

SECTION 081119 - STAINLESS STEEL DOOR 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. Stainless steel swinging doors and frames.
- B. Codes and References: Comply with the version year adopted by the Authority Having Jurisdiction.
 - 1. ANSI/SDI A250.8 - Recommended Specifications for Standard Steel Doors and Frames.
 - 2. ANSI/SDI A250.4 - Test Procedure and Acceptance Criteria for Physical Endurance for Steel Doors, Frames, Frames Anchors and Hardware Reinforcing.
 - 3. ANSI/SDI A250.6 - Recommended Practice for Hardware Reinforcing on Standard Steel Doors and Frames.
 - 4. ANSI/SDI A250.11 - Recommended Erection Instructions for Steel Frames.
 - 5. ASTM A167-99: Standard Specification for Stainless and Heat-Resisting Chromium-Nickel Steel Plate, Sheet, and Strip.
 - 6. ANSI/BHMA A156.115 - Hardware Preparation in Steel Doors and Frames.
 - 7. ANSI/SDI 122 - Installation and Troubleshooting Guide for Standard Steel Doors and Frames.
 - 8. ANSI/NFPA 80 - Standard for Fire Doors and Fire Windows; National Fire Protection Association.
 - 9. NFPA 252 - Standard Methods of Fire Tests of Door Assemblies; National Fire Protection Association.
 - 10. UL 10C (1998) - Positive Pressure Fire Tests of Door Assemblies; UL 1784 (2001) - Standard for Air Leakage Tests of Door Assemblies.

1.3 SUBMITTALS

- A. Product Data: For each type of product indicated. Include construction details, material descriptions, core descriptions, hardware reinforcements, profiles, anchors, fire-resistance rating, and finishes.
- B. Templates: Door hardware supplier is to furnish templates, template reference number and/or physical hardware to the steel door and frame supplier in order to prepare the doors and frames to receive the finish hardware items.
- C. 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 preparations for power, signal, and control systems.

D. Samples for Verification:

1. Samples are only required by request of the architect and for manufactures that are not current members of the Steel Door Institute.

1.4 QUALITY ASSURANCE

- A. Source Limitations: Obtain stainless steel doors and frames through one source from a single manufacturer wherever possible.
- 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, based on testing at positive pressure according to NFPA 252 (neutral pressure at 40" above sill) or UL 10C.
 1. Oversize Fire-Rated Door Assemblies Construction: 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: Where indicated and at vertical exit enclosures (stairwell openings) and exit passageways, 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. Label each individual glazed lite.
- D. Smoke-Control Door Assemblies: Comply with NFPA 105.
- E. Pre-Installation Conference: Conduct conference in compliance with requirements in Division 01 Section "Project Meetings" with attendance by representatives of Supplier, Installer, and Contractor to review proper methods and procedures for installing stainless steel doors and frames and to verify installation of electrical knockout boxes and conduit at frames with electrified or access control hardware.

1.5 DELIVERY, STORAGE, AND HANDLING

- A. Deliver stainless steel work 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 stainless steel 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. Door and frames to be stacked in a vertical upright position.

1.6 PROJECT CONDITIONS

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

1.7 COORDINATION

- A. Coordinate installation of anchorages for stainless steel 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.

1.8 WARRANTY

- A. Provide manufacturer's written warranty against defects in materials and workmanship upon final completion and acceptance of Work in this section.

PART 2 - PRODUCTS

2.1 MANUFACTURERS

- A. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
 - 1. CECO Door Products (C).
 - 2. Curries Company (CU).
 - 3. Security Metal Products (SM).
- B. Substitutions: Material from alternate stainless steel door and frame fabricators will not be accepted on jobsite without prior written and sample approval in accordance with requirements specified in Division 01.

2.2 MATERIALS

- A. General: Doors and frames shall be manufactured of commercial quality stainless steel complying with ASTM A167, Type 304 for standard applications and Type 316 for extremely corrosive environments.
- B. Frame Anchors: ASTM A 653/A 653M, Commercial Steel (CS), Commercial Steel (CS), Type B; with minimum G60 (Z180) or A60 (ZF180) metallic coating.
- C. Glazing: Comply with requirements in Division 08 Section, "Glazing."

