

---

---

**PART 1 GENERAL****1.1 RELATED DOCUMENTS**

- A. Drawings and general provisions of the Contract, including General Conditions and Division 1 Specification Sections, apply to this Section.

**1.2 SUMMARY**

- A. This Section includes hollow-metal work.
- B. Related Requirements:
  - 1. Division 1 Section "Sustainable Design Requirements".
  - 2. Division 8 Section "Stainless-Steel Doors and Frames" for hollow-metal doors and frames manufactured from stainless steel.
  - 3. Division 8 Section "Door Hardware" for door hardware for hollow-metal doors.

**1.3 DEFINITIONS**

- A. Minimum Thickness: Minimum thickness of base metal without coatings according to NAAMM-HMMA 803 or SDI A250.8.

**1.4 QUALITY ASSURANCE**

- A. The work of this section shall be performed by a company which specializes in the type of hollow metal doors and frames work required for this Project, with a minimum of 5 years of documented successful experience and shall be performed by skilled workmen thoroughly experienced in the necessary crafts.
  - 1. Work shall be performed in compliance with Owner's insurance underwriters' requirements and UL approvals and testing for materials, assemblies and procedures.
- B. Manufacturer shall specialize in manufacturing the type of hollow metal doors and frames specified in this section, with a minimum of 5 years of documented successful experience, and have the facilities capable of meeting all requirements of Contract Documents as a single-source responsibility and warranty.
- C. Manufacturer's identification tags or marks are not acceptable on surfaces which will remain exposed to view after installation.
  - 1. Evidence of "patching" after removal of tags or marks is not acceptable.

**1.5 SUBMITTALS**

- A. Submit the following according to Conditions of the Construction Contract and Division 1 Specification Sections.
- B. Product Data: For each type of product.
  - 1. Include construction details, material descriptions, core descriptions, fire-resistance ratings, temperature-rise ratings, and finishes.
- C. LEED Submittals:
  - 1. Product Data for Credit MR 4: 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.
  - 2. MRc5 – List all materials with regional content indicated the cost and percentage of each material or fraction of each material (by weight) that is extracted, harvested or recovered as well as manufactured within 500 miles of the project site – 101 First Street, San Francisco, CA.
- D. Shop Drawings: Include the following:
  - 1. Elevations of each door type.
  - 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.

- E. Samples for Verification:
1. For each type of exposed finish required, prepared on Samples of not less than 3 by 5 inches (75 by 127 mm).
  2. For "Doors" and "Frames" subparagraphs below, prepare Samples approximately 12 by 12 inches (305 by 305 mm) 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.
- F. Acoustical Door Certification: Submit letter of certification by the manufacturer that doors meet or exceed the sound transmission class specified based on test conducted at an independent testing agency in accordance with ASTM E90 and ASTM E413.
- G. 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 final Door Hardware Schedule.
- H. Hazardous Materials Notification: In the event no product or material is available that does not contain asbestos, PCB or other hazardous materials as determined by the Owner, a "Material Safety Data Sheet" (MSDS) equivalent to OSHA Form 20 shall be submitted for that proposed product or material prior to installation.
- I. Asbestos and PCB Certification: After completion of installation, but prior to Substantial Completion, Contractor shall certify in writing that products and materials installed, and processes used, do not contain asbestos or polychlorinated biphenyls (PCB), using format in using format in Article 3 of General Conditions.

#### 1.6 INFORMATIONAL SUBMITTALS

- A. Product Test Reports: For each type of hollow-metal door and frame assembly, for tests performed by a qualified testing agency.
- B. Oversize Construction Certification: For assemblies required to be fire rated and exceeding limitations of labeled assemblies.

#### 1.7 DELIVERY, STORAGE, AND HANDLING

- A. Comply with General Conditions and Division 1 Section "Product Requirements".
- B. Deliver hollow-metal work palletized, packaged, or crated to provide protection during transit and Project-site storage. Do not use nonvented plastic.
  1. Provide additional protection to prevent damage to factory-finished units.
- C. Deliver welded frames with two removable spreader bars across bottom of frames, tack welded to jambs and mullions.
- D. Store hollow-metal work vertically under cover at Project site with head up. Place on minimum 4-inch- (102-mm-) high wood blocking. Provide minimum 1/4-inch (6-mm) space between each stacked door to permit air circulation.

#### 1.8 COORDINATION

- A. Coordinate anchorage installation 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.

#### 1.9 WARRANTY

- A. Comply with General Conditions and Division 1 Section "Product Requirements".

#### 1.10 PREINSTALLATION MEETINGS

- A. Preinstallation Conference: Conduct conference at Project site.

