

**SECTION 23 73 00**  
**INDOOR CENTRAL-STATION AIR-HANDLING UNITS**

SPEC WRITER NOTES:

1. Delete between //---- // if not applicable to project. Also delete any other item or paragraph not applicable in the Section and renumber the paragraphs.
2. Provide the year of latest edition to each publication given in paragraph APPLICABLE PUBLICATIONS.
3. References to pressure in this section are gauge pressure unless otherwise noted.

**PART 1 - GENERAL**

**1.1 DESCRIPTION**

- A. A complete listing of common acronyms and abbreviations are included in Section 23 05 11, COMMON WORK RESULTS FOR HVAC.
- B. Air handling units including integral components specified herein.
- C. Definition of Air Handling Unit (AHU): A factory-fabricated and tested assembly of modular sections consisting of //housed-centrifugal fan with V-belt drive// //single or multiple plenum fans with direct-drive//, coils, filters, and other necessary equipment to perform one or more of the following functions of circulating, cleaning, heating, cooling, humidifying, dehumidifying, and mixing of air. Design capacities of units shall be as scheduled in the contract documents.

**1.2 RELATED WORK**

- A. Section 01 00 00, GENERAL REQUIREMENTS.
- B. Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- C. Section 01 81 13, SUSTAINABLE CONSTRUCTION REQUIREMENTS.
- D. //Section 01 91 00, GENERAL COMMISSIONING REQUIREMENTS.//
- E. Section 09 91 00, PAINTING.
- F. //Section 13 05 41, SEISMIC RESTRAINT REQUIREMENTS FOR NON-STRUCTURAL COMPONENTS.//
- G. Section 23 05 11, COMMON WORK RESULTS FOR HVAC.
- H. Section 23 05 12, GENERAL MOTOR REQUIREMENTS FOR HVAC AND STEAM GENERATION EQUIPMENT.
- I. Section 23 05 41, NOISE AND VIBRATION CONTROL FOR HVAC PIPING AND EQUIPMENT.
- J. Section 23 05 93, TESTING, ADJUSTING, AND BALANCING FOR HVAC.
- K. //Section 23 07 11, HVAC AND BOILER PLANT INSULATION.//

- L. //Section 23 08 00, COMMISSIONING OF HVAC SYSTEMS.//
- M. Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC.
- N. //Section 23 21 13, HYDRONIC PIPING.//
- O. Section 23 22 13, STEAM AND CONDENSATE HEATING PIPING.
- P. Section 23 31 00, HVAC DUCTS and CASINGS.
- Q. Section 23 34 00, HVAC FANS.
- R. Section 23 40 00, HVAC AIR CLEANING DEVICES.
- S. Section 23 82 16, AIR COILS.
- T. Section 26 29 11, MOTOR CONTROLLERS.

### 1.3 APPLICABLE PUBLICATIONS

#### SPEC WRITER NOTES:

1. Make material requirements agree with requirements specified in the referenced Applicable Publications. Verify and update the publication list to that which applies to the project unless the reference applies to all HVAC systems. Publications that apply to all HVAC systems may not be specifically referenced in the body of the specification but shall form a part of this specification.
2. Insert the year of approved latest edition of the publication between the brackets // // and delete the brackets if applicable to this project.

A. The publications listed below form a part of this specification to the extent referenced. The publications are referenced in the text by the basic designation only. Where conflicts occur these specifications and the VHA standards will govern.

B. Air-Conditioning, Heating, and Refrigeration Institute (AHRI):

260-//2017//.....Sound Rating of Ducted Air Moving and

Conditioning Equipment

410-//2001//.....Forced-Circulation Air-Cooling and Air-Heating

Coils with Addenda 1, 2 and 3

430-//2020//.....Performance Rating of Central Station

Air-Handling Unit Supply Fans

C. Air Movement and Control Association International, Inc. (AMCA):

99-//2016//.....Standards Handbook

210-//2016//.....Laboratory Methods of Testing Fans for

Certified Aerodynamic Performance Rating



AHUs, in different configurations, for an initial submission. The suggested different configurations are:

1. 100 percent outside air AHUs with or without heat recovery coils.
2. Re-circulating type of variable air volume AHUs with minimum outside air and economizer cycle features. The remaining submission shall be received only after the initial submission is approved with satisfactory resolution of all comments made during the review and approval process.

