

SECTION 081113 - HOLLOW METAL DOORS AND FRAMES

PART 1 - GENERAL

1.1 RELATED DOCUMENTS

- A. Drawings and general provisions of the Contract, including General and Supplementary Conditions and Division 01 Specification Sections, apply to this Section.

1.2 SUMMARY

- A. Section Includes:

- 1. Standard hollow metal doors and frames.

- B. Related Sections:

- 1. Division 04 Section "Unit Masonry" for embedding anchors for hollow metal work into masonry construction.
 - 2. Division 08 Section "Sound Control Door Assemblies" for packaged, acoustical hollow metal door and frame assemblies with STC ratings of 35 or more.
 - 3. Division 08 Section "Door Hardware" for door hardware for hollow metal doors.
 - 4. Division 09 Sections for field painting hollow metal doors and frames.
 - 5. Division 26 Sections for electrical connections including conduit and wiring for door controls and operators.

1.3 DEFINITIONS

- A. Minimum Thickness: Minimum thickness of base metal without coatings.
- B. Standard Hollow Metal Work: Hollow metal work fabricated according to ANSI/SDI A250.8.
- C. Custom Hollow Metal Work: Hollow metal work fabricated according to ANSI/NAAMM-HMMA 861.

1.4 SUBMITTALS

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, core descriptions, fire-resistance rating, temperature-rise ratings, and finishes.
- B. Shop Drawings: Include the following:
 - 1. Elevations of each door design.
 - 2. Details of doors, including vertical and horizontal edge details and metal thicknesses.
 - 3. Frame details for each frame type, including dimensioned profiles and metal thicknesses.
 - 4. Locations of reinforcement and preparations for hardware.
 - 5. Details of each different wall opening condition.

6. Details of anchorages, joints, field splices, and connections.
7. Details of accessories.
8. Details of moldings, removable stops, and glazing.
9. Details of conduit and preparations for power, signal, and control systems.

C. Samples for Verification:

1. For each type of exposed finish required, prepared on Samples of not less than 3 by 5 inches (75 by 125 mm).
2. For the following items, prepared on Samples about 12 by 12 inches to demonstrate compliance with requirements for quality of materials and construction:
 - a. Doors: Show vertical-edge, top, and bottom construction; core construction; and hinge and other applied hardware reinforcement. Include separate section showing glazing if applicable.
 - b. Frames: Show profile, corner joint, floor and wall anchors, and silencers. Include separate section showing fixed hollow metal panels and glazing if applicable.

D. Other Action Submittals:

1. Schedule: Provide a schedule of hollow metal work prepared by or under the supervision of supplier, using same reference numbers for details and openings as those on Drawings. Coordinate with door hardware schedule.

E. Oversize Construction Certification: For assemblies required to be fire rated and exceeding limitations of labeled assemblies.

F. Product Test Reports: Based on evaluation of comprehensive tests performed by a qualified testing agency, for each type of hollow metal door and frame assembly.

1.5 QUALITY ASSURANCE

A. Source Limitations: Obtain hollow metal work from single source from single manufacturer.

B. Fire-Rated Door Assemblies: Assemblies complying with NFPA 80 that are listed and labeled by a qualified testing agency, for fire-protection ratings indicated.

1. Oversize Fire-Rated Door Assemblies: For units exceeding sizes of tested assemblies, provide certification by a qualified testing agency that doors comply with standard construction requirements for tested and labeled fire-rated door assemblies except for size.
2. Temperature-Rise Limit: At vertical exit enclosures and exit passageways and where indicated, provide doors that have a maximum transmitted temperature end point of not more than 450 deg F (250 deg C) above ambient after 30 minutes of standard fire-test exposure.

C. Fire-Rated, Borrowed-Light Frame Assemblies: Assemblies complying with NFPA 80 that are listed and labeled, by a testing and inspecting agency acceptable to authorities having jurisdiction, for fire-protection ratings indicated, based on testing according to NFPA 257 or UL 9. Label each individual glazed lite.

