with built-in overload protection, a geared limit switch and one push button station located inside the building unless otherwise stated drawing.
- It is desirable that the bottom bar of motor operated doors shall be provided with a sensitive edge, electrically connected to stop the travel of the door on meeting an obstruction.
- j) Operating chains shall be of tested quality, heavily galvanised and with all ends rounded to assure smooth operation and hand protection.
- k) Reduction gears shall be high strength gray cast iron, machine moulded from machine out patterns.

2.2.0 Manually Operated Shutters/Grills

Manually operated shutters shall be easily operable by one person. The speed of operation shall be about 1.3 metres per second. In general, manually operated shutters shall be push pull type for openings upto 9 Sq.metre in area. Larger shutters shall be either chain and gear operated or crank and gear operated. The crank handle shall be removable. All shutters shall be lockable from one or both sides as described as desired by the Engineer.

2.3.0 Power Operated Shutters/Grills

These shall be operable from a push button station conveniently located beside the door or as shown on drawings. One emergency hand chain/crank operation shall also be provided for use in case of failure of the electric system. Where called for in Schedule, externally mounted shutters shall be operated by control mechanism located inside the building.

2.4.0 **Shop Coat**

Shutters shall be painted with one coat of red lead or zinc chromate primer. Where specified, doors shall be galvanized and subsequently painted one coat of zinc chromate for adhesion of field coat.

2.5.0 Erection

Door shall be installed by the manufacturer or his authorised representative and all work shall be as per manufacturer's instructions. Any drilling or cutting to concrete, masonry etc. shall be made good after erection of shutters and all abrasion to shop coat shall be touched up. All electrical work shall be in strict accordance with the latest Indian Electricity Rules.

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3.0.0 ACCEPTANCE CRITERIA

3.1.0 Shop Inspection

After completing the manufacture of the different components of the rolling shutter, an arrangement for shop inspection by the Engineer shall be made to check the conformity with approved shop drawings.

3.2.0 Field Inspection

After installing the shutters, the Contractor shall test the performance of the shutter in the presence of the Engineer. The doors shall be smoothly operable under all ambient conditions. All control and locking devices shall give fault-free performance.

3.3.0 Guarantee

The Contractor shall give one year's guarantee for the successful operation of the shutters. This shall be supported by a separate and unilateral guarantee from the manufacturer of the shutters.

4.0.0 I.S. CODE

IS : 6248 - Metal rolling shutters and rolling grills.