- A. Submittals, including number of required copies, shall be submitted in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, AND SAMPLES.
- B. Information and material submitted under this section shall be marked "SUBMITTED UNDER SECTION 23 XX XX, SECTION TITLE", with applicable paragraph identification.
- C. Manufacturer's Literature and Data Including: Full item description and optional features and accessories. Include dimensions, weights, materials, applications, standard compliance, model numbers, size, and capacity.
  1. Submittals for AHUs shall include fans, drives, motors, coils, //humidifiers, // //sound attenuators, // mixing box with outside/return air dampers, filter housings, //blender sections, // and all other related accessories. The contractor shall provide custom drawings showing total air handling unit assembly including dimensions, operating weight, access sections, //diffusion plates, // flexible connections, door swings, controls penetrations, electrical disconnect, lights, duplex receptacles, switches, wiring, utility connection points, unit support system, vibration isolators, drain pan, pressure drops through each component (filter, coil etc).
  2. Submittal drawings of section or component only will not be acceptable. Contractor shall also submit performance data including performance test results, charts, curves, or certified computer selection data; data sheets; fabrication and insulation details. If the unit cannot be shipped in one piece, the contractor shall indicate the number of pieces that each unit will have to be broken into to meet shipping and job site rigging requirements.
  3. Submit sound power levels in each octave band for the inlet and discharge of the fan and at entrance and discharge of AHUs at

scheduled conditions. In absence of sound power ratings refer to Section 23 05 41, NOISE AND VIBRATION CONTROL FOR HVAC PIPING AND EQUIPMENT.

4. Provide fan curves showing Liters/Second (cubic feet per minute), static pressure, efficiency, and horsepower for design point of operation and at maximum design Liters/Second (cubic feet per minute).
  5. Submit total fan static pressure, external static pressure, for AHU including total, inlet and discharge pressures, and itemized specified internal losses and unspecified internal losses. Refer to air handling unit schedule in the contract documents.
- D. Submit written test procedures two weeks prior to factory testing. Submit written results of factory tests for approval prior to shipping.
- E. Submit shipping information that clearly indicates how the units will be shipped in compliance with the descriptions below.
1. Units shall be shipped in one (1) piece where possible and in shrink wrapping to protect the unit from dirt, moisture and/or road salt.
  2. If not shipped in one (1) piece, provide manufacturer approved shipping splits where required for installation or to meet shipping and/or job site rigging requirements in modular sections. Indicate clearly that the shipping splits shown in the submittals have been verified to accommodate the construction constraints for rigging as required to complete installation and removal of any section for replacement through available access without adversely affecting other sections.
  3. If shipping splits are provided, each component shall be individually shrink wrapped to protect the unit and all necessary hardware (e.g., bolts, gaskets etc.) will be included to assemble unit onsite.
  4. Lifting lugs will be provided to facilitate rigging on shipping splits and joining of segments. If the unit cannot be shipped in one piece, the contractor shall indicate the number of pieces that each unit will have to be broken into to meet shipping and job site rigging requirements.

SPEC WRITER NOTE: Coordinate O&M Manual and commissioning requirements with Section 01 00 00, GENERAL REQUIREMENTS and Section 01 91 00, GENERAL COMMISSIONING REQUIREMENTS. O&M Manuals

shall be submitted for content review as part of closeout documents.

- F. Complete operating and maintenance manuals including wiring diagrams, technical data sheets, information for ordering replaceable parts, and troubleshooting guide:
  - 1. Include complete list indicating all components of the systems.
  - 2. Include instructions for lubrication, filter replacement, motor and drive replacement, and spare parts list.
  - 3. Include complete diagrams of the internal wiring for each item of equipment.
  - 4. Diagrams shall have their terminals identified to facilitate installation, operation, and maintenance.
- G. //Completed System Readiness Checklist provided by the CxA and completed by the contractor, signed by a qualified technician, and dated on the date of completion, in accordance with the requirements of Section 23 08 00, COMMISSIONING OF HVAC SYSTEMS.//
- H. //Submit training plans and instructor qualifications in accordance with the requirements of Section 23 08 00, COMMISSIONING OF HVAC SYSTEMS.//

#### **1.5 QUALITY ASSURANCE**

- A. Comply with requirements in paragraph QUALITY ASSURANCE of Section 23 05 11, COMMON WORK RESULTS FOR HVAC.
- B. Air Handling Units Certification:
  - 1. Air Handling Units with Housed Centrifugal Fans: The air handling units shall be certified in accordance with AHRI 430 and tested/rated in accordance with AHRI 260.
  - 2. Air Handling Units with Plenum Fans:
    - a. Air Handling Units with a single Plenum Fan shall be certified in accordance with AHRI 430 and tested/rated in accordance with AHRI 260.
    - b. Air handling Units with Multiple Fans in an Array shall be tested and rated in accordance with AHRI 430 and AHRI 260.
- C. Heating, Cooling, and Air Handling Capacity and Performance Standards: AHRI 430, AHRI 410, ASHRAE 51, and AMCA 210.
- D. Performance Criteria:
  - 1. The fan BHP shall include all system effects for all fans and v-belt drive losses for housed centrifugal fans.