D. Smoke-Control Door Assemblies: Comply with NFPA 105 or UL 1784.

- E. Preinstallation Conference: Conduct conference at Project site

1.6 DELIVERY, STORAGE, AND HANDLING

- A. Deliver hollow metal work palletized, wrapped, or crated to provide protection during transit and Project-site storage. Do not use nonvented plastic.
 - 1. Provide additional protection to prevent damage to finish of factory-finished units.
- B. Deliver welded frames with two removable spreader bars across bottom of frames, tack welded to jambs and mullions.
- C. Store hollow metal work under cover at Project site. Place in stacks of five units maximum in a vertical position with heads up, spaced by blocking, on minimum 4-inch- (102-mm-) high wood blocking. Do not store in a manner that traps excess humidity.
 - 1. Provide minimum 1/4-inch (6-mm) space between each stacked door to permit air circulation.

1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify actual dimensions of openings by field measurements before fabrication.

1.8 COORDINATION

- A. Coordinate installation of anchorages for hollow metal frames. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors. Deliver such items to Project site in time for installation.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - 1. Amweld Building Products, LLC.
 - 2. Ceco Door Products; an Assa Abloy Group company.
 - 3. Curries Company; an Assa Abloy Group company.
 - 4. Deansteel Manufacturing Company, Inc.
 - 5. Fleming Door Products Ltd.; an Assa Abloy Group company.
 - 6. Karpen Steel Custom Doors & Frames.
 - 7. Kewanee Corporation (The).
 - 8. Pioneer Industries, Inc.
 - 9. Security Metal Products Corp.
 - 10. Steelcraft; an Ingersoll-Rand company.
 - 11. Windsor Republic Doors.

2.2 MATERIALS

- A. Cold-Rolled Steel Sheet: ASTM A 1008/A 1008M, Commercial Steel (CS), Type B; suitable for exposed applications.
- B. Hot-Rolled Steel Sheet: ASTM A 1011/A 1011M, Commercial Steel (CS), Type B; free of scale, pitting, or surface defects; pickled and oiled.
- C. Metallic-Coated Steel Sheet: ASTM A 653/A 653M, Commercial Steel (CS), Type B; with minimum G60 (Z180) or A60 (ZF180) metallic coating.
- D. Frame Anchors: ASTM A 591/A 591M, Commercial Steel (CS), 40Z (12G) coating designation; mill phosphatized.
 - 1. For anchors built into exterior walls, steel sheet complying with ASTM A 1008/A 1008M or ASTM A 1011/A 1011M, hot-dip galvanized according to ASTM A 153/A 153M, Class B.
- E. Inserts, Bolts, and Fasteners: Hot-dip galvanized according to ASTM A 153/A 153M.
- F. Powder-Actuated Fasteners in Concrete: Fastener system of type suitable for application indicated, fabricated from corrosion-resistant materials, with clips or other accessory devices for attaching hollow metal frames of type indicated.
- G. Grout: ASTM C 476, except with a maximum slump of 4 inches (102 mm), as measured according to ASTM C 143/C 143M.
- H. Mineral-Fiber Insulation: ASTM C 665, Type I (blankets without membrane facing); consisting of fibers manufactured from slag or rock wool with 6- to 12-lb/cu. ft. (96- to 192-kg/cu. m) density; with maximum flame-spread and smoke-development indexes of 25 and 50, respectively; passing ASTM E 136 for combustion characteristics.
- I. Glazing: Comply with requirements in Division 08 Section "Glazing."
- J. Bituminous Coating: Cold-applied asphalt mastic, SSPC-Paint 12, compounded for 15-mil (0.4-mm) dry film thickness per coat. Provide inert-type noncorrosive compound free of asbestos fibers, sulfur components, and other deleterious impurities.

2.3 STANDARD HOLLOW METAL DOORS

- A. General: Provide doors of design indicated, not less than thickness indicated; fabricated with smooth surfaces, without visible joints or seams on exposed faces unless otherwise indicated. Comply with ANSI/SDI A250.8.
 - 1. Design: Flush panel
 - 2. Core Construction: Manufacturer's standard kraft-paper honeycomb, polystyrene, polyurethane, polyisocyanurate, mineral-board, or vertical steel-stiffener core.
 - a. Fire Door Core: As required to provide fire-protection and temperature-rise ratings indicated.
 - b. Thermal-Rated (Insulated) Doors: Where indicated, provide doors fabricated with thermal-resistance value (R-value) of not less than 4.0 deg F x h x sq. ft./Btu (0.704 K x sq. m/W) when tested according to ASTM C 1363.

