

PART 1 - GENERAL

1.1 SUMMARY

1. Types of items described in this Section:
 1. Steel frame products including frames, transom frames (glazed or paneled), sidelight and window assemblies, fire-rated and non-rated.
 2. Steel panels, fixed or removable, flush or rebated, similar in construction to steel doors, for use in steel frame product.
 3. Steel doors, swing type, flush, with or without embossed face sheets, with or without glazed or louvered openings, fire-rated and non-rated.
 4. Louvers, fire rated and non-rated.
2. Related Work
 1. Division 04 Section *Concrete Unit Masonry* for embedding anchors for hollow metal work into masonry construction.
 2. Division 07 Sections on air barriers for spray-foam sealant between frame and rough opening.
 3. Division 08 Section *Door Hardware*.
 4. Division 09 Section on field painting of doors and frames.
3. Types of items you will not find described in this Section:
 1. Detention Doors and Frames.
 2. Sound Control Door Assemblies for packaged, acoustical hollow metal door and frame assemblies.
 3. Lead-lined, hollow metal doors and frames.
 4. Electrical connections including conduit and wiring for door controls and operators.

1.2 DEFINITIONS

1. Minimum Thickness: Minimum thickness of base metal without coatings.

1.3 SUBMITTALS

1. Product Data: For each type of product indicated. Include construction details, material descriptions, core descriptions, fire-resistance rating, and finishes.
2. LEED Submittals:
 1. Product Data for products having recycled content, documentation indicating percentages by weight of postconsumer and preconsumer recycled content. Include statement indicating cost for each product having recycled content.
3. 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 mouldings, removable stops, and glazing.
 9. Details of conduit and preparations for power, signal, and control systems.

4. 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.

1.4 INFORMATIONAL SUBMITTALS

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

1.5 QUALITY ASSURANCE

1. Except as otherwise specified, comply with requirements of *Canadian Manufacturing Standards for Steel Doors and Frames* published by the Canadian Steel Door and Frame Manufacturers' Association.
2. Source Limitations: Obtain hollow metal work from single source from single manufacturer.
3. Fire-Rated Door Assemblies: Assemblies complying with CAN4-S104-M that are listed and labelled 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 labelled fire-rated door assemblies except for size.
4. Fire-Rated, Borrowed-Light Frame Assemblies: Assemblies complying with CAN4-S104-M that are listed and labelled, by a testing and inspecting agency acceptable to authorities having jurisdiction, for fire-protection ratings indicated. Label each individual glazed lite.

1.6 DELIVERY, STORAGE, AND HANDLING

1. Deliver hollow metal work palletized, wrapped, or crated to provide protection during transit and Project-site storage. Do not use nonvented plastic.
2. Deliver welded frames with two removable spreader bars across bottom of frames, tack welded to jambs and mullions.
3. 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 102 mm high wood blocking. Do not store in a manner that traps excess humidity.
 1. Provide minimum 6 mm space between each stacked door to permit air circulation.

1.7 PROJECT CONDITIONS

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

1.8 COORDINATION

1. 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 MATERIALS

1. Recycled Content of Steel Products: Postconsumer recycled content plus one-half of preconsumer recycled content not less than 25 percent.
2. Steel
 1. Commercial grade steel to ASTM A924-97 (M-97), galvanized to ASTM A653-97 (M-97), Commercial Steel (CS), Type B, A40 (ZF120) minimum unless otherwise noted.
 2. Minimum steel thicknesses shall be in accordance with Appendix 1 of the CSDMA, *Recommended Specifications for Commercial Steel Door and Frame Products*.
3. Door Core Materials
 1. Honeycomb: Structural small cell 25.4 mm maximum kraft paper 'honeycomb'. Weight: 36.3 kg per ream minimum, density: 16.5 kg/m³ minimum, sanded to required thickness.
 2. Fibreglass: Loose batt type, density 24 kg/m³ minimum, conforming to ASTM C553 or ASTM C592.
 3. Polystyrene: Rigid extruded, fire retardant, closed cell board, Type 1, density: 16 to 32 kg/m³, thermal values: RSI 1.06 (R 6.0) minimum, conforming to ASTM C578.
 4. Polystyrene: Rigid extruded fire retardant, closed cell board. Density: 16 to 32 kg/m³, thermal values; RSI 1.0 (R 6.0) minimum, Type 1, in accordance with ASTM C578.
 5. Polyisocyanurate: Rigid foam, closed cell, faced board, thermal value: RSI 2.17 (R12.3) minimum, conforming to ASTM C1289