2. The fan motor shall be selected within the rated nameplate capacity, without relying upon NEMA Standard Service Factor.
3. Select the fan operating point as follows:
  - a. Forward Curve and Axial Flow Fans: Right hand side of peak pressure point.
  - b. Air Foil, Backward Inclined, or Tubular Fans Including Plenum Fans: At or near the peak static efficiency but at an appropriate distance from the stall line.
4. Operating Limits: AMCA 99 and manufacturer's recommendations.
- E. Units shall be factory-fabricated, assembled, and tested by a manufacturer, in business of manufacturing similar air-handling units for at least five (5) years.
- F. Bio-Based Materials: For products designated by the USDA's Bio-Preferred Program, provide products that meet or exceed USDA recommendations for bio-based content, so long as products meet all performance requirements in this specifications section. For more information regarding the product categories covered by the Bio-Preferred Program, visit <http://www.biopreferred.gov>.
- G. Refer to Section 01 81 13, SUSTAINABLE CONSTRUCTION REQUIREMENTS for additional sustainable design requirements.

#### **1.6 AS-BUILT DOCUMENTATION**

- A. Comply with requirements in paragraph AS-BUILT DOCUMENTATION of Section 23 05 11, COMMON WORK RESULTS FOR HVAC.

### **PART 2 - PRODUCTS**

#### **2.1 AIR HANDLING UNITS**

##### SPEC WRITER NOTES:

1. Use of the blow-through air-handling units, with cooling coils and after-filters located on the downstream side of the supply air fans, is prohibited.
2. Capacity of a single air-handling unit shall not exceed 23,600 Liters/Second (50,000 Cubic Feet per Minute - CFM).

##### A. General:

1. AHUs shall be fabricated from insulated, solid double-wall galvanized steel without any perforations in draw-through configuration. Galvanizing shall be hot dipped conforming to ASTM A653/A653M and shall provide a minimum of 0.275 kg of zinc per square meter (0.97 oz. of zinc per square foot) (G90). Aluminum constructed units, subject to VA approval, may be used in place of

- galvanized steel. The unit manufacturer shall provide published documentation confirming that the structural rigidity of aluminum air-handling units is equal or greater than the specified galvanized steel.
2. The contractor and the AHU manufacturer shall be responsible for ensuring that the unit will not exceed the allocated space shown in the contract documents, including required clearances for service and future overhaul or removal of unit components. All structural, piping, wiring, and ductwork alterations of units, which are dimensionally different than those specified, shall be the responsibility of the contractor at no additional cost or time to the Government.
  3. AHUs shall be fully assembled by the manufacturer in the factory in accordance with the arrangement shown in the contract documents. The unit shall be assembled into the largest sections possible subject to shipping and rigging restrictions. The correct fit of all components and casing sections shall be verified in the factory for all units prior to shipment. All units shall be fully assembled, tested, and then split to accommodate shipment and job site rigging. On units not shipped fully assembled, the manufacturer shall tag each section and include air flow direction to facilitate assembly at the job site. Lifting lugs or shipping skids shall be provided for each section to allow for field rigging and final placement of unit.
  4. The AHU manufacturer shall provide the necessary gasketing, caulking, and all screws, nuts, and bolts required for assembly. The manufacturer shall provide a factory-trained and qualified local representative at the job site to supervise the assembly and to assure that the units are assembled to meet manufacturer's recommendations and requirements noted in the contract documents. Provide documentation to the Contracting Officer that the local representative has provided services of similar magnitude and complexity on jobs of comparable size. If a local representative cannot be provided, the manufacturer shall provide a factory representative.
  5. Gaskets: All door and casing and panel gaskets and gaskets between air handling unit components, if joined in the field, shall be high quality which seal airtight and retain their structural integrity



and sealing capability after repeated assembly and disassembly of bolted panels and opening and closing of hinged components. Bolted sections may use a more permanent gasketing method provided they are not disassembled.

6. Structural Rigidity: Provide structural reinforcement when required by span or loading so that the deflection of the assembled structure shall not exceed 1/200 of the span based on a differential static pressure of 2000 Pa (8 inch WG) or higher.

B. Base:

1. Provide a heavy duty steel base for supporting all major AHU components. Bases shall be constructed of wide-flange steel I-beams, channels, or minimum 127 mm (5 inch) high 3.5 mm (10 Gauge) steel base rails. Welded or bolted cross members shall be provided as required for lateral stability. Contractor shall provide supplemental steel supports as required to obtain proper operation heights for cooling coil condensate drain trap //and steam coil condensate return trap// as shown in the contract documents.
2. AHUs shall be completely self-supporting for installation on concrete housekeeping pad, steel support pedestals, or suspended as shown in the contract documents.
3. The AHU bases not constructed of galvanized steel shall be cleaned, primed with a rust inhibiting primer, and finished with rust inhibiting exterior enamel.