2.3 STAINLESS STEEL DOORS

- A. General: Provide 1-3/4 inch doors of type and 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 polystyrene core.
 - a. Polystyrene Core: Manufacturer's standard polystyrene permanently bonded to both faces.

- b. Fire Door Core: As required to provide fire-protection and temperature-rise ratings indicated.
- 3. Level/Model: Level 3 and Physical Performance Level A (Extra Heavy Duty), Minimum 16 gage (0.053-inch - 1.3-mm) thick steel, Model 2 (Fully welded, seamless face and edges).
- 4. Vertical Edges: Vertical edges to have the face sheets joined by a continuous weld extending the full height of the door. Welds are to be ground, filled and dressed smooth. Beveled Edge, 1/8 inch in 2 inches (3 mm in 50 mm).
- 5. Top and Bottom Edges: Reinforce tops and bottoms of doors with a continuous steel channel not less than 16 gage (0.053-inch - 1.3-mm), extending the full width of the door and welded to the face sheet. Finish top and bottom to provide a smooth flush condition.
- 6. Surface Applied Hardware Reinforcements: Fabricate according to ANSI/SDI A250.6 with reinforcing plates from same material as door face sheets.

2.4 STAINLESS STEEL FRAMES

- A. General: Provide frames of the type and profile indicated, not less than thickness indicated; to comply with ANSI/SDI A250.8.
 - 1. Fabricate frames with mitered corners.
 - 2. Fabricate frames with "closed and tight" mitered, full depth continuously welded seams, finished smooth with no visible seam unless otherwise indicated. Knock down type frames are not permitted.
 - 3. Minimum 16 gage (0.053-inch -1.3-mm) thick steel sheet
- B. Fire rated frames: Fabricate frames in accordance with NFPA 80, listed and labeled by a qualified testing agency, for fire-protection ratings indicated.
- C. Surface Applied Hardware Reinforcements: Fabricate according to ANSI/SDI A250.6 Table 4 with reinforcement plates from same material as frames.

2.5 FRAME ANCHORS

- A. Jamb Anchors:
 - 1. Masonry Type: Adjustable strap-and-stirrup anchors to suit frame size, not less than 16 (0.8 mm) gage thickness, 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 and not less than 16 gage (0.8 mm) thickness.
- B. Floor Anchors: Floor anchors to be provided at each jamb. Formed from same material as frames, not less than 14 gage (0.067-inch -1.7-mm) thick.
- C. Mortar Guards: Provide minimum 26 gage mortar guards welded to the back of each hardware cutout.

2.6 FABRICATION

- A. General: Fabricate stainless steel 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. When shipping limitations so dictate, frames for large openings are to be fabricated in sections for splicing or splining in the field by others.

- B. Tolerances: Fabricate stainless steel work to tolerances indicated in ANSI/SDI A250.8.
- C. Stainless Steel Doors:
 - 1. Sanitary Water Tight Design Doors: Where indicated, provide optional sanitary design to completely seal door against water penetration.
 - 2. Glazed Lites: Factory cut openings in doors with applied flush trim kit to fit.
 - 3. Astragals: Provide overlapping astragals 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.
 - 4. Continuous Hinge Reinforcement: Provide welded continuous 12 gage strap for continuous hinges specified in hardware sets in Division 08 Section, "Door Hardware".
- D. Stainless 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: Full depth continuously weld frame seams; grind, fill, dress, and make smooth and flush.
 - a. Welded frames are to be provided with two steel spreaders temporarily attached to the bottom of both jambs to serve as a brace during shipping and handling. Spreader bars are for bracing only and are not to be used to size the frame opening.
 - 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. High Frequency Hinge Reinforcement: Provide 12 gage angle reinforcements for butt type hinges on every door and frame assembly.
 - 4. Continuous Hinge Reinforcement: Provide welded continuous 12 gage straps for continuous hinges specified in hardware sets in Division 08 Section, "Door Hardware".
 - 5. Electrical Knock Out Boxes: Factory weld 18 gage electrical knock out boxes to frame for electrical hardware preps; this includes but not limited to electric through wire transfer hardware, electrical raceways and wiring harnesses, door position switches, electric strikes, magnetic locks, and jamb mounted card readers as noted in door hardware sets in Division 08 Section, "Door Hardware".
 - a. Provide electrical knock out boxes as required for Project.
 - b. Conduit to be coordinated and installed in the field (Division 26) from middle hinge box and strike box to door position box.
 - c. Electrical knock out boxes to comply with NFPA requirements and fit electrical door hardware as specified in hardware sets in Division 08 Section, "Door Hardware".
 - d. Electrical knock out boxes for continuous hinges should be located in the center of the vertical dimension on the hinge jamb.
 - 6. Floor Anchors: Weld anchors to bottom of jambs and mullions with at least four spot welds per anchor.
 - 7. Jamb Anchors: Provide number and spacing of anchors as follows:
 - a. Masonry and Stud Wall Types: 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) Four anchors per jamb plus 1 additional anchor per jamb for each 24 inches (610 mm) or fraction thereof above 84 inches (2137 mm) high.