2.2 MISCELLANEOUS

1. Primers
 1. Rust inhibitive touch-up only.
2. Door Silencers
 1. Single stud rubber/neoprene type.
3. Exterior Top Caps
 1. Rigid polyvinylchloride extrusion conforming to CGSB 41-GP-19MA.
4. Frame Thermal Breaks
 1. Rigid polyvinylchloride extrusion conforming to CGSB 41-GP-19MA.
5. Inserts, Bolts, and Fasteners: Hot-dip galvanized according to ASTM A 153/A 153M.
6. 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.
7. Grout: ASTM C 476, except with a maximum slump of 102 mm, as measured according to ASTM C 143/C 143M.
8. Glazing: Comply with requirements in Division 08 Section *Glazing*.
9. Bituminous Coating: Cold-applied asphalt mastic, SSPC-Paint 12, compounded for 0.4 mm dry film thickness per coat. Provide inert-type noncorrosive compound free of asbestos fibres, sulphur components, and other deleterious impurities.

2.3 FABRICATION – GENERAL

1. Manufacturer door and frame products in accordance with the CSDMA's, *Recommended Dimensional Standards for Commercial Steel Doors and Frames*.
2. Selected Door and Frame Requirements, unless noted otherwise (uno)

Item	Location		
	Interior, Unless noted otherwise	Exterior, Unless noted otherwise	Steel Stiffened, where noted
Steel Coating	A40 (ZF120) minimum; uno.	A40 (ZF120) minimum, uno. Provide G90 (Z275) coating where noted.	A40 (ZF120) minimum, uno. Provide G90 (Z275) coating where noted.
Doors			
Duty / Min. Steel Thickness	Medium duty / 1.3 mm (18 gauge nominal); uno.	Heavy duty / 1.6 mm (16 gauge nominal); uno.	Extra heavy duty / 2.0 mm (14 gauge nominal), uno.
Design	Flush panel, uno.	Flush panel, uno.	Flush panel, uno
Core,	Honeycomb core, laminated under pressure to face sheets; unless noted otherwise.	Polystyrene or polyisocyanurate core, laminated under pressure to face sheets; unless otherwise noted.	Core reinforced with vertical stiffeners, securely welded to each face at 150mm on centre maximum; voids filled with fibre-glass batt type insulation.
Longitudinal Seams	Mechanically interlocked, adhesive assisted with edge seams tack welded, filled and sanded flush with no visible seam; uno.	Mechanically interlocked, adhesive assisted with edge seams tack welded, filled and sanded flush with no visible seam; uno.	Continuously welded the full height of the door filled and ground smooth with no visible seams.
Caps	None, uno.	PVC, uno. Provide steel caps where noted.	Steel cap.
Thermally Broken?	No	No, uno.	No.
Frames			
Duty / Min. Steel Thickness	Medium duty / 1.3 mm (18 gauge nominal); uno. Standard duty / 1.0 mm (20 gauge nominal) for hollow core wood doors.	Heavy duty / 1.6 mm (16 gauge nominal); uno.	Heavy duty / 1.6 mm (16 gauge nominal); uno.
Construction	Full face, punch-mitred, or saw mitred welded construction; uno.	Full face welded construction.	Full face welded construction.
Thermally Broken?	No	No, uno.	No.

2.4 FABRICATION - FRAME PRODUCTS

1. General
 1. Provide frame mortised, blanked, reinforced, drilled, and tapped at the factory for templated hardware only, in accordance with the approved hardware schedule and templates provided by the hardware supplier.
 2. Protect mortised cut-outs with steel guard boxes except for dry wall applications.

