

SUBJECT:**400 Series 1 3/4" Frame Specification****NO: F-1.0****DATE: 10/00****PAGE: 1**

SCOPE:

This bulletin covers specifications and features of Amweld's frames for 1 3/4" doors.

PURPOSE:

To provide a concise specification with details showing the frame construction and frame anchors.

DESCRIPTION:

The 1 3/4", 400 Series frames are available in the following depths in 1/8" increments and are applicable to virtually every type of wall construction. This is made possible by Amweld's frame anchoring system.

Double Rabbet (1 15/16" - 1 9/16") from 4 1/2" through 13 3/4"

Single Rabbet from 3" through 12 3/4"

Trimmed Opening from 3" through 12 3/4"

400 SERIES 1 3/4" FRAME SPECIFICATIONS

Contractor shall furnish and install steel frames as manufactured by Amweld Building Products, in all openings except as provided for in the specifications.

CONSTRUCTION - Frames shall be formed of 16 gage steel (14 gage optional). Frames shall be furnished as Amweld "Inter-Lok®" construction for field assembly. Headers to be equipped at each miter joint with 18 gage channel-shaped reinforcements. Headers and jambs shall have mating self-aligning slots and tabs for secure locking of the assembly. (Option: May be furnished as a complete one-piece welded assembly with header and jambs securely welded.) All corners shall present neat mitered joints. All stop heights are 5/8". All frame returns are 1/2" except the 5 3/4" which have 7/16". Three (3) steel snap-in anchors, for field insertion of wood stud, channel steel stud, or masonry, as specified, shall be provided with each jamb.

When specified, door frame members shall be manufactured of hot dip material in the .4 oz. (A40) or .6 oz. (A60) coating class conforming to ASTM A924 and A653 (formerly A525 and A526 respectively). The material shall be treated in the mill to insure superior prime paint adhesion.

Each jamb shall be equipped with one welded-in floor anchor as standard.

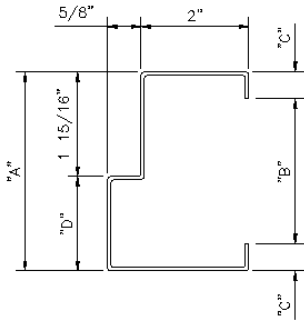
HARDWARE - Hinge jambs shall be mortised and reinforced with 10 gage steel to receive 1 1/2 pairs of 4 1/2" x 4 1/2" template hinges (2 pairs on frames over 7'6" in height). Hinge reinforcements shall be covered with a welded-in steel plaster guard. (Hinges not furnished.) Strike jambs shall be mortised and reinforced to receive an ANSI/DHI A115.1 strike (4 7/8" Universal) or optional 2 3/4" strike. Strike plate cutouts shall be covered with either an integral plaster guard as part of the reinforcement or with a welded-in steel plaster guard. Strike jambs shall be prepared to receive three (3) mutes and headers for double doors shall be prepared to receive two (2) mutes.

Communicating or contrastwing door frames are manufactured of 16 gage steel with 1 15/16" rabbets formed on both sides and prepared for strikes and hinges.

FINISH - Exposed surfaces on frames shall be cleaned, treated with a three (3) stage iron phosphate and given one shop coat of synthetic resin, rust-inhibitive alkyd enamel primer.

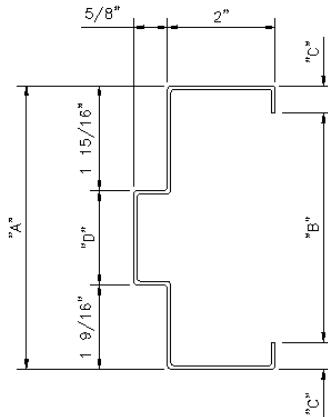
STANDARD FRAME SIZES

SINGLE FRAME WIDTHS	2'0" through 4'0"
DOUBLE FRAME WIDTHS	4'0", 4'8", 5'0", 5'4", 5'8", 6'0", 6'8", 7'0", 7'4", 7'8", & 8'0"
FRAME HEIGHTS	6'8", 7'0", 7'2", 7'10", 8'0", 8'1" to 10'0"