C. Casing (Including Wall, Floor, and Roof):

1. General: AHU casing shall be constructed as solid double wall, galvanized steel insulated panels without any perforations, integral of or attached to a structural frame. The thickness of insulation, mode of application and thermal breaks shall be such that there is no visible condensation on the exterior panels of the AHU located in the non-conditioned spaces.
2. Casing Construction:

Outer Panel	0.8 mm (22 Gauge) Minimum
Inner Panel	0.8 mm (22 Gauge) Minimum
Insulation	Foam
Thickness	50 mm (2 inch) Minimum
Density	48 kg/m <sup>3</sup> (3.0 lb/ft <sup>3</sup> ) Minimum

Total R Value	2.3 m <sup>2</sup> .K/W (13.0 ft <sup>2</sup> .°F.hr/Btu) Minimum
---------------	--

3. Casing Construction (Contractor's Option):

Outer Panel	1.3 mm (18 Gauge) Minimum
Inner Panel	1.0 mm (20 Gauge) Minimum
Insulation	Fiberglass
Thickness	50 mm (2 inch) Minimum
Density	24 kg/m <sup>3</sup> (1.5 lb/ft <sup>3</sup> ) Minimum
Total R Value	1.4 m <sup>2</sup> .K/W (8.0 ft <sup>2</sup> .°F.hr/Btu) Minimum

4. Blank-Off: Provide blank-offs as required to prevent air bypass between the AHU sections, around coils, and filters.
5. Casing panels shall be secured to the support structure with stainless-steel or zinc-chromate plated screws and gaskets installed around the panel perimeter. Panels shall be completely removable to allow removal of fan, coils, and other internal components for future maintenance, repair, or modifications. Welded exterior panels are prohibited.
6. Access Doors: Provide in each access section and where shown in the contract documents. Show single-sided and double-sided access doors with door swings on the floor plans. Doors shall be a minimum of 50 mm (2 inch) thick with same double wall construction as the unit casing. Doors shall be a minimum of 610 mm (24 inches) wide, unless shown of different size in the contract documents, and shall be the full casing height up to a maximum of 1829 mm (6 feet). Doors shall be gasketed, hinged, and latched to provide an airtight seal. The access doors for fan section, mixing box, //humidifier// coil section shall include a minimum 152 mm x 152 mm (6 inch x 6 inch) double thickness, with air space between the glass panes tightly sealed, reinforced glass or Plexiglas window in a gasketed frame.
- Hinges: Manufacturer's standard, designed for door size, weight and pressure classifications. Hinges shall hold door completely rigid with minimum 45 kg (100 lb) weight hung on latch side of door.
  - Latches: Non-corrosive alloy construction, with operating levers for positive cam action, operable from either inside or outside. Doors that do not open against unit operating pressure shall

allow the door to ajar and then require approximately 0.785 radian (45 degrees) further movement of the handle for complete opening. Latch shall be capable of restraining explosive opening of door with a force not less than 2000 Pa (8 inch WG).

c. Gaskets: Neoprene, continuous around door, positioned for direct compression with no sliding action between the door and gasket. Secure with high quality mastic to eliminate possibility of gasket slipping or coming loose.

7. Provide sealed sleeves, metal or plastic escutcheons or grommets for penetrations through casing for power and temperature control wiring and pneumatic tubing. Coordinate with electrical and temperature control subcontractors for number and location of penetrations. Coordinate lights, switches, and duplex receptacles and disconnect switch location and mounting. All penetrations and equipment mounting may be provided in the factory or in the field. All field penetrations shall be performed neatly by drilling or saw cutting. No cutting by torches will be allowed. Neatly seal all openings airtight.

SPEC WRITER NOTE: Use the following paragraph only where painting is required by architectural specification sections. Note that painting will require additional cost and maintenance and should be used only where absolutely necessary.

