

**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 1 Specification Sections, apply to this Section.

**1.2 SUMMARY**

- A. This Section includes the following:
  - 1. Standard hollow-metal steel doors.
  - 2. Standard hollow-metal steel frames.
- B. Related Sections include the following:
  - 1. Division 8 Sections for door hardware for standard steel doors.
  - 2. Division 9 Painting Sections for field painting standard steel doors and frames.

**1.3 DEFINITIONS**

- A. Minimum Thickness: Minimum thickness of base metal without coatings.

**1.4 SUBMITTALS**

- A. Product Data: Include construction details, material descriptions, core descriptions, label compliance, fire-resistance rating and finishes for each type of steel door and frame specified.
- B. Shop Drawings: In addition to requirements below, provide a schedule of standard steel doors and frames using same reference numbers for details and openings as those on Drawings:
  - 1. Elevations of each door design.
  - 2. Details of doors, including vertical and horizontal edge details.
  - 3. Frame details for each frame type, including dimensioned profiles.
  - 4. Details and locations of reinforcement and preparations for hardware.
  - 5. Details of each different wall opening condition.
  - 6. Details of anchorages, accessories, joints, and connections.
  - 7. Details of conduit and preparations for electrified door hardware and controls.

- C. Qualification Data: For Installer.

**1.5 QUALITY ASSURANCE**

- A. Installer Qualifications: An employer of workers trained and approved by manufacturer.

- B. Testing Agency Qualifications: An independent agency qualified according to ASTM E 329 for testing indicated, as documented according to ASTM E 548.
- C. Source Limitations: Obtain standard steel doors and frames through one source from a single manufacturer.

#### 1.6 DELIVERY, STORAGE, AND HANDLING

- A. Deliver doors and frames palletized, wrapped, or crated to provide protection during transit and Project-site storage. Do not use non-vented plastic.
- B. Deliver welded frames with two removable spreader bars across bottom of frames, tack welded to jambs and mullions.
- C. Store doors and frames under cover at Project site. Place units in a vertical position with heads up, spaced by blocking, on minimum 4-inch- high wood blocking. Avoid using non-vented plastic or canvas shelters that could create a humidity chamber.
  - 1. If wrappers on doors become wet, remove cartons immediately. Provide minimum 1/4-inch space between each stacked door to permit air circulation.

#### 1.7 PROJECT CONDITIONS

- A. Field Measurements: Verify openings by field measurements before fabrication and indicate measurements on Shop Drawings.
  - 1. Established Dimensions: Where field measurements cannot be made without delaying the Work, establish opening dimensions and proceed with fabricating standard steel frames without field measurements. Coordinate wall construction to ensure that actual opening dimensions correspond to established dimensions.

#### 1.8 COORDINATION

- A. Coordinate installation of anchorages for standard steel frames. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in masonry. Deliver such items to Project site in time for installation.

### PART 2 - PRODUCTS

#### 2.1 MANUFACTURERS

- A. Available Manufacturers: Subject to compliance with requirements, manufacturers offering products that may be incorporated into the Work include, but are not limited to, the following:
  - 1. Ceco Door Products; an ASSA ABLOY Group Company.
  - 2. Fleming Door Products Ltd.; an ASSA ABLOY Group Company.
  - 3. Kewanee Corporation (The).
  - 4. Steelcraft; an Ingersoll-Rand Company.
  - 5. "Or Approved Equal"

## 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 A40 zinc-iron-alloy (galvannealed) coating designation.
- D. Electrolytic Zinc-Coated Steel Sheet: ASTM A 591/A 591M, Commercial Steel (CS), Class B coating; mill phosphatized.
- E. Supports and Anchors: After fabricating, galvanize units to be built into exterior walls according to ASTM A 153/A 153M, Class B.
- F. Inserts, Bolts, and Fasteners: Provide items to be built into exterior walls, hot-dip galvanized according to ASTM A 153/A 153M.
- G. 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 standard steel door frames of type indicated.
- 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. density; with maximum flame-spread and smoke-developed indexes of 25 and 50 respectively; passing ASTM E 136 for combustion characteristics.
- I. Bituminous Coating: Cold-applied asphalt mastic, SSPC-Paint 12, compounded for 15-mil dry film thickness per coat. Provide inert-type non-corrosive compound free of asbestos fibers, sulfur components, and other deleterious impurities.