**PART 2 PRODUCTS****2.1 UNAUTHORIZED MATERIALS**

- A. Materials and products required for work of this section shall not contain asbestos, polychlorinated biphenyls (PCB) or other hazardous materials identified by the Owner.

**2.2 ACCEPTABLE MANUFACTURERS**

- A. Products of the manufacturers specified in this section establish the minimum functional, aesthetic and quality standards required for work of this section.
- B. Manufacturers: Subject to compliance with requirements, provide products by one of the following:
1. Amweld International, LLC.
  2. Ceco Door Products; an Assa Abloy Group company.
  3. Curries Company; an Assa Abloy Group company.
  4. Steelcraft; an Ingersoll-Rand company.
- C. Source Limitations: Obtain hollow-metal work from single source from single manufacturer.
- D. Substitutions: Comply with General Conditions using form in Division 1 Section "Substitution Request Form".

**2.3 REGULATORY REQUIREMENTS**

- A. Fire-Rated Assemblies: Complying with NFPA 80 and listed and labeled by a qualified testing agency acceptable to authorities having jurisdiction for fire-protection ratings[ **and temperature-rise limits** ] indicated, based on testing at positive pressure according to NFPA 252 or UL 10C.
1. Smoke- and Draft-Control Assemblies: Provide an assembly with gaskets listed and labeled for smoke and draft control by a qualified testing agency acceptable to authorities having jurisdiction, based on testing according to UL 1784 and installed in compliance with NFPA 105.
- B. Fire-Rated, Borrowed-Light Assemblies: Complying with NFPA 80 and 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.

**2.4 INTERIOR DOORS AND FRAMES**

- A. Construct interior doors and frames to comply with the standards indicated for materials, fabrication, hardware locations, hardware reinforcement, tolerances, and clearances, and as specified.
- B. Commercial Doors and Frames: NAAMM-HMMA 861. At locations indicated in the Door and Frame Schedule.
1. Physical Performance: Level A according to SDI A250.4.
  2. Doors:
    - a. Type: As indicated in the Door and Frame Schedule.
    - b. Thickness: 1-3/4 inches (44.5 mm.)
    - c. Face: Uncoated, cold-rolled steel sheet, minimum thickness of 0.042 inch (1.0 mm).
    - d. Edge Construction: Continuously welded with no visible seam.
    - e. Core: Steel stiffened.
  3. Frames:
    - a. Materials: Uncoated steel sheet, minimum thickness of 0.053 inch (1.3 mm) for door openings 48 inches (1219 mm) or less, or window frames; minimum thickness of 0.067 inch (1.7 mm) for door openings greater than 48 inches (1219 mm).
    - b. Construction: Full profile welded.
  4. Exposed Finish: Prime.
- C. Acoustical Doors: Ceco's "MEDALLION" doors, Grade II - Heavy Duty, fabricated in accordance with SDI 100 specifications, tested in accordance with ASTM E90 and classified according to ASTM E413.
1. Face Sheets: 18 gauge cold-rolled carbon steel sheets of commercial quality complying with ASTM A366 and ASTM A568, flush design, seamless.
  2. Sound-Deadening Material: Fiberglass insulation full height of door placed between stiffeners.
  3. STC Rating: 38.
  4. Fire Ratings: As scheduled on drawings.
  5. Sizes: 1-3/4" thick and as scheduled on drawings.

**2.5 EXTERIOR HOLLOW-METAL DOORS AND FRAMES**

- A. Construct exterior doors and frames to comply with the standards indicated for materials, fabrication, hardware locations, hardware reinforcement, tolerances, and clearances, and as specified.
- B. Commercial Doors and Frames: NAAMM-HMMA 861. At locations indicated in the Door and Frame Schedule.
  - 1. Physical Performance: Level A according to SDI A250.4.
  - 2. Doors:
    - a. Type: As indicated in the Door and Frame Schedule.
    - b. Thickness: 1-3/4 inches (44.5 mm.)
    - c. Face: Metallic-coated steel sheet, minimum thickness of 0.053 inch (1.30 mm), with minimum G60 (Z180 or)A60 (ZF180) coating.
    - d. Edge Construction: Continuously welded with no visible seam.
    - e. Core: Steel stiffened.
      - 1) Thermal-Rated Doors: Provide doors fabricated with thermal-resistance value (R-value) of not less than 2.1 deg F x h x sq. ft./Btu (0.370 K x sq. m/W) when tested according to ASTM C1363.
  - 3. Frames:
    - a. Materials: Metallic-coated steel sheet, minimum thickness of 0.067 inch (1.7 mm), with minimum G60 (Z180 or)A60 (ZF180) coating.
    - b. Construction: Full profile welded.
  - 4. Exposed Finish: Prime.