- D. //Painted Exterior Finish: Galvanized steel (G90) exterior shall be mill prepared for painting by bonderizing and factory prepared for prime coat of paint by acid etch cleaning, as required, to assure paint adhesion. Provide factory applied prime coat and enamel finish coat of paint of color selected by owner. Paint corrosion resistance and adhesion shall have satisfactorily passed ASTM B117, ASTM D1654, ASTM D1735, ASTM D3359, and ASTM G152 for a minimum of 500 hours. Rating of failure at the scribe mark shall not be less than 6, average creepage not greater than 3.2 mm (1/8 inch). Rating of the inscribed area shall not be less than 10, no failure. Refer to Section 09 91 00, PAINTING.//
- E. Floor:
  1. Unit floor shall be level without offset space or gap and designed to support a minimum of 488 kg/square meter (91 lbs per square foot) distributed load without permanent deformation or crushing of internal insulation. Provide adequate structural base members

beneath floor in service access sections to support typical service foot traffic and to prevent damage to unit floor or internal insulation. Unit floors in casing sections, which may contain water or condensate, shall be watertight with drain pan.

2. Where indicated, furnish and install floor drains flush with the floor, with nonferrous grate cover and stub through floor for external connection.

F. Condensate Drain Pan: Drain pan shall be designed to extend entire length of cooling coils including headers and return bends. Depth of drain pan shall be at least 43 mm (1.7 inches) and shall handle all condensate without overflowing. Drain pan shall be double-wall, double sloping type, and fabricated from stainless-steel (304) with at least 50 mm (2 inch) thick insulation sandwiched between the inner and outer surfaces. Drain pan shall be continuous metal or welded watertight. No mastic sealing of joints exposed to water will be permitted. Drain pan shall be placed on top of casing floor or integrated into casing floor assembly. Drain pan shall be pitched in all directions to drain line.

1. An intermediate, stainless-steel (304) condensate drip pan with copper downspouts shall be provided on stacked cooling coils. Use of intermediate condensate drain channel on upper casing of lower coil is permissible provided it is readily cleanable. Design of intermediate condensate drain shall prevent upper coil condensate from flowing across face of lower coil.
2. Drain pan shall be piped to the exterior of the unit. Drain pan shall be readily cleanable.
3. Installation, including frame, shall be designed and sealed to prevent blow-by.

SPEC WRITER NOTES:

1. In this section, housed centrifugal fans and plenum fans are specified. Before selecting one type or another for a specific application, multiple selections comparing both types of fans should be made. Selection of the fan type and arrangement would dependent upon the specific priority involving such factors as power input, overall dimensions, acoustics, and redundancy requirement.
2. Use of the housed forward curved centrifugal fans should be considered only for low static pressure

applications, typically 950 Pa (3-3/4 inch WG) or less.

G. Housed Centrifugal Fan Sections:

1. Fans shall be minimum Class II construction, double width, double inlet centrifugal, //air foil or backward inclined// //forward curved// type as indicated in the contract documents, factory balanced and rated in accordance with AMCA 210 or ASHRAE 51. Provide self-aligning, pillow block, regreasable ball-type bearings selected for a B (10) life of not less than 50,000 hours and an L (50) average fatigue life of 200,000 hours per ABMA 9. Extend bearing grease lines to motor and drive side of fan section. Fan shall be located in airstream to assure proper air flow.
2. Provide internally vibration isolated fan, motor and drive, mounted on a common integral bolted or welded structural steel base with adjustable motor slide rail with locking device. Provide vibration isolators and flexible duct connections at fan discharge to completely isolate fan assembly. Refer to Section 23 05 41, NOISE AND VIBRATION CONTROL FOR HVAC PIPING AND EQUIPMENT, for additional requirements.
3. Allowable vibration tolerances for fan shall not exceed a self-excited vibration maximum velocity of 0.005 m/s (0.20 inch per second) RMS, filter in, when measured with a vibration meter on bearing caps of machine in vertical, horizontal, and axial directions or measured at equipment mounting feet if bearings are concealed. After field installation, compliance to this requirement shall be demonstrated with field test in accordance with Section 23 05 41, NOISE AND VIBRATION CONTROL FOR HVAC PIPING AND EQUIPMENT and Section 23 05 93, TESTING, ADJUSTING, AND BALANCING FOR HVAC. Following fan assembly, the complete fan assembly balance shall be tested using an electronic balance analyzer with a tunable filter and stroboscope. Vibration measurements shall be taken on each motor bearing housing in the vertical, horizontal, and axial planes (5 total measurements, 2 each motor bearing and 1 axial).

H. Fan Motor, Drive, and Mounting Assembly (Housed Centrifugal Fans):

1. Fan Motor and Drive: Motors shall be premium energy efficient type, as mandated by the Energy Policy Act of 2005, with efficiencies as shown in Section 23 05 12, GENERAL MOTOR REQUIREMENTS FOR HVAC AND STEAM GENERATION, in the contract documents and suitable for use in

variable frequency drive applications on AHUs where this type of drive is indicated. Refer to Section 23 05 11, COMMON WORK RESULTS FOR HVAC, for additional motor and drive specifications. Refer to Section 26 29 11, MOTOR CONTROLLERS.