- 1) Locations: interior doors where indicated.
 3. Vertical Edges for Single-Acting Doors: Square edge
 4. Vertical Edges for Double-Acting Doors: Round vertical edges with 2-1/8-inch (54-mm) radius.
 5. Top and Bottom Edges: Closed with flush or inverted 0.042-inch- (1.0-mm-) thick, end closures or channels of same material as face sheets.
 6. Tolerances: Comply with SDI 117, "Manufacturing Tolerances for Standard Steel Doors and Frames."
- B. Interior Doors: Face sheets fabricated from cold-rolled steel sheet. Provide doors complying with requirements indicated below by referencing ANSI/SDI A250.8 for level and model and ANSI/SDI A250.4 for physical performance level:
1. Level 1 and Physical Performance Level C (Standard Duty), Model 1 (Full Flush)
 - a. Width: 1-3/4 inches (44.5 mm)
- C. Hardware Reinforcement: Fabricate according to ANSI/SDI A250.6 with reinforcing plates from same material as door face sheets.
- D. Fabricate concealed stiffeners and hardware reinforcement from either cold- or hot-rolled steel sheet.
- 2.4 STANDARD HOLLOW METAL FRAMES
- A. General: Comply with ANSI/SDI A250.8 and with details indicated for type and profile.
- B. Exterior Frames: Fabricated from metallic-coated steel sheet.
1. Fabricate frames with mitered corners.
 2. Fabricate frames as full profile welded unless otherwise indicated.
 3. Frames for Level 1 Steel Doors: 0.042-inch- (1.0-mm-) thick steel sheet.
- C. Interior Frames: Fabricated from cold-rolled steel sheet.
1. Fabricate frames with mitered corners.
 2. Fabricate frames as full profile welded unless otherwise indicated.
 3. Fabricate knocked-down, drywall slip-on frames for in-place gypsum board partitions.
 4. Frames for Level 1 Steel Doors: 0.042-inch- (1.0-mm-) thick steel sheet.
 5. Frames for Wood Doors: 0.042-inch- (1.0-mm-) thick steel sheet.
 6. Frames for Borrowed Lights: 0.042-inch- (1.0-mm-) thick steel sheet.
- D. Hardware Reinforcement: Fabricate according to ANSI/SDI A250.6 with reinforcement plates from same material as frames.

2.5 CUSTOM HOLLOW METAL DOORS

- A. General: Provide doors not less than 1-3/4 inches (44.5 mm) thick, of seamless hollow construction unless otherwise indicated. Construct doors with smooth surfaces without visible joints or seams on exposed faces. Comply with ANSI/NAAMM-HMMA 861.
- B. Interior Door Face Sheets: Fabricated from cold-rolled steel sheet unless metallic-coated sheet is indicated, minimum 0.042 inch (1.0 mm) thick.
- C. Core Construction: Provide thermal-resistance-rated cores for interior doors where indicated.
 - 1. Steel-Stiffened Core: 0.026-inch- (0.7-mm-) thick, steel vertical stiffeners of same material as face sheets extending full-door height, with vertical webs spaced not more than 6 inches (152 mm) apart, spot welded to face sheets a maximum of 5 inches (127 mm) o.c. Spaces filled between stiffeners with glass- or mineral-fiber insulation.
 - a. Fire Door Core: As required to provide fire-protection and temperature-rise ratings indicated.
 - b. Thermal-Rated (Insulated) Doors: Where indicated, provide doors fabricated with thermal-resistance value (R-value) of not less than 4.0 deg F x h x sq. ft./Btu (0.704 K x sq. m/W) when tested according to ASTM C 1363.
- D. Vertical Edges for Single-Acting Doors: Beveled 1/8 inch in 2 inches (3 mm in 50 mm).
- E. Vertical Edges for Double-Acting Doors: Round vertical edges with 2-1/8-inch (54-mm) radius.
- F. Top and Bottom Channels: Closed with continuous channels, minimum 0.053 inch (1.3 mm) thick, of same material as face sheets and spot welded to both face sheets.
- G. Hardware Reinforcement: Fabricate according to ANSI/NAAMM-HMMA 861 with reinforcing plates from same material as door face sheets.