- E. Surface Hardware Preparation: Factory prepare stainless steel work to receive template 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 non-template, 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 stainless steel work for hardware.
 - 4. Coordinate locations of conduit and wiring boxes for electrical connections with Division 26 Sections.
- F. Stops and Moldings: Provide stops and moldings around glazed lites where indicated. Form corners of stops and moldings with butted or mitered hairline joints at fabricators shop.
 - 1. Single Glazed Lites: Provide fixed stops and moldings welded on secure side of stainless steel work.
 - 2. Multiple Glazed Lites: Provide fixed and removable stops and moldings so glazed lites are capable of being removed independently.
 - 3. Provide fixed frame moldings on outside of exterior and on secure side of interior doors and frames.

2.7 STAINLESS STEEL FINISHES

- A. Finish shall be one of the following:
 - 1. No. 4 - Brushed Satin Finish (general purpose with visible grain).
- B. Graining: Where required, graining to run in the vertical direction.

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. General Contractor to verify the accuracy of dimensions given to door and frame manufacturer for existing openings or existing frames (strike height, hinge spacing, hinge back set, etc.).
- C. 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 as required to make repaired area smooth, flush, and invisible on exposed faces.
- B. Prior to installation, adjust and securely brace welded stainless steel frames for squareness, alignment, twist, and plumbness.
- C. Tolerances shall comply with SDI-117 "Manufacturing Tolerances Standard Steel Doors and Frames."
- D. Drill and tap doors and frames to receive non-template, mortised, and surface-mounted door hardware.

3.3 INSTALLATION

- A. General: Install stainless steel work plumb, rigid, properly aligned, and securely fastened in place; comply with Drawings and manufacturer's written instructions.
- B. Stainless Steel Frames: Install stainless steel 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. Shim as necessary to comply with installation tolerances.
 - 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.
 - 2. Floor Anchors: Provide floor anchors for each jamb and mullion that extends to floor, and secure with post-installed expansion anchors.
 - 3. Masonry Walls: Coordinate installation of frames to allow for solidly filling space between frames and masonry with appropriate mortar.
 - 4. Grout Requirements: Do not grout head of frames unless reinforcing has been installed in head of frame. Do not grout vertical or horizontal closed mullion members.
- C. Stainless Steel Doors: Fit stainless steel 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 Finish Floor (No Threshold): Maximum 3/4 inch (19 mm).
 - 2. Fire-Rated Doors: Install doors with clearances according to NFPA 80.
- D. Glazing: Comply with installation requirements in Division 08 Section "Glazing" and with door manufacturer's written instructions.

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 stainless steel work that is warped, bowed, or otherwise unacceptable.
- B. Remove grout and other bonding material from stainless steel work immediately after installation.
- C. Remove stains and materials that will have and adverse affect on the doors and frames and restore slight blemishes in accordance with manufacturer's instructions to match original finish.

END OF SECTION 081119