2. Fan drive and belts shall be factory mounted with final alignment and belt adjustment to be made by the Contractor after installation. Drive and belts shall be as specified in Section 23 05 11, COMMON WORK RESULTS FOR HVAC. Provide additional drive(s) if required during balancing, to achieve desired airflow.

SPEC WRITER NOTE: Number of plenum fans in each array shall not exceed four (4). Number of fans in an array shall be based on the percentage redundancy included in the design and other factors, such as, acoustics, overall space requirements, and power input.

I. Plenum Fans - Single and/or Multiple Fans in an Array:

1. General: Fans shall be Class II (minimum) construction with single inlet, aluminum wheel and stamped air-foil aluminum bladed. The fan wheel shall be mounted on the directly-driven motor shaft in AMCA Arrangement 4. Fans shall be dynamically balanced and internally isolated to minimize the vibrations. Provide a steel inlet cone for each wheel to match with the fan inlet. Locate fan in the air stream to assure proper flow. The fan performance shall be rated in accordance with AMCA 210 or ASHRAE 51.
2. Allowable vibration tolerances for fan shall not exceed a self-excited vibration maximum velocity of 0.005 m/s (0.20 inch per second) RMS, filter in, when measured with a vibration meter on bearing caps of machine in vertical, horizontal, and axial directions or measured at equipment mounting feet if bearings are concealed. After field installation, compliance to this requirement shall be demonstrated with field test in accordance with Section 23 05 41, NOISE AND VIBRATION CONTROL FOR HVAC PIPING AND EQUIPMENT and Section 23 05 93, TESTING, ADJUSTING, AND BALANCING FOR HVAC. Following fan assembly, the complete fan assembly balance shall be tested using an electronic balance analyzer with a tunable filter and stroboscope. Vibration measurements shall be taken on each motor bearing housing in the vertical, horizontal, and axial planes (5 total measurements, 2 each motor bearing and 1 axial).

3. The plenum fans shall be driven by variable speed drives with at least one back-up drive as shown in the design documents. Use of a drive with bypass is prohibited.
4. Multiple fans shall be installed in a pre-engineered structural frame to facilitate fan stacking. All fans shall modulate in unison, above or below the synchronous speed within the limits specified by the manufacturer, by a common control sequence. Staging of the fans is prohibited. Redundancy requirement shall be met by all operating fans in an array and without the provision of an idle standby fan.
5. Fan Accessories:
  - a. Fan Isolation: Provide //an actuator-controlled damper// //a manual blank off plate// //an automatic back draft damper// to isolate the fan not in operation due to failure.
  - b. Fan Airflow Measurement: Provide an airflow measuring device integral to the fan to measure air volume within +/- 5 percent accuracy. The probing device shall not be placed in the airflow path to stay clear of turbulence and avoid loss of performance.
- J. Fan Motor and Drive (Plenum Fans): Motors shall be premium energy efficient type, as mandated by the Energy Policy Act of 2005, with efficiencies as shown in Section 23 05 12, GENERAL MOTOR REQUIREMENTS FOR HVAC AND STEAM GENERATION EQUIPMENT, in the contract documents and suitable for use in variable frequency drive applications. Refer to Section 23 05 11, COMMON WORK RESULTS FOR HVAC, for additional motor and drive specifications. Refer to Section 26 29 11, MOTOR CONTROLLERS.
- K. //Multi-zone damper blades shall be galvanized steel or aluminum type. Dampers shall have metal compressible jamb seals and extruded vinyl or metal blade edge seals. Dampers shall rotate on stainless-steel bearings or bronze bushings. Leakage rate shall not exceed 2.5 cubic meters/minute/square meter (8 CFM per sq. foot) at 250 Pa (1 inch WG). Dampers and operators shall be furnished and factory-installed by AHU manufacturer. Damper operators shall be of the same manufacturer as controls furnished under Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC.//
- L. //Mixing Boxes: Mixing box shall consist of casing and outdoor air and return air dampers in opposed blade arrangement with damper linkage for automatic operation. Coordinate damper operator with Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC. Dampers shall be of ultra-low leak design with metal compressible bronze jamb seals and extruded

vinyl edge seals on all blades. Blades shall rotate on stainless-steel sleeve bearings or bronze bushings. Leakage rate shall not exceed 1.6 cubic meters/min/square meter (5 CFM per square foot) at 250 Pa (1 inch WG) and 2.8 cubic meters/min/square meter (9 CFM per square foot) at 995 Pa (4 inch WG). //Electronic// operators shall be furnished and mounted in an accessible and easily serviceable location by the air handling unit manufacturer at the factory. Damper operators shall be of same manufacturer as controls furnished under Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC.//