2.6 CUSTOM HOLLOW METAL FRAMES

- A. General: Fabricate frames of construction indicated. Close contact edges of corner joints tight with faces mitered and stops butted or mitered. Continuously weld faces and soffits and finish faces smooth. Comply with ANSI/NAAMM-HMMA 861.
 - 1. Door Frames for Openings 48 Inches (1219 mm) Wide or Less: Fabricated from 0.053-inch- (1.3-mm-) thick steel sheet.
 - 2. Door Frames for Openings More Than 48 Inches (1219 mm) Wide: Fabricated from 0.067-inch- (1.7-mm-) thick steel sheet.
 - 3. Sidelight and Transom Frames: Fabricated from same thickness material as adjacent door frame.
 - 4. Borrowed-Light Frames: Fabricated from 0.053-inch- (1.3-mm-) thick steel sheet.
- B. Exterior Frames: Formed from metallic-coated steel sheet.
- C. Interior Frames: Fabricated from cold-rolled steel sheet.
- D. Hardware Reinforcement: Fabricate according to ANSI/NAAMM-HMMA 861 with reinforcing plates from same material as frame.

- E. Head Reinforcement: Provide minimum 0.093-inch- (2.3-mm-) thick, steel channel or angle stiffener for opening widths more than 48 inches (1219 mm).

2.7 BULLET RESISTANT WOOD DOOR & HOLLOW METAL FRAME ASSEMBLY

- A. DOOR: Bullet resistant solid core wood door shall be of the "non-ricochet type" complete with unfinished face veneer. Door unit shall be supplied pre hung with a Clear Anodized Aluminum Continuous Gear Hinge on steel frame. If bullet resistant transparent armor glazing is required for door vision panels, they shall be standard products furnished by the door manufacturer and must be a material of the same ballistic level as door assembly. All stiles and rail edges shall be solid wood same species as veneer, a minimum of 3/8" thick.
- B. FRAME: Frames shall be a protection level equal to the door. Frame shall be a "non-ricochet type" design; constructed of 16 ga. commercial grade steel lined with UL LISTED Bullet Resistant Composite. Steel shall be free of scale, pitting, coil breaks or other surface defects. Finish work shall be neat and free of defects. Frames must be welded. Knocked down and mechanical joints are unacceptable. Standard manufacturing tolerances shall be +/- 1/16" for frame opening width, height, diagonal dimensions and overall width and height (outside to outside). If ballistic protection level is greater than level 3, ballistic hardened steel of the appropriate level will be used to line the frames.
- C. FINISH: Cold rolled steel is factory prime painted gray, the continuous hinge is clear anodized aluminum and the door is to be unfinished plain sliced red oak veneer or (other selected by architect). Field paint and finish in accordance with and as directed in the Finish Section 9 of these specifications.

2.8 FRAME ANCHORS

- A. Jamb Anchors:
 - 1. Masonry Type: Adjustable strap-and-stirrup or T-shaped anchors to suit frame size, not less than 0.042 inch (1.0 mm) thick, with corrugated or perforated straps not less than 2 inches (50 mm) wide by 10 inches (250 mm) long; or wire anchors not less than 0.177 inch (4.5 mm) thick.
 - 2. Stud-Wall Type: Designed to engage stud, welded to back of frames; not less than 0.042 inch (1.0 mm) thick.
- B. Floor Anchors: Formed from same material as frames, not less than 0.042 inch (1.0 mm) thick, and as follows:
 - 1. Monolithic Concrete Slabs: Clip-type anchors, with two holes to receive fasteners.
 - 2. Separate Topping Concrete Slabs: Adjustable-type anchors with extension clips, allowing not less than 2-inch (50-mm) height adjustment. Terminate bottom of frames at finish floor surface.

2.9 HOLLOW METAL PANELS

- A. Provide hollow metal panels of same materials, construction, and finish as specified for adjoining hollow metal work.