## 2.3 STANDARD STEEL 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 A250.8.
  - 1. Design: Flush panel.
  - 2. Core Construction: Manufacturer's standard kraft-paper honeycomb, polyurethane, or vertical steel-stiffener core that produces doors complying with ANSI A250.8.
    - a. Fire Door Core: As required to provide fire-protection ratings indicated.
    - b. Thermal-Rated (Insulated) Doors: Where indicated, provide doors fabricated with thermal-resistance value (R-value) of not less than 6.0 deg F x h x sq. ft. /Btu when tested according to ASTM C 1363.
      - 1) Locations: Exterior doors.
  - 3. Vertical Edges for Single-Acting Doors: Beveled edge.
    - a. Beveled Edge: 1/8 inch in 2 inches.
  - 4. Vertical Edges for Double-Acting Doors: Round vertical edges with 2-1/8-inch radius.

5. Top and Bottom Edges: Closed with flush or inverted 0.042-inch- 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. Hardware Reinforcement: Fabricate reinforcement plates from same material as door face sheets to comply with the following minimum sizes:

1. Hinges: Minimum 0.123 inch thick by 1-1/2 inches wide by 6 inches longer than hinge, secured by not less than 6 spot welds.
2. Pivots: Minimum 0.167 inch thick by 1-1/2 inches wide by 6 inches longer than hinge, secured by not less than 6 spot welds.
3. Lock Face, Flush Bolts, Closers, and Concealed Holders: Minimum 0.067 inch thick.
4. All Other Surface-Mounted Hardware: Minimum 0.067 inch thick.

C. Fabricate concealed stiffeners and hardware reinforcement from either cold- or hot-rolled steel sheet.

## 2.4 STANDARD STEEL FRAMES

A. General: Comply with ANSI A250.8 and with details indicated for type and profile.

B. Exterior Frames: Fabricated from metallic-coated steel sheet.

1. Fabricate frames with mitered or coped and welded face corners and seamless face joints.
2. Frames for Level 2 Steel Doors: 0.053-inch- thick steel sheet, unless otherwise indicated.

C. Interior Frames: Fabricated from cold-rolled steel sheet, unless otherwise indicated to comply with exterior frame requirements.

1. Fabricate frames with mitered or coped and welded face corners and seamless face joints, unless otherwise indicated.
2. Fabricate knocked-down frames with mitered or coped corners, for field assembly.
3. Fabricate knocked-down, drywall slip-on frames for in-place gypsum board partitions.
4. Frames for Wood Doors: 0.053-inch- thick steel sheet.

D. Hardware Reinforcement: Fabricate reinforcement plates from same material as frames to comply with the following minimum sizes:

1. Hinges: Minimum 0.123 inch thick by 1-1/2 inches wide by 6 inches longer than hinge, secured by not less than 6 spot welds.
2. Pivots: Minimum 0.167 inch thick by 1-1/2 inches wide by 6 inches longer than hinge, secured by not less than 6 spot welds.
3. Lock Face, Flush Bolts, Closers, and Concealed Holders: Minimum 0.067 inch thick.
4. All Other Surface-Mounted Hardware: Minimum 0.067 inch thick.

E. Supports and Anchors: Fabricated from electrolytic zinc-coated or metallic-coated steel sheet.

F. Jamb Anchors:

1. Masonry Type: Adjustable strap-and-stirrup or T-shaped anchors to suit frame size, not less than 0.042 inch thick, with corrugated or perforated straps not less than 2 inches wide by 10 inches long; or wire anchors not less than 0.177 inch thick.
2. Stud-Wall Type: Designed to engage stud, welded to back of frames; not less than 0.042 inch thick.

3. Compression Type for Slip-on Frames: Adjustable compression anchors.
- G. Floor Anchors: Formed from same material as frames, not less than 0.042 inch thick, and as follows:
  1. Concrete Slabs: Clip-type anchors, with two holes to receive fasteners.
- H. Fabricate concealed stiffeners and hardware reinforcement from either cold- or hot-rolled steel sheet.