3. Reinforce frame where required, for surface mounted hardware, anchor hinges, thrust pivots, pivot reinforced hinges, or non-templated hardware.
 4. Provide anchorage appropriate to floor, wall, and frame construction. Each wall anchor shall be located immediately above or below each hinge reinforcement on the hinge jamb and directly opposite on the strike jamb. For rebate opening heights up to and including 1520 mm provide two anchors, and an additional anchor for each additional 760 mm of height or fraction thereof, except as indicated below. Frames in previously placed concrete, masonry, or structural steel shall be provided with anchors located not more than 150 mm from the top and bottom of each jamb, and intermediate anchors at 660 mm on centre maximum. Fasteners for such anchors shall be provided by others.
 5. Provide minimum reinforcing, anchor and other component gauges in accordance with Table 1 of the CSDMA, *Recommended Specifications for Commercial Steel Door and Frame Products*.
 6. Prepare each door opening for single stud rubber door silencers, three 3 for single
 7. Provide fire-rated frame products for those openings requiring fire protection. Provide frames, transom and sidelight assemblies listed for conformance with CAN4-S104. Provide window assemblies listed for conformance with CAN4-S106. Ensure all fire-rated frame products bear the label of, and be listed by a nationally recognized testing agency having a factory inspection service. Labelling shall be in accordance with NFPA 80, the listing authority's policies and label materials, and identify the manufacturer. Construct fire-rated frame products as listed for labelling in the Follow-Up Service Procedures/Factory Inspection Manuals issued by the listing agency to individual manufacturers.
 8. For each grade frame indicated form from a steel sheet having a minimum thickness of:
 1. Standard Duty grade frames: 1.0 mm
 2. Medium Duty grade frames: 1.3 mm
 3. Heavy Duty and Extra Heavy Duty grade frames: 1.6 mm
2. Welded Type
1. Accurately mitre or mechanically join frame products.
 2. Ensure frame product perimeter corner joints shall be as defined in Appendix 2 of the CSDMA, *Recommended Specifications for Commercial Steel Door and Frame Products*, and as follows
 1. Profile welded; punch-mitred - continuously welded on the profile faces, rabbets, returns and soffit intersections, or saw-mitred - continuously welded on the profile faces, rabbets, returns, stops and soffit intersections. Punch or saw-mitred, at the manufacturer's discretion. All profile welded frame product exposed faces shall be filled and ground to a smooth, uniform, seamless surface.
 2. Face welded; continuously welded on the profile faces, with exposed faces filled and ground to a smooth, uniform, seamless surface.
 3. Tack welded; welded on the faces and returns, with exposed hairline joint intersections.
 3. Ensure joints at mullions, sills and center rails are:
 1. Coped accurately, butted and tightly fitted.
 2. At intersecting flush profile faces, securely welded, filled and ground to a smooth, uniform, seamless surface.
 3. At intersecting recessed profile faces, securely welded to concealed reinforcements, with exposed hairline face seams.
 4. At all other intersecting profile elements have exposed hairline face seams.
 4. Welding: to CSA W59.
 5. Ensure a floor anchor is securely attached to the inside of each jamb profile where frame product is to be installed prior to the adjacent partition. Provide each floor anchor s with two holes for securing to the floor. For conditions that do not permit the use of a floor anchor, substitute with an additional wall anchor, located within 150 mm of the base of the jamb.
 6. Weld in two temporary jamb spreaders per door opening to maintain proper alignment during shipment and handling. Do not be used for installation.
 7. Form glazing stops from steel channel, minimum 16 mm height, accurately fitted, butted at corners and fastened to frame sections with counter-sunk oval head sheet metal screws.

8. When required due to site access or due to shipping limitations, fabricate frame product for large openings in sections as designated on the submittal drawings, with splice joints for field assembly and welding.
 9. Prior to shipment, mark each frame product with an identification number as shown on submittal drawings.
3. Knocked-Down Type
1. Ship knocked-down type frames unassembled.
 2. Ensure frames have mechanical joints which inter-lock securely and provide functionally satisfactory performance when assembled and installed in accordance with the manufacturer's published instructions.
 3. Where frame product is to be installed prior to the adjacent partition, securely attach a floor anchor to the inside of each jamb profile. Provide each floor anchor with two 2 holes for securing to the floor. For conditions that do not permit the use of a floor anchor, substitute with an additional wall anchor, located within 150 mm of the base of the jamb.
 4. Prior to shipment, mark each frame product with an identification number as shown on submittal drawings.