2.10 STOPS AND MOLDINGS

- A. Moldings for Glazed Lites in Doors: Minimum 0.032 inch (0.8 mm) thick, fabricated from same material as door face sheet in which they are installed.
- B. Fixed Frame Moldings: Formed integral with hollow metal frames, a minimum of 5/8 inch (16 mm) high unless otherwise indicated.
- C. Loose Stops for Glazed Lites in Frames: Minimum 0.032 inch (0.8 mm) thick, fabricated from same material as frames in which they are installed.

2.11 LOUVERS

- A. Provide louvers for interior doors, where indicated, that comply with SDI 111C, with blades or baffles formed of 0.020-inch- ((0.5-mm-)) thick, cold-rolled steel sheet set into 0.032-inch- (0.8-mm-) thick steel frame.
 - 1. Sightproof Louver: Stationary louvers constructed with inverted V-shaped or Y-shaped blades.
 - 2. Lightproof Louver: Stationary louvers constructed with baffles to prevent light from passing from one side to the other, any angle.
 - 3. Fire-Rated Automatic Louvers: Louvers constructed with movable blades closed by actuating fusible link, and listed and labeled for use in fire-rated door assemblies of type and fire-resistance rating indicated by same testing and inspecting agency that established fire-resistance rating of door assembly.

2.12 ACCESSORIES

- A. Mullions and Transom Bars: Join to adjacent members by welding or rigid mechanical anchors.
- B. Ceiling Struts: Minimum 1/4-inch-thick by 1-inch- (6.4-mm-thick by 25.4-mm-) wide steel.
- C. Grout Guards: Formed from same material as frames, not less than 0.016 inch (0.4 mm) thick.

2.13 FABRICATION

- A. Fabricate hollow metal work to be rigid and free of defects, warp, or buckle. Accurately form metal to required sizes and profiles, with minimum radius for thickness of metal. Where practical, fit and assemble units in manufacturer's plant. To ensure proper assembly at Project site, clearly identify work that cannot be permanently factory assembled before shipment.
- B. Tolerances: Fabricate hollow metal work to tolerances indicated in SDI 117
- C. Hollow Metal Doors:
 - 1. Exterior Doors: Provide weep-hole openings in bottom of exterior doors to permit moisture to escape. Seal joints in top edges of doors against water penetration.
 - 2. Glazed Lites: Factory cut openings in doors.
 - 3. Astragals: Provide overlapping astragal on one leaf of pairs of doors where required by NFPA 80 for fire-performance rating or where indicated. Extend minimum 3/4 inch (19 mm) beyond edge of door on which astragal is mounted.

- D. Hollow Metal Frames: Where frames are fabricated in sections due to shipping or handling limitations, provide alignment plates or angles at each joint, fabricated of same thickness metal as frames.
1. Welded Frames: Weld flush face joints continuously; grind, fill, dress, and make smooth, flush, and invisible.
 2. Sidelight and Transom Bar Frames: Provide closed tubular members with no visible face seams or joints, fabricated from same material as door frame. Fasten members at crossings and to jambs by butt welding.
 3. Provide countersunk, flat- or oval-head exposed screws and bolts for exposed fasteners unless otherwise indicated.
 4. Grout Guards: Weld guards to frame at back of hardware mortises in frames to be grouted.
 5. Floor Anchors: Weld anchors to bottom of jambs and mullions with at least four spot welds per anchor.
 6. Jamb Anchors: Provide number and spacing of anchors as follows:
 - a. Masonry Type: Locate anchors not more than 18 inches (457 mm) from top and bottom of frame. Space anchors not more than 32 inches (813 mm) o.c. and as follows:
 - 1) Two anchors per jamb up to 60 inches (1524 mm) high.
 - 2) Three anchors per jamb from 60 to 90 inches (1524 to 2286 mm) high.
 - 3) Four anchors per jamb from 90 to 120 inches (2286 to 3048 mm) high.
 - b. Stud-Wall Type: Locate anchors not more than 18 inches (457 mm) from top and bottom of frame. Space anchors not more than 32 inches (813 mm) o.c. and as follows:
 - 1) Three anchors per jamb up to 60 inches (1524 mm) high.
 - 2) Four anchors per jamb from 60 to 90 inches (1524 to 2286 mm) high.
 - 3) Five anchors per jamb from 90 to 96 inches (2286 to 2438 mm) high.
 - 4) Two anchors per head for frames above 42 inches (1066 mm) wide and mounted in metal-stud partitions.
 7. Door Silencers: Except on weather-stripped doors, drill stops to receive door silencers as follows. Keep holes clear during construction.
 - a. Single-Door Frames: Drill stop in strike jamb to receive three door silencers.
 - b. Double-Door Frames: Drill stop in head jamb to receive two door silencers.
- E. Fabricate concealed stiffeners, edge channels, and hardware reinforcement from either cold- or hot-rolled steel sheet.
- F. Hardware Preparation: Factory prepare hollow metal work to receive templated mortised hardware; include cutouts, reinforcement, mortising, drilling, and tapping according to the Door Hardware Schedule and templates furnished as specified in Division 08 Section "Door Hardware."
1. Locate hardware as indicated, or if not indicated, according to ANSI/SDI A250.8
 2. Reinforce doors and frames to receive nontemplated, mortised and surface-mounted door hardware.
 3. Comply with applicable requirements in ANSI/SDI A250.6 and ANSI/DHI A115 Series specifications for preparation of hollow metal work for hardware.

