



## **West Leigh Ltd - NBS Specification**

### **W20 – Range**

#### **L 10 - WINDOWS / ROOFLIGHTS / SCREENS / LOUVRES**

#### **320 - STEEL WINDOWS AND DOORS**

Manufacturer:  
West Leigh Ltd  
Unit 6, Meridian Trading Estate  
Bugsby's Way  
Charlton  
London  
SE7 7SJ

**Product Reference:** W20 - Range - Mild steel window sections.

**Mild Steel:** To BS EN 10025-2 and cold straightened.  
Manufactured in accordance with - BS 6510 - W20 Section.

**Weathertightness:** To BS 6375: Part 1. Exposure category (Design wind pressure)  
1200/1200 (Pa) - See Table **AA** unless otherwise specified.

For air permeability, water-tightness and wind resistance test data see table **AA**.

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 +/- 1.5mm.

All intermediate bars are riveted and/or welded to frames and interlock with rigid joints displaying face gaps of no more than 1mm.

#### **Galvanising:**

Hot dip galvanising: All frames and ancillary profiles (steel attachments, coupling members and ancillaries) shall be positively rustproofed by hot-dipped galvanising after manufacture to BS EN ISO 1461:2009.

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### **Glazing Details:**

Can accept Single and Insulating glass units up to 16mm in thickness with a change of Bead.

Thermal insulation: Approximately 5.7 W/m<sup>2</sup>/K (single glazed) down to minimum 2.2 W/m<sup>2</sup>/K Uw (90% krypton gas filled soft coat low E 16mm sealed double glazing units) combined frame and glass U values, Centre Pane glass U values 5.7 W/m<sup>2</sup>/K – 1.1 W/m<sup>2</sup>/K Ug.

Double Glass) / 35- 40dB reduction (with secondary window and 200mm cavity).

Compliant with Part L 2010 (2013 Edition)

### **Weather Stripping:**

Gaskets complying with BS 4255: Part 1 manufactured from EPDM which is secured into the grooves of opening frame with adhesive.

### **328 - Ironmongery/Accessories:**

#### **Standard finishes:**

A variety of handles, catches, stays and openers, with locking options, are available in chromed or toned brass, anodised or painted aluminium, and chromed or painted zinc alloy.

Optional Hardware/Finishes: Available, consult West Leigh Ltd.

### **331 – Finishing:**

**Finish:** Type / Reference: Polyester powder coating to BS 6497 or BS EN 13438

**Preparation:** Following galvanising, windows are chemically cleaned and pre-treated to provide a surface to which powder coating will adhere.

**Covering:** Minimum powder coating thickness of 60 microns on all significant surfaces.

**Colours:** All standard RAL colour references available.

**Gloss level:** Standard matt (30% +/- 7% gloss level). Optional semi-gloss and full gloss levels available.

**Process:** Coating will be undertaken by our specialised polyester powder coat applicator.

### **470 – Sealants:**

Joint surfaces are to be clean, grease and dust free and prepared in accordance with the sealant manufacturers recommendations.

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**Table AA**

Type of Opening Light	Air Permeability	Water Tightness	Wind resistance	Exposure Category
Fixed Light	600	300	2400	2400
Top Hung Open Out	300	200	2000	2000
Side Hung Open Out	300	200	2000	2000
Side Hung Open In	300	200	2000	2000
Bottom Hung Open In	300	200	2000	2000
Horizontal Pivot	200	100	1600	1200
Vertical Pivot	200	50	1600	1200
Single Door Open Out*	150	50	800	800x
Double Door Open Out**	150	50	800	800x

\* A higher wind resistance can be achieved.

\*\* Applies to doors with a full rebated threshold.  
Thresholds designed to meet accessibility requirements of the UK Building Regulations are unlikely to meet category 800x.

> **Permissible Window Sizes** – See **W20** data sheet for minimum / maximum frame sizes.

> Windows fitted with manual or electrically operated winding gear may not achieve the performance detailed in Table AA.

Manufactured at our West Leigh Factory in the United Kingdom and in compliance with British and Harmonised European standards.

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