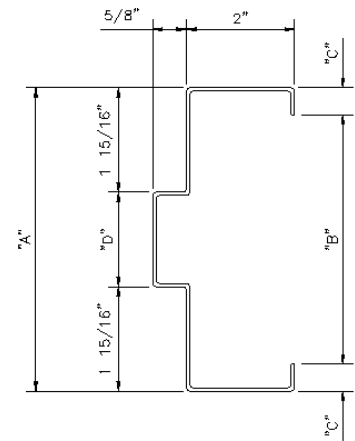
SINGLE RABBETED

A	B	C	D
3	2 1/8	7/16	1 1/16
3	1 3/4	5/8	1 1/16
3 3/4	2 3/4	1/2	1 13/16



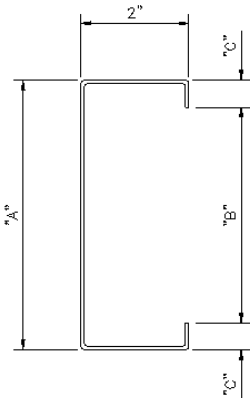
STANDARD DOUBLE RABBETED

A	B	C	D
5 3/4	4 7/8	7/16	2 1/4
ALL OTHERS	DEPTH - 1"	1/2	DEPTH - 3 7/8"



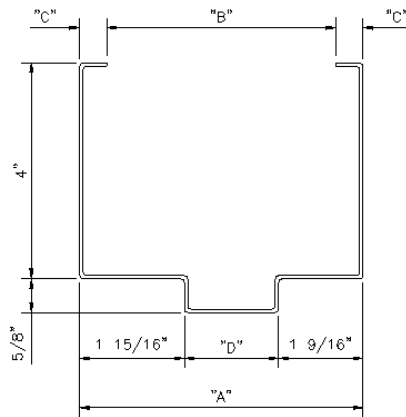
COMMUNICATING (2200 SERIES)

A	B	C	D
5 3/4	4 7/8	7/16	2 1/4
ALL OTHERS	DEPTH - 1"	1/2	DEPTH - 3 7/8"



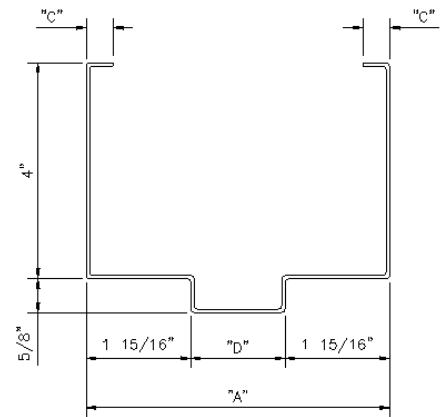
CASED OPENING

A	B	C
3	2 1/8	7/16
3	1 3/4	5/8
3 3/4	2 3/4	1/2
5 3/4	4 7/8	7/16
ALL OTHERS	DEPTH - 1"	1/2



4" FACE HEADER
STANDARD DOUBLE RABBETED

A	B	C	D
5 3/4	4 7/8	7/16	2 1/4
ALL OTHERS	DEPTH - 1"	1/2	DEPTH - 3 7/8"



4" FACE HEADER
COMMUNICATING (2200 SERIES)

A	B	C	D
5 3/4	4 7/8	7/16	2 1/4
ALL OTHERS	DEPTH - 1"	1/2	DEPTH - 3 7/8"

STANDARD SNAP-IN ANCHOR TYPES

WIRE MASONRY ANCHOR
3" THRU 8 3/4"
(STANDARD)
SPECIFY "M"