**2.6 HOLLOW-METAL PANELS**

- A. Provide hollow-metal panels of same materials, construction, and finish as adjacent door assemblies.

**2.7 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 (51 mm) wide by 10 inches (254 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.
  - 3. Compression Type for Drywall Slip-on Frames: Adjustable compression anchors.
  - 4. Postinstalled Expansion Type for In-Place Concrete or Masonry: Minimum 3/8-inch- (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.
- B. Floor Anchors: Formed from same material as frames, minimum thickness of 0.042 inch (1.0 mm), 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 (51-mm) height adjustment. Terminate bottom of frames at finish floor surface.

**2.8 MATERIALS**

- A. Recycled Content: For materials containing post-industrial (pre-consumer) and/or post-consumer recycled content, contractor shall document the cost and percentage (by weight) of each material broken out by post-industrial (pre-consumer) and post-consumer content.
- B. Regional Content: For material that is extracted, harvested or recovered as well as manufactured within 500 miles of the project site – 100 Mission Street, San Francisco, CA 94103, contractor shall document the cost and percentage (by weight) of each material that is regional.
- C. Cold-Rolled Steel Sheet: ASTM A1008/A 1008M, Commercial Steel (CS), Type B; suitable for exposed applications.
- D. Hot-Rolled Steel Sheet: ASTM A1011/A 1011M, Commercial Steel (CS), Type B; free of scale, pitting, or surface defects; pickled and oiled.
- E. Metallic-Coated Steel Sheet: ASTM A653/A 653M, Commercial Steel (CS), Type B.

- F. Frame Anchors: ASTM A879/A 879M, Commercial Steel (CS), 04Z (12G) coating designation; mill phosphatized.
  - 1. For anchors built into exterior walls, steel sheet complying with ASTM A1008/A 1008M or ASTM A1011/A 1011M, hot-dip galvanized according to ASTM A153/A 153M, Class B.
- G. Inserts, Bolts, and Fasteners: Hot-dip galvanized according to ASTM A153/A 153M.
- H. Hinge Reinforcement Plate: 7 gauge minimum.
- I. Frames for Acoustical and Temperature Rise Doors: Provide high frequency hinge reinforcement.
- J. Power-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.
- K. Grout: ASTM C476, except with a maximum slump of 4 inches (102 mm), as measured according to ASTM C143/C 143M.
- L. Mineral-Fiber Insulation: ASTM C665, Type I (blankets without membrane facing); consisting of fibers manufactured from slag or rock wool; with maximum flame-spread and smoke-developed indexes of 25 and 50, respectively; passing ASTM E136 for combustion characteristics.
- M. Glazing: Comply with requirements in Section 08 80 00 "Glazing".
- N. Bituminous Coating: Cold-applied asphalt mastic, 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.

## 2.9 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 metal thickness. 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. Hollow-Metal Doors:
  - 1. Steel-Stiffened Door Cores: Provide minimum thickness 0.026 inch (0.66 mm), 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 weld to face sheets no more than 5 inches (127 mm) o.c. Fill spaces between stiffeners with glass- or mineral-fiber insulation.
  - 2. Fire Door Cores: As required to provide fire-protection and temperature-rise ratings indicated.
  - 3. Vertical Edges for Single-Acting Doors: Bevel edges 1/8 inch in 2 inches (3.2 mm in 51 mm).
  - 4. Top Edge Closures: Close top edges of doors with flush closures of same material as face sheets.
  - 5. Bottom Edge Closures: Close bottom edges of doors with end closures or channels of same material as face sheets.
  - 6. Exterior Doors: Provide weep-hole openings in bottoms of exterior doors to permit moisture to escape. Seal joints in top edges of doors against water penetration.
  - 7. 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 or as required to comply with published listing of qualified testing agency.
  - 8. Labels of independent testing agency approved by local authorities shall be of a color selected by Architect if labels will be visible if the door will be open in its typical condition.
- C. 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. 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.
  - 2. Provide countersunk, flat- or oval-head exposed screws and bolts for exposed fasteners unless otherwise indicated.
  - 3. Grout Guards: Weld guards to frame at back of hardware mortises in frames to be grouted.
  - 4. Floor Anchors: Weld anchors to bottoms of jambs with at least four spot welds per anchor; however, for slip-on drywall frames, provide anchor clips or countersunk holes at bottoms of jambs.
  - 5. Jamb Anchors: Provide number and spacing of anchors as follows:

- a. Masonry Type: Locate anchors not more than 16 inches (406 mm) from top and bottom of frame. Space anchors not more than 32 inches (813 mm) o.c., to match coursing, 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.
    - 4) Four anchors per jamb plus one additional anchor per jamb for each 24 inches (610 mm) or fraction thereof above 120 inches (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) Five anchors per jamb plus one additional anchor per jamb for each 24 inches (610 mm) or fraction thereof above 96 inches (2438 mm) high.
  - c. Compression Type: Not less than two anchors in each frame.
  - d. Postinstalled Expansion Type: Locate anchors not more than 6 inches (152 mm) from top and bottom of frame. Space anchors not more than 26 inches (660 mm) o.c.
6. Door Silencers: Except on weather-stripped frames, 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.
  - c. Frames to have factory installed silencers except do not provide silencers on fire-rated door and frame assemblies.
7. Labels of independent testing agency approved by local authorities shall be of a color selected by Architect if labels will be visible if the door will be open in its typical condition.
8. Terminated Stops: Terminate stops 6 inches (152 mm) above finish floor with a 90-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.
- D. Fabricate concealed stiffeners and edge channels from either cold- or hot-rolled steel sheet.
- E. Hardware Preparation: Factory prepare hollow-metal work to receive templated mortised hardware; include cutouts, reinforcement, mortising, drilling, and tapping according to SDI A250.6, the Door Hardware Schedule, and templates.
1. Reinforce doors and frames to receive nontemplated, mortised, and surface-mounted door hardware.
  2. Comply with applicable requirements in SDI A250.6 and BHMA A156.115 for preparation of hollow-metal work for hardware.
  3. Prepare frame for concealed magnetic door position switches as indicated on Security drawings.
- F. Stops and Moldings: Provide stops and moldings around glazed lites and louvers where indicated. Form corners of stops and moldings with 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 glazing and installation types indicated.
- ## 2.10 STEEL FINISHES
- A. Prime Finish: Clean, pretreat, and apply manufacturer's standard primer.
1. Shop Primer: Manufacturer's standard, fast-curing, lead- and chromate-free primer complying with SDI A250.10; recommended by primer manufacturer for substrate; compatible with substrate and field-applied coatings despite prolonged exposure.
- ## 2.11 ACCESSORIES
- A. Louvers: Provide louvers for interior doors, where indicated, which 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 or inverted-Y blades.
  2. Lightproof Louver: Stationary louvers constructed with baffles to prevent light from passing from one side to the other.

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 qualified testing and inspecting agency that established fire-resistance rating of door assembly.
- B. Mullions and Transom Bars: Join to adjacent members by welding or rigid mechanical anchors.
- C. Grout Guards: Formed from same material as frames, not less than 0.016 inch (0.4 mm) 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 the Work.
- B. Examine roughing-in for embedded and built-in anchors to verify actual locations before frame installation.
- C. 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. 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 SDI A250.11 or NAAMM-HMMA 840 as required by standards specified.
  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-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 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 plumb, square, 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 will be 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 power-actuated fasteners instead of postinstalled expansion anchors if so indicated and approved on Shop Drawings.
  3. Metal-Stud Partitions: Solidly pack mineral-fiber insulation inside 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 mineral-fiber insulation.
  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. At acoustical doors, solidly pack a 6 to 12 lb. density mineral wool insulation around frames in gypsum board partitions and solidly grout-fill the frames and eliminate voids in masonry partitions.

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. In-Place Metal or Wood-Stud Partitions: Secure slip-on drywall frames in place according to manufacturer's written instructions.
  10. 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 Steel Doors:
    - a. Between Door and Frame Jambs and Head: 1/8 inch (3.2 mm) plus or minus 1/32 inch (0.8 mm).
    - b. Between Edges of Pairs of Doors: 1/8 inch (3.2 mm) to 1/4 inch (6.3 mm) plus or minus 1/32 inch (0.8 mm).
    - c. At Bottom of Door with No Threshold: 5/8 inch (15.8 mm) plus or minus 1/32 inch (0.8 mm).
    - d. At Bottom of Door with Threshold: 3/8 inch (95 mm) maximum.
    - e. Between Door Face and Stop: 1/16 inch (1.6 mm) to 1/8 inch (3.2 mm) plus or minus 1/32 inch (0.8 mm).
  2. Fire-Rated Doors: Install doors with clearances according to NFPA 80.
  3. Smoke-Control Doors: Install doors and gaskets according to NFPA 105.
- D. Glazing: Comply with installation requirements in Section 08 80 00 "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 (51 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 Surface Touchup: Clean abraded areas and repair with galvanizing repair paint according to manufacturer's written instructions.
- E. Touchup Painting: Cleaning and touchup painting of abraded areas of paint are specified in painting Sections.

**END OF SECTION**