4. Coordinate locations of conduit and wiring boxes for electrical connections with Division 26 Sections.
- G. Stops and Moldings: Provide stops and moldings around glazed lites where indicated. Form corners of stops and moldings with butted or mitered hairline joints.
1. Single Glazed Lites: Provide fixed stops and moldings welded on secure side of hollow metal work.
 2. Multiple Glazed Lites: Provide fixed and removable stops and moldings so that each glazed lite is capable of being removed independently.
 3. Provide fixed frame moldings on outside of exterior and on secure side of interior doors and frames.
 4. Provide loose stops and moldings on inside of hollow metal work.
 5. Coordinate rabbet width between fixed and removable stops with type of glazing and type of installation indicated.

2.14 STEEL FINISHES

- A. Prime Finish: Apply manufacturer's standard primer immediately after cleaning and pretreating.
1. Shop Primer: Manufacturer's standard, fast-curing, lead- and chromate-free primer complying with ANSI/SDI A250.10 acceptance criteria; recommended by primer manufacturer for substrate; compatible with substrate and field-applied coatings despite prolonged exposure.

PART 3 - EXECUTION

3.1 EXAMINATION

- A. Examine substrates, areas, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
- B. Examine roughing-in for embedded and built-in anchors to verify actual locations before frame installation.
- C. For the record, prepare written report, endorsed by Installer, listing conditions detrimental to performance of the Work.
- D. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 PREPARATION

- A. Remove welded-in shipping spreaders installed at factory. Restore exposed finish by grinding, filling, and dressing, as required to make repaired area smooth, flush, and invisible on exposed faces.
- B. Prior to installation, adjust and securely brace welded hollow metal frames for squareness, alignment, twist, and plumbness to the following tolerances:

1. Squareness: Plus or minus 1/16 inch (1.6 mm), measured at door rabbet on a line 90 degrees from jamb perpendicular to frame head.
 2. Alignment: Plus or minus 1/16 inch (1.6 mm), measured at jambs on a horizontal line parallel to plane of wall.
 3. Twist: Plus or minus 1/16 inch (1.6 mm), measured at opposite face corners of jambs on parallel lines, and perpendicular to plane of wall.
 4. Plumbness: Plus or minus 1/16 inch (1.6 mm), measured at jambs on a perpendicular line from head to floor.
- C. Drill and tap doors and frames to receive nontemplated, mortised, and surface-mounted door hardware.

