

**ASTA AMERICA 400 SERIES HEAVY DUTY ROLLING STEEL SERVICE DOOR** is produced with the highest quality and durability in the industry. The **400 Series** consists of 3" - 24, 22, 20, or 18-gauge slats with a flat or curved profile. The **400 Series** is available in sizes up to 40' wide or 30' high (varies by model). **The 400 Series** is the perfect choice for industrial, commercial, or high cycle applications.

#### FOUR FINISH OPTIONS:

- White Topcoat
- Gray Topcoat
- Tan Topcoat
- Galvanized

*Powder Coat Finish is available in a variety of color options*

40 year film integrity and a 35 year no-chalk/no-fade limited paint warranty.

#### STANDARD FEATURES:

- Enclosed hood
- Reduction gear chain hoist
- 3-piece structural steel guides
- Double angle bottom bar with astragal
- 2 year limited warranty



## OPTIONS

**Electric Operation:** Easy fast motorized operation at a push of a button (motor mounting plates available upon request).

**Slide Bolt Locks:** Dual steel slide bolt locks attached to bottom suitable for padlocks (padlocks by other) (standard for manual push-up operation).

**Vision Panels:** 5" x 3/4" cut out spaced approximately 3" apart and covered with clear Lexan (Flat Slat Only).

**Hood Baffle:** 8" wide PVC rubber riveted to the inside of the hood.

**Guide Weatherseal:** One-piece vinyl weather seal attached to door guide on the non-coil side (brush seal with retainer available upon request).

**Insulation (Steel Backed):** Refer to 600 series.

**Windload:** Available design to +/- 45 PSF for 16'0" wide (test size). Windload varies by model; for windload availability on larger sizes contact customer service.

# HEAVY DUTY SERVICE DOOR 400

MODEL 424 - 24 GAUGE SLAT, MODEL 422 - 22 GAUGE SLAT  
MODEL 420 - 20 GAUGE SLAT, MODEL 418 - 18 GAUGE SLAT

Flat or Curved Profile (specify when ordering)

**Hoods** | 24-gauge galvanized steel with baked epoxy primer and baked polyester topcoat designed to enclose door coil. Reinforcing to be 1/4" thick steel brackets for door over 16'0" wide.

**Drum/Axle Assembly** | Barrel to be a steel pipe of diameter and wall thickness to restrict maximum deflection to .03" per foot width. Springs to be oil tempered grease packed helical torsion type designed to cycle 25,000 times with an overload factor of 25%. Springs are to be mounted on a cold rolled steel inner shaft. End bearing to be self-lubricating ball bearings.

**Guide Assembly** | Guide angles to be 3/16" minimum thickness structural steel with 30" service cutout and removable headstops. Guide depth to provide slat penetration adequate to satisfy specified wind loading.

**Slats** | 24, 22, 20, or 18-gauge slats are manufactured from full hard galvanized grade 80 steel and coated with Super Durable polyester paint that is backed by a 40 year film integrity and 25 year no-fade limited paint warranty.

**Bracket Assembly** | Bracket plates to be 1/4" minimum thickness steel plate and enclose ends of barrel assembly. Drive end bracket plate to be filled with a self-aligning sealed ball bearing.

**Operation** | Drive to consist of roller chains and sprockets. Hand chain to be galvanized machine link. Pull not to exceed 35 lbs. (156 N).

**Hand Chain Lock** | Lockable bracket mounted on guide angle or wall suitable for padlocking (padlock by others).

**Endlocks** | Each end of alternate slats to be fitted with end locks to provide a wearing surface in the guides and maintain slat alignment. Fastened with 1/4" or 3/16" rivets. Windlocks provided on larger sizes.

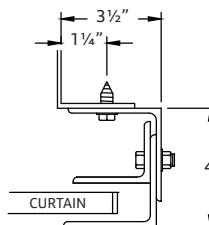
**Bottom Bar** | Curtain to be reinforced with a bottom bar consisting of two 2" x 2" x 1/8" structural steel angles with PVC bulb astragal.

## SPECIFICATION DETAILS

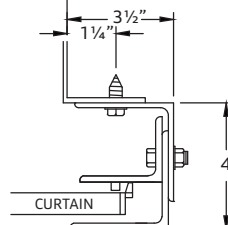


## STANDARD GUIDE DETAILS

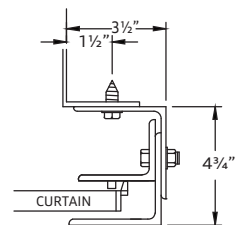
3 piece Structural Steel Guide



3 piece Structural Steel Windlock Guide



3 piece Structural Steel Windload Certified Guide



(Dimensions are approximate and vary by door size)

\* For headroom and sideroom dimensions, refer to door specific shop drawings.

ASTA AMERICA reserves the right to change engineering specifications without prior notice. Illustrations shown are for general reference and should be verified for construction purposes.