2.5 FABRICATION - DOORS

1. 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 requirements of Canadian Manufacturing Standards for Steel Doors and Frames published by the Canadian Steel Door and Frame Manufacturers' Association except as noted.
 1. Longitudinal Edge Profile:
 1. Vertical Edges for Single-Acting Doors: Manufacturer's standard.
 2. Vertical Edges for Double-Acting Doors: Round vertical edges with 54 mm radius.
 2. Provide doors mortised, blanked, reinforced, drilled and tapped at the factory for templated hardware only, in accordance with the approved hardware schedule and templates provided by the hardware supplier.
 3. Factory prepare holes 12.7 mm diameter and larger, except for mounting and through-bolt holes.. Factory-prepare holes less than 12.7 mm when required for the function of the device (for knob, lever, cylinder, thumb or turn pieces) or when these holes over-lap function holes.
 4. Reinforce doors where required for surface mounted hardware, anchor hinges, thrust pivots, pivot reinforced hinges, or non-templated hardware.
 5. Provide top and bottom of doors with inverted, recessed, welded steel channels.
 6. Provide minimum reinforcing and component gauges in accordance with Table 1 of the CSDMA, *Recommended Specifications for Commercial Steel Door and Frame Products*.
 7. Provide factory-applied touch-up primer at areas where zinc coating has been removed during fabrication.
 8. Provide fire-rated doors for those openings requiring fire protection. Provide products listed for conformance with CAN4-S104. Provide fire-rated doors bearing label of, and be listed by a nationally recognized testing agency having a factory inspection service. Labelling shall be in accordance with NFPA 80, the listing authority's policies and label materials, and shall identify the manufacturer. Construct fire-rated doors as listed for labelling in the Follow-Up Service Procedures/Factory Inspection Manuals issued by the listing agency to individual manufacturers.
 9. Prior to shipment, mark each door with an identification number as shown on the submittal drawings.
 10. For each grade door indicated form both face sheets for doors from a steel sheet having a minimum thickness of:
 1. Standard Duty grade doors: 1.0 mm
 2. Medium Duty grade doors: 1.3 mm
 3. Heavy Duty grade doors: 1.6 mm
 4. Extra Heavy Duty grade doors: 2.0 mm

2.6 HOLLOW METAL PANELS

1. Provide hollow metal panels of same materials, construction, and finish as specified for adjoining hollow metal doors.

2.7 FRAME ANCHORS

1. Jamb Anchors:
 1. Masonry Type: Adjustable strap-and-stirrup or T-shaped anchors to suit frame size, not less than 1.0 mm thick, with corrugated or perforated straps not less than 50 mm wide by 250 mm long; or wire anchors not less than 4.5 mm thick.
 2. Stud-Wall Type: Designed to engage stud, welded to back of frames; not less than 1.0 mm thick.
 3. Compression Type for Drywall Slip-on Frames: Adjustable compression anchors.
 4. Postinstalled Expansion Type for In-Place Concrete or Masonry: Minimum 9.5 mm diameter bolts with expansion shields or inserts. Provide pipe spacer from frame to wall, with throat reinforcement plate, welded to frame at each anchor location.
2. Floor Anchors: Formed from same material as frames, not less than 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 50 mm height adjustment. Terminate bottom of frames at finish floor surface.

2.8 STOPS AND MOULDINGS

1. Mouldings for Glazed Lites in Doors: Minimum 0.8 mm thick, fabricated from same material as door face sheet in which they are installed.
2. Fixed Frame Mouldings: Formed integral with hollow metal frames, a minimum of 16 mm high unless otherwise indicated.
3. Loose Stops for Glazed Lites in Frames: Minimum 0.8 mm thick, fabricated from same material as frames in which they are installed.
4. Terminated Stops: Where indicated on interior door frames, terminate stops 152 mm above finish floor with a 45-degree angle cut, and close open end of stop with steel sheet closure. Cover opening in extension of frame with welded-steel filler plate, with welds ground smooth and flush with frame.
 1. Provide terminated stops only where indicated.

2.9 LOUVERS

1. Provide louvers for interior doors, where indicated, with blades or baffles formed of 0.5 mm thick, cold-rolled steel sheet set into 0.8 mm thick steel frame.
 1. Sightproof Louver: Stationary louvers constructed with inverted V-shaped or Y-shaped blades.
 2. Fire-Rated Automatic Louvers: Louvers constructed with movable blades closed by actuating fusible link, and listed and labelled 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.

2.10 ACCESSORIES

1. Mullions and Transom Bars: Join to adjacent members by welding or rigid mechanical anchors.
2. Ceiling Struts: Minimum 6.4 mm thick by 25.4 mm wide steel.
3. Grout Guards: Formed from same material as frames, not less than 0.4 mm thick.