WOOD STUD ANCHOR
3 3/4", 4 3/4", 5 3/4", 6 1/4",
6 3/4", 7 3/4", 8 1/4", 8 3/4"
(STANDARD)
SPECIFY "S"



CHANNEL STEEL STUD ANCHOR
3 3/4", 4 3/4", 5 3/4"
(STANDARD)
SPECIFY "C"



ADJUSTABLE WOOD STUD ANCHOR
5 3/4", 6 1/4", 6 3/4", 7 1/4",
7 3/4", 8 1/4", 8 3/4"
(OPTIONAL)



FLOOR ANCHOR—WELDED
(STANDARD)



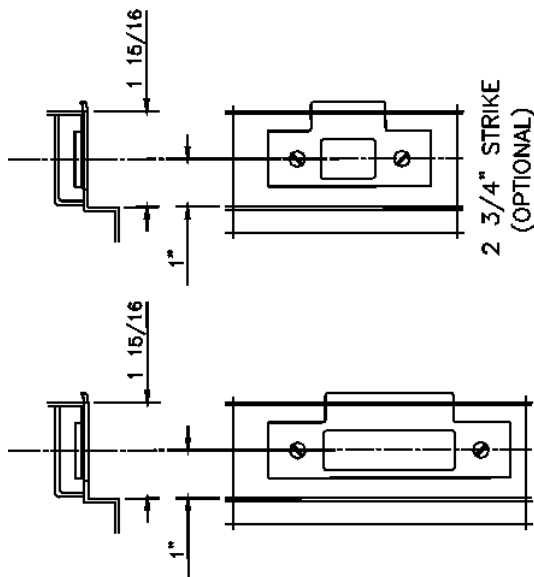
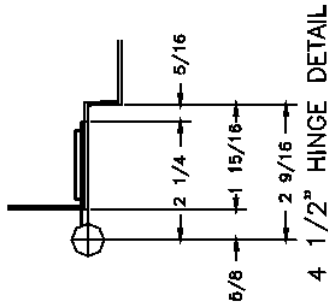
COMPLETED OPENING ANCHOR / LAG BOLT
5 3/4", 6 3/4"
SPECIFY "CO" FOR COMPLETED OPENING
SPECIFY "LAG" FOR LAG BOLT (OPTIONAL)



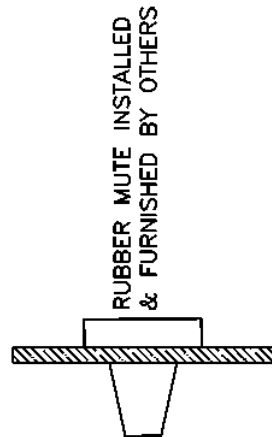
MASONRY ANCHOR
9 1/2" AND OVER
(OPTIONAL)
SPECIFY "M"



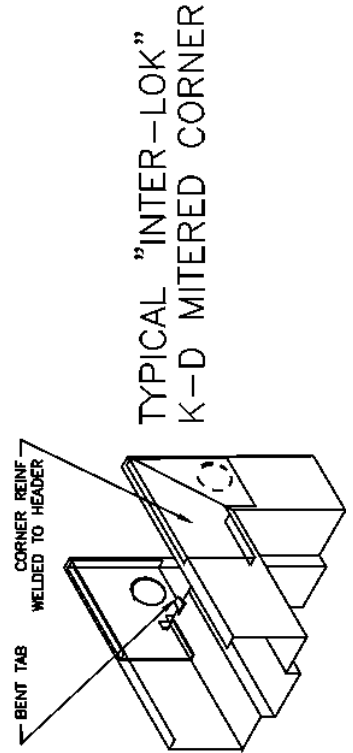
NOTE: ALL OTHER SIZES WILL REQUIRE A WELD-IN TYPE ANCHOR



ANSI/DHI A115.1
4 7/8" UNIVERSAL STRIKE



RUBBER MUTE INSTALLED & FURNISHED BY OTHERS



TYPICAL "INTER-LOK"
K-D MITERED CORNER