3.3 INSTALLATION

- A. General: Install hollow metal work plumb, rigid, properly aligned, and securely fastened in place; comply with Drawings and manufacturer's written instructions.
- B. Hollow Metal Frames: Install hollow metal frames of size and profile indicated. Comply with ANSI/SDI A250.11
1. Set frames accurately in position, plumbed, aligned, and braced securely until permanent anchors are set. After wall construction is complete, remove temporary braces, leaving surfaces smooth and undamaged.
 - a. At fire-protection-rated openings, install frames according to NFPA 80.
 - b. Where frames are fabricated in sections because of shipping or handling limitations, field splice at approved locations by welding face joint continuously; grind, fill, dress, and make splice smooth, flush, and invisible on exposed faces.
 - c. Install frames with removable glazing stops located on secure side of opening.
 - d. Install door silencers in frames before grouting.
 - e. Remove temporary braces necessary for installation only after frames have been properly set and secured.
 - f. Check plumbness, squareness, and twist of frames as walls are constructed. Shim as necessary to comply with installation tolerances.
 - g. Field apply bituminous coating to backs of frames that are filled with grout containing antifreezing agents.
 2. Floor Anchors: Provide floor anchors for each jamb and mullion that extends to floor, and secure with postinstalled expansion anchors.
 - a. Floor anchors may be set with powder-actuated fasteners instead of postinstalled expansion anchors if so indicated and approved on Shop Drawings.
 3. Metal-Stud Partitions: Solidly pack mineral-fiber insulation behind frames.
 4. Masonry Walls: Coordinate installation of frames to allow for solidly filling space between frames and masonry with grout.
 5. Concrete Walls: Solidly fill space between frames and concrete with grout. Take precautions, including bracing frames, to ensure that frames are not deformed or damaged by grout forces.
 6. In-Place Concrete or Masonry Construction: Secure frames in place with postinstalled expansion anchors. Countersink anchors, and fill and make smooth, flush, and invisible on exposed faces.

7. In-Place Gypsum Board Partitions: Secure frames in place with postinstalled expansion anchors through floor anchors at each jamb. Countersink anchors, and fill and make smooth, flush, and invisible on exposed faces.
 8. Ceiling Struts: Extend struts vertically from top of frame at each jamb to overhead structural supports or substrates above frame unless frame is anchored to masonry or to other structural support at each jamb. Bend top of struts to provide flush contact for securing to supporting construction. Provide adjustable wedged or bolted anchorage to frame jamb members.
 9. Installation Tolerances: Adjust hollow metal door frames for squareness, alignment, twist, and plumb to the following tolerances:
 - a. Squareness: Plus or minus 1/16 inch (1.6 mm), measured at door rabbet on a line 90 degrees from jamb perpendicular to frame head.
 - b. Alignment: Plus or minus 1/16 inch (1.6 mm), measured at jambs on a horizontal line parallel to plane of wall.
 - c. Twist: Plus or minus 1/16 inch (1.6 mm), measured at opposite face corners of jambs on parallel lines, and perpendicular to plane of wall.
 - d. Plumbness: Plus or minus 1/16 inch (1.6 mm), measured at jambs at floor.
- C. Hollow Metal Doors: Fit hollow metal doors accurately in frames, within clearances specified below. Shim as necessary.
1. Non-Fire-Rated Standard Steel Doors:
 - a. Jambs and Head: 1/8 inch (3 mm) plus or minus 1/16 inch (1.6 mm).
 - b. Between Edges of Pairs of Doors: 1/8 inch (3 mm) plus or minus 1/16 inch (1.6 mm).
 - c. Between Bottom of Door and Top of Threshold: Maximum 3/8 inch (9.5 mm).
 - d. Between Bottom of Door and Top of Finish Floor (No Threshold): Maximum 3/4 inch (19 mm).
 2. Fire-Rated Doors: Install doors with clearances according to NFPA 80.
 3. Smoke-Control Doors: Install doors according to NFPA 105.
- D. Glazing: Comply with installation requirements in Division 08 Section "Glazing" and with hollow metal manufacturer's written instructions.
1. Secure stops with countersunk flat- or oval-head machine screws spaced uniformly not more than 9 inches (230 mm) o.c. and not more than 2 inches (50 mm) o.c. from each corner.

3.4 ADJUSTING AND CLEANING

- A. Final Adjustments: Check and readjust operating hardware items immediately before final inspection. Leave work in complete and proper operating condition. Remove and replace defective work, including hollow metal work that is warped, bowed, or otherwise unacceptable.
- B. Remove grout and other bonding material from hollow metal work immediately after installation.
- C. Prime-Coat Touchup: Immediately after erection, sand smooth rusted or damaged areas of prime coat and apply touchup of compatible air-drying, rust-inhibitive primer.

- D. Metallic-Coated Surfaces: Clean abraded areas and repair with galvanizing repair paint according to manufacturer's written instructions.

END OF SECTION 081113