## 2.5 STOPS AND MOLDINGS

- A. Fixed Frame Moldings: Formed integral with standard steel frames, minimum 5/8 inch high, unless otherwise indicated.
- B. Astragals: Provide Astragals and/or Astragal Weather Strips at all exterior double doors.

## 2.6 FABRICATION

- A. General: Fabricate standard steel doors and frames 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. Standard Steel 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.
- C. Standard Steel 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. Provide countersunk, flat- or oval-head exposed screws and bolts for exposed fasteners, unless otherwise indicated.
  3. Floor Anchors: Weld anchors to bottom of jambs and mullions with at least four spot welds per anchor.
  4. Jamb Anchors: Provide number and spacing of anchors as follows:
    - a. Masonry Type: Locate anchors not more than 18 inches from top and bottom of frame. Space anchors not more than 32 inches o.c. and as follows:
      - 1) Two anchors per jamb up to 60 inches in height.
      - 2) Three anchors per jamb from 60 to 90 inches in height.
      - 3) Four anchors per jamb from 90 to 120 inches in height.
      - 4) Four anchors per jamb plus 1 additional anchor per jamb for each 24 inches or fraction thereof more than 120 inches in height.
    - b. Stud-Wall Type: Locate anchors not more than 18 inches from top and bottom of frame. Space anchors not more than 32 inches o.c. and as follows:
      - 1) Three anchors per jamb up to 60 inches in height.
      - 2) Four anchors per jamb from 60 to 90 inches in height.
      - 3) Five anchors per jamb from 90 to 96 inches in height.

- 4) Five anchors per jamb plus 1 additional anchor per jamb for each 24 inches or fraction thereof more than 96 inches in height.
    - 5) Two anchors per head for frames more than 42 inches wide and mounted in metal-stud partitions.
  - c. Compression Type: Not less than two anchors in each jamb.
- 5. Door Silencers: Except on weather-stripped doors, drill stops to receive door silencers as follows. Provide plastic plugs to 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.
- D. Hardware Preparation: Factory prepare standard steel doors and frames 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 8 Section "Door Hardware."
  - 1. Reinforce doors and frames to receive non-templated mortised and surface-mounted door hardware.
  - 2. Comply with applicable requirements in ANSI A250.6 and ANSI/DHI A115 Series specifications for door and frame preparation for hardware. Locate hardware as indicated on Shop Drawings or, if not indicated, according to ANSI A250.8.
- E. 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. Provide fixed frame moldings on outside of exterior and on secure side of interior doors and frames.
  - 2. Provide loose stops and moldings on inside of hollow metal work.
  - 3. Coordinate rabbet width between fixed and removable stops with type of glazing and type of installation indicated.
  - 4. Single Glazed Lites: Provide fixed stops and moldings welded on secure side of hollow metal work.
  - 5. Multiple Glazed Lites: Provide fixed and removable stops and moldings so that each glazed lite is capable of being removed independently.
  - 6. Provide fixed frame moldings on outside of exterior and on secure side of interior doors and frames.

## 2.7 STEEL FINISHES

- A. General: Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
  - 1. Finish standard steel door and frames after assembly.

## 2.8 Color and Gloss: As selected by Government Design Professional from manufacturer's full range.

- A. Metallic-Coated Steel Surface Preparation: Clean surfaces with non-petroleum solvent so surfaces are free of oil and other contaminants. After cleaning, apply a conversion coating suited to the organic coating to be applied over it. Clean welds, mechanical connections, and abraded areas, and apply galvanizing repair paint specified below to comply with ASTM A 780.

1. Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in steel, complying with SSPC-Paint 20.
- B. Steel Surface Preparation: Clean surfaces to comply with SSPC-SP 1, "Solvent Cleaning"; remove dirt, oil, grease, or other contaminants that could impair paint bond. Remove mill scale and rust, if present, from uncoated steel; comply with SSPC-SP 3, "Power Tool Cleaning," or SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning."
- C. Factory Priming for Field-Painted Finish: Apply shop primer specified below immediately after surface preparation and pretreatment. Apply a smooth coat of even consistency to provide a uniform dry film thickness of not less than 0.7 mils.
  1. Shop Primer: Manufacturer's standard, fast-curing, lead- and chromate-free primer complying with ANSI A250.10 acceptance criteria; recommended by primer manufacturer for substrate; compatible with substrate and field-applied finish paint system indicated; and providing a sound foundation for field-applied topcoats despite prolonged exposure.