- M. //Blenders: Construction of the blender section shall be of welded aluminum 2 mm (0.081 inch) thick framing and turbulators. The mixer shall have no moving parts and shall contain a primary set of directional changing vanes, a secondary set of turbulator vanes, and a cone design for mixing of air streams. Certify blender performance to achieve no greater than a 5 degrees F variation across the cross section of the AHU measured 305 mm (12 inches) downstream of the blender over a face velocity range of 1-4 m/s (200-787 FPM).//

SPEC WRITER NOTE: For air-handling units equipped with plenum fans and requiring after-filters to be located on the downstream side of the supply air fans, follow manufacturer's recommendations to establish the distance between the supply air fan and after-filters.

- N. Filter Section: Refer to Section 23 40 00, HVAC AIR CLEANING DEVICES, for filter requirements.
1. Filters including one complete set for temporary use at site shall be provided independent of the AHU. The AHU manufacturer shall install filter housings and racks in filter section compatible with filters furnished. The AHU manufacturer shall be responsible for furnishing temporary filters (pre-filters and after-filters, as shown in the contract documents) required for AHU testing.
  2. Factory-fabricated filter section shall be of the same construction and finish as the AHU casing including filter racks and hinged double wall access doors. Filter housings shall be constructed in accordance with side service or holding frame housing requirements in Section 23 40 00, HVAC AIR CLEANING DEVICES.

SPEC WRITER NOTE: Diffuser section is required for the housed centrifugal fan and not for the plenum fan, where the



plenum is pressurized and provides uniform velocity distribution.

- O. //Diffuser Section: Furnish a diffuser segment with perforated diffuser plate immediately downstream of supply fan to assure uniform distribution of leaving air across the face of the downstream after-filters to create uniform velocity profiles across the entire opening. Bolt or weld diffuser plate to a sturdy steel support frame so that it remains rigid. Manufacturer shall include any diffuser section pressure loss in excess of diffuser plate and this value shall be included in unspecified internal losses when selecting fan.//
- P. Coils: Coils shall be mounted on hot dipped galvanized steel supports to assure proper anchoring of coil and future maintenance. Coils shall be face or side removable for future replacement thru the access doors or removable panels. Each coil shall be removable without disturbing adjacent coil. Cooling coils //and glycol-water exhaust heat recovery coils// shall be designed and installed to ensure no condensate carry over. Provide factory-installed extended supply, return, drain, and vent piping connections. //Coils installed in the air handling units serving surgical suites shall be equipped with copper fins. Copper fins are also required for all duct-mounted and terminal reheat coils.//  
//All coils in the high humidity areas, shall be epoxy-coated as shown below.// Refer to the contract documents and Section 23 82 16, AIR COILS for additional coil requirements.

SPEC WRITER NOTE: Corrosion protection specified below is applicable to the high-humidity locations described in the VA HVAC Design Manual and as determined by the designer for a specific location. Coating should not be used for the chemically corrosive locations where the pH values are not within 3 to 12.

1. Epoxy Immersion Coating - Electrically Deposited: The multi-stage corrosion-resistant coating application comprises of cleaning (heated alkaline immersion bath) and reverse-osmosis immersion rinse prior to the start of the coating process. The coating thickness shall be maintained between 0.6-mil and 1.2-mil. Before the coils are subjected to high-temperature oven cure, they are treated to permeate immersion rinse and spray. Where the coils are subject to UV exposure, UV protection spray treatment comprising of UV-resistant urethane mastic topcoat shall be applied. Provide complete

- coating process traceability for each coil and minimum five years of limited warranty.
2. The coating process shall such that uniform coating thickness is maintained at the fin edges. The quality control shall be maintained by ensuring compliance to the applicable ASTM Standards for the following:
    - a. Salt Spray Resistance (Minimum 6,000 Hours)
    - b. Humidity Resistance (Minimum 1,000 Hours)
    - c. Water Immersion (Minimum 260 Hours)
    - d. Cross-Hatch Adhesion (Minimum 4B-5B Rating)
    - e. Impact Resistance (Up to 160 Inch/Pound)
  3. Water coils //including glycol-water//.
  4. //Integral Face and Bypass Steam Coils: Provide integral vertical face and bypass dampers. Electric damper operators shall be furnished and mounted by the AHU manufacturer at the factory. Damper operators shall be of same manufacturer as controls furnished under Section 23 09 23, DIRECT-DIGITAL CONTROL SYSTEM FOR HVAC.//
  5. //Steam distributing tube coils.//
- Q. Humidifier: When included in design, coordinate the humidification requirements with Section 23 22 13 STEAM AND CONDENSATE HEATING PIPING. Provide air-handling unit-mounted humidification section with stainless-steel drain pan of adequate length to allow complete absorption of water vapor. Provide stainless-steel dispersion panel or distributors as indicated, with stainless-steel supports and hardware.
- R. Sound Attenuators: Refer to the contract documents, Section 23 05 41, NOISE AND VIBRATION CONTROL FOR HVAC PIPING AND EQUIPMENT, and Section 23 31 00, HVAC DUCTS AND CASINGS, for additional unit mounted sound attenuator requirements. AHU sound attenuators shall be factory-installed as an integral part of AHU.
- S. Discharge Section: Provide aerodynamically designed framed discharge openings or spun bellmouth fittings to minimize pressure loss.
- T. Electrical and Lighting: Wiring and equipment specifications shall conform to Division 26, ELECTRICAL.
1. Vapor-proof lights using cast aluminum base style with glass globe and cast aluminum guard shall be installed in access sections for fan, mixing box, //humidifier,// and any section over 305 mm (12 inch) wide. A switch shall control the lights in each compartment with pilot light mounted outside the respective compartment access

