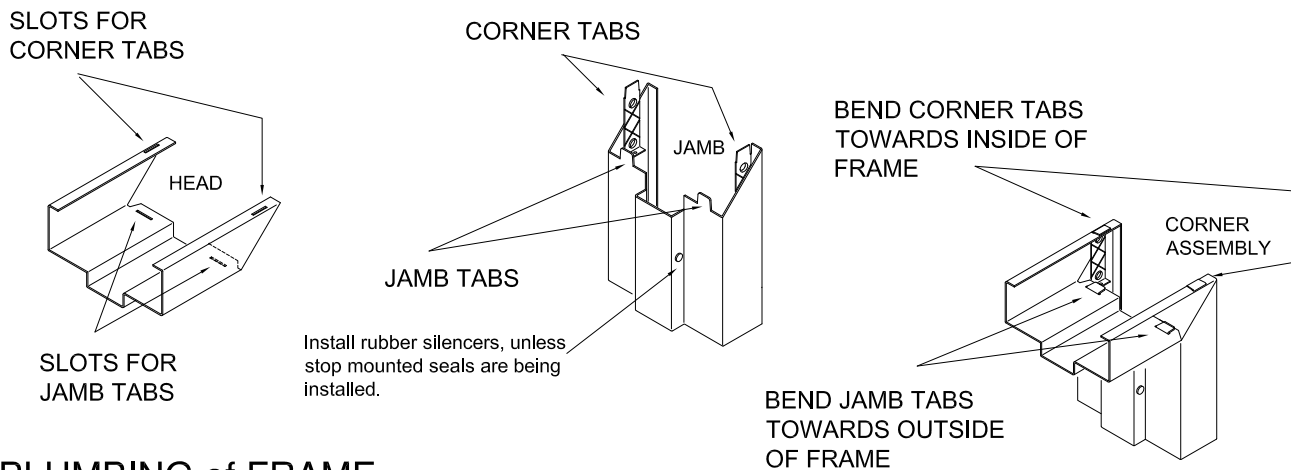


ASSA ABLOY FRAME INSTALLATION

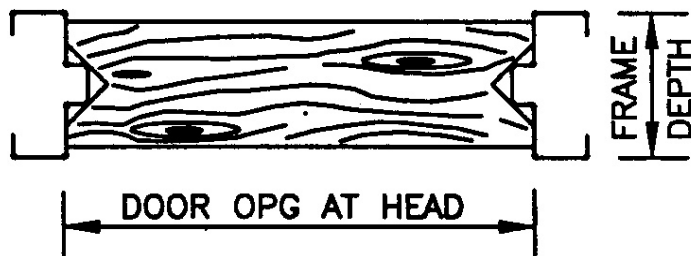
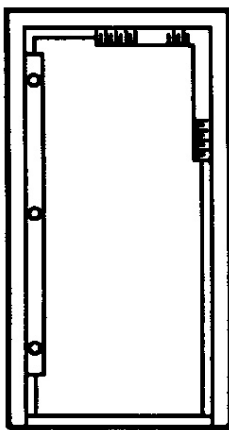
FOR FIRE RATED WELD TO BUILDING STRUCTURE

JOBSITE STORAGE: Store frames off the ground on at least 4" high wood runners or skids, in a manner that will prevent rust or damage. Do not store directly on the ground. Assembled frames shall be stored vertically. Cover frames with tarpaulin or plastic but do insure that adequate ventilation is provided to eliminate moisture condensation.

ASSEMBLY of KD (Knock Down) FRAME



PLUMBING of FRAME



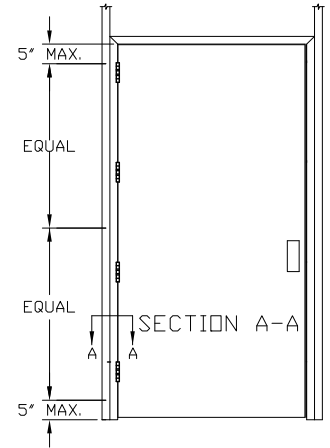
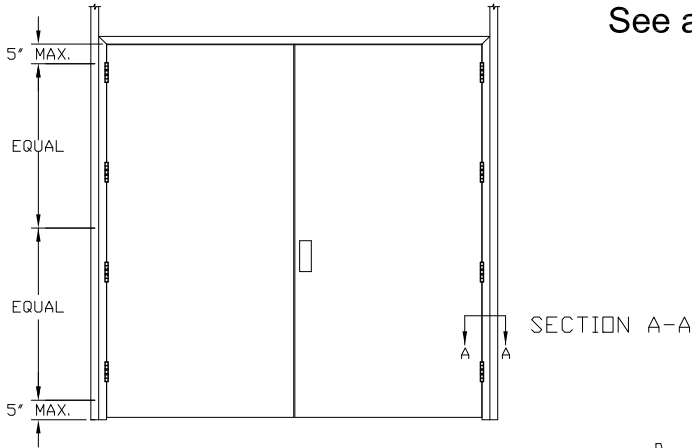
The installer should use wood spreaders (as described at right), a carpenter's level (the longer the better), and a carpenter's square (the bigger the better). Set the frame in the desired location. Level head and plumb jamps. Shim under jamps if necessary.

Typical wood spreaders must be square and made from lumber at least 1" thick. Length of spreader equals door opening width at the head. Cut clearance notches for frame stops as shown. Spreader must be nearly as wide as frame depth for proper installation.

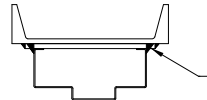
FRAME INSTALLATION

FIRE RATED WELD TO STEEL BUILDING STRUCTURE WELDING INSTRUCTIONS AND LOCATIONS

See all notes listed below

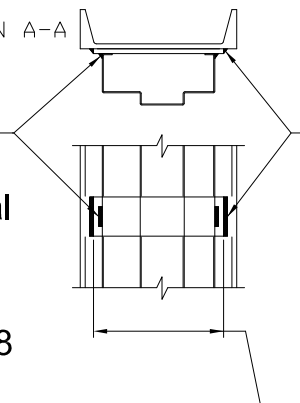


SECTION A-A



Fill gaps with intumescent caulk as required.

Weld hollow metal frame to building structure or optional shim with $\frac{3}{16}$ " weld, 1" long both sides of frame with E6018 electrodes.



Shim is