## 2.9 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 wide steel.
- C. Grout Guards: Formed from same material as frames, not less than 0.016 inch thick.

## 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 standard steel doors and frames.
  1. Examine roughing-in for embedded and built-in anchors to verify actual locations of standard steel frame connections before frame installation.
  2. For the record, prepare written report, endorsed by Installer, listing conditions detrimental to performance of work.
  3. Proceed with installation only after unsatisfactory conditions have been corrected.

### 3.2 PREPARATION

- A. Remove welded-in shipping spreaders installed at factory.
- B. Prior to installation and with installation spreaders in place, adjust and securely brace standard steel door frames for squareness, alignment, twist, and plumb to the following tolerances:
  1. Squareness: Plus or minus 1/16 inch, measured at door rabbet on a line 90 degrees from jamb perpendicular to frame head.
  2. Alignment: Plus or minus 1/16 inch, measured at jambs on a horizontal line parallel to plane of wall.
  3. Twist: Plus or minus 1/16 inch, measured at opposite face corners of jambs on parallel lines, and perpendicular to plane of wall.

4. Plumbness: Plus or minus 1/16 inch, measured at jambs on a perpendicular line from head to floor.
- C. Drill and tap doors and frames to receive non-templated mortised and surface-mounted door hardware.

### 3.3 INSTALLATION

- A. General: Provide doors and frames of sizes, thicknesses, and designs indicated. Install standard steel doors and frames plumb, rigid, properly aligned, and securely fastened in place; comply with Drawings and manufacturer's written instructions.
- B. Standard Steel Frames: Install standard steel frames for doors and other openings, of size and profile indicated. Comply with SDI 105.
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 due to 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 door silencers in frames before grouting.
    - d. Remove temporary braces necessary for installation only after frames have been properly set and secured.
    - e. Check plumb, squareness, and twist of frames as walls are constructed. Shim as necessary to comply with installation tolerances.
    - f. Apply bituminous coating to backs of frames that are filled with mortar, grout, and plaster containing antifreeze agents.
  2. Floor Anchors: Provide floor anchors for each jamb and mullion that extends to floor and secure with post installed expansion anchors.
    - a. Floor anchors may be set with powder-actuated fasteners instead of post installed 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 mortar as specified in Division 4 Section "Unit Masonry Assemblies."
  5. In-Place Gypsum Board Partitions: Secure frames in place with post installed expansion anchors through floor anchors at each jamb. Countersink anchors, and fill and make smooth, flush, and invisible on exposed faces.
  6. Installation Tolerances: Adjust standard steel door frames for squareness, alignment, twist, and plumb to the following tolerances:
    - a. Squareness: Plus or minus 1/16 inch, measured at door rabbet on a line 90 degrees from jamb perpendicular to frame head.
    - b. Alignment: Plus or minus 1/16 inch, measured at jambs on a horizontal line parallel to plane of wall.
    - c. Twist: Plus or minus 1/16 inch, measured at opposite face corners of jambs on parallel lines, and perpendicular to plane of wall.
    - d. Plumbness: Plus or minus 1/16 inch, measured at jambs at floor.

C. Standard Steel Doors: Fit hollow-metal doors accurately in frames, within clearances specified below. Shim as necessary.

1. Non-Fire-Rated Standard Steel Doors:

- a. Jamb and Head: 1/8 inch plus or minus 1/16 inch.
- b. Between Edges of Pairs of Doors: 1/8 inch plus or minus 1/16 inch.
- c. Between Bottom of Door and Top of Threshold: Maximum 3/8 inch.
- d. Between Bottom of Door and Top of Finish Floor (No Threshold): Maximum 3/4 inch.

2. Fire-Rated Doors: Install doors with clearances according to NFPA 80.

### 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 standard steel doors or frames that are warped, bowed, or otherwise unacceptable.
- B. Clean grout and other bonding material off standard steel doors and frames 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 primer.
- D. Galvanized Surfaces: Clean abraded areas and repair with galvanizing repair paint according to manufacturer's written instructions.

**END OF SECTION 081113**