2.11 FABRICATION

1. 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.
2. 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 19 mm beyond edge of door on which astragal is mounted.
3. 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:
 1. Masonry Type: Locate anchors not more than 457 mm from top and bottom of frame. Space anchors not more than 813 mm o.c. and as follows:
 - 1) Two anchors per jamb up to 1524 mm high.
 - 2) Three anchors per jamb from 1524 to 2286 mm high.
 - 3) Four anchors per jamb from 2286 to 3048 mm high.
 - 4) Four anchors per jamb plus 1 additional anchor per jamb for each 610 mm or fraction thereof above 3048 mm high.
 2. Stud-Wall Type: Locate anchors not more than 457 mm from top and bottom of frame. Space anchors not more than 813 mm o.c. and as follows:
 - 1) Three anchors per jamb up to 1524 mm high.
 - 2) Four anchors per jamb from 1524 to 2286 mm high.
 - 3) Five anchors per jamb from 2286 to 2438 mm high.
 - 4) Five anchors per jamb plus 1 additional anchor per jamb for each 610 mm or fraction thereof above 2438 mm high.
 - 5) Two anchors per head for frames above 1066 mm wide and mounted in metal-stud partitions.
 3. Compression Type: Not less than two anchors in each jamb.
 4. Postinstalled Expansion Type: Locate anchors not more than 152 mm from top and bottom of frame. Space anchors not more than 660 mm o.c.
 7. Door Silencers: Except on weather-stripped doors, drill stops to receive door silencers as follows. Keep holes clear during construction.
 1. Single-Door Frames: Drill stop in strike jamb to receive three door silencers.
 2. Double-Door Frames: Drill stop in head jamb to receive two door silencers.
 4. Fabricate concealed stiffeners, edge channels, and hardware reinforcement from either cold- or hot-rolled steel sheet.

5. Hardware Preparation: Factory prepare hollow metal work to receive templated mortised hardware; include cut-outs, 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. Coordinate locations of conduit and wiring boxes for electrical connections with Electrical sections.
6. Stops and Mouldings: Provide stops and mouldings around glazed lites indicated. Form corners of stops and mouldings with butted or mitred hairline joints.
 1. Single Glazed Lites: Provide fixed stops and mouldings welded on secure side of hollow metal work.
 2. Multiple Glazed Lites: Provide fixed and removable stops and mouldings so that each glazed lite is capable of being removed independently.
 3. Provide fixed frame mouldings on outside of exterior and on secure side of interior doors and frames.
 4. Provide loose stops and mouldings on inside of hollow metal work.
 5. Coordinate rabbet width between fixed and removable stops with type of glazing and type of installation indicated.

PART 3 - EXECUTION

3.1 EXAMINATION

1. Examine substrates, areas, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.
2. Examine roughing-in for embedded and built-in anchors to verify actual locations before frame installation.
3. Proceed with installation only after unsatisfactory conditions have been corrected.

3.2 PREPARATION

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

3.3 INSTALLATION

1. General: Install hollow metal work plumb, rigid, properly aligned, and securely fastened in place; comply with Drawings and manufacturer's written instructions.
2. Hollow Metal Frames: Install hollow metal frames of size and profile indicated.

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.
 1. At fire-protection-rated openings, install frames according to NFPA 80.
 2. 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.
 3. Install frames with removable glazing stops located on secure side of opening.
 4. Install door silencers in frames before grouting.
 5. Remove temporary braces necessary for installation only after frames have been properly set and secured.
 6. Check plumbness, squareness, and twist of frames as walls are constructed. Shim as necessary to comply with installation tolerances.
 7. 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.
 1. 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-fibre 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, but only when specifically noted. 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:
 1. Squareness: Plus or minus 1.6 mm, measured at door rabbet on a line 90 degrees from jamb perpendicular to frame head.
 2. Alignment: Plus or minus 1.6 mm, measured at jambs on a horizontal line parallel to plane of wall.
 3. Twist: Plus or minus 1.6 mm, measured at opposite face corners of jambs on parallel lines, and perpendicular to plane of wall.
 4. Plumbness: Plus or minus 1.6 mm, measured at jambs at floor.
3. Hollow Metal Doors: Fit hollow metal doors accurately in frames, within clearances specified below. Shim as necessary.
 1. Non-Fire-Rated Standard Steel Doors:
 1. Jambs and Head: 3 mm plus or minus 1.6 mm.
 2. Between Edges of Pairs of Doors: 3 mm plus or minus 1.6 mm.
 3. Between Bottom of Door and Top of Threshold: Maximum 9.5 mm.
 4. Between Bottom of Door and Top of Finish Floor (No Threshold): Maximum 19 mm.
 2. Fire-Rated Doors: Install doors with clearances according to NFPA 80.

4. 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 230 mm o.c. and not more than 50 mm o.c. from each corner.
- 3.4 ADJUSTING AND CLEANING
 1. 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.
 2. Remove grout and other bonding material from hollow metal work immediately after installation.
 3. Metallic-Coated Surfaces: Clean abraded areas and repair with galvanizing repair paint according to manufacturer's written instructions.

END OF SECTION