door. Wiring between switches and lights shall be factory-installed. All wiring shall run in neatly installed electrical conduits and terminate in a junction box for field connection to the building system. Provide single point 115 volt - one phase connection at junction box.

2. Install compatible LED bulb in each light fixture.
3. Provide a convenience duplex //weatherproof// receptacle next to the light switch.
4. Disconnect switch and power wiring: Provide factory or field mounted disconnect switch. Coordinate with Division 26, ELECTRICAL.
5. Provide single point power connection. Coordinate with Division 26, ELECTRICAL.

### **PART 3 - EXECUTION**

#### **3.1 INSTALLATION**

- A. If an installation is unsatisfactory to the COR, the contractor shall correct the installation at no additional cost or time to the Government.
- B. Install air handling unit in conformance with AHRI 430.
- C. Assemble air handling unit components following manufacturer's instructions for handling, testing and operation. Repair damaged galvanized areas with paint in accordance with Mil. Spec. P-21035B. Repair painted units by touch up of all scratches with finish paint material. Vacuum the interior of air handling units clean prior to operation.
- D. //Install seismic restraints for roof top units. Refer to Section 13 05 41, SEISMIC RESTRAINT REQUIREMENTS FOR NON-STRUCTURAL COMPONENTS.//
- E. Leakage and test requirements for air handling units shall be the same as specified for ductwork in Section 23 31 00, HVAC DUCTS AND CASINGS except leakage shall not exceed Leakage Class (CL) 12 listed in SMACNA HVAC Air Duct Leakage Test Manual when tested at 1.5 times the design static pressure. Repair casing air leaks that can be heard or felt during normal operation and to meet test requirements.
- F. Perform field mechanical (vibration) balancing in accordance with Section 23 05 41, NOISE AND VIBRATION CONTROL FOR HVAC PIPING AND EQUIPMENT.
- G. Seal and/or fill all openings between the casing and AHU components and utility connections to prevent air leakage or bypass.

**3.2 STARTUP AND TESTING**

- A. The air handling unit shall not be operated for any purpose, temporary or permanent, until ductwork is clean, filters are in place, bearings are lubricated, and the fan has been test run under observation.
- B. After the air handling unit is installed and tested, provide startup and operating instructions to VA personnel.
- C. An authorized factory representative should startup, test, and certify the final installation and application specific calibration of control components. Items to be verified include fan performance over entire operating range, noise and vibration testing, verification of proper alignment, overall inspection of the installation, Owner/Operator training, etc.
- D. Perform tests as recommended by product manufacturer and listed standards and under actual or simulated operating conditions and prove full compliance with design and specified requirements. Tests of the various items of equipment shall be performed simultaneously with the system of which each item is an integral part.
- E. When any defects are detected, correct defects and repeat test at no additional cost or time to the Government.
- F. //The CxA will observe startup and contractor testing of selected equipment. Coordinate the startup and contractor testing schedules with the COR and CxA. Provide a minimum notice of 10 working days prior to startup and testing.//

**3.3 //COMMISSIONING**

- A. Provide commissioning documentation in accordance with the requirements of Section 23 08 00, COMMISSIONING OF HVAC SYSTEMS.
- B. Components provided under this section of the specification will be tested as part of a larger system.//

**3.4 DEMONSTRATION AND TRAINING**

- A. Provide services of manufacturer's technical representative for //4//  
// // hour//s// to instruct each VA personnel responsible in operation and maintenance of the system.
- B. //Submit training plans and instructor qualifications in accordance with the requirements of Section 23 08 00, COMMISSIONING OF HVAC SYSTEMS.//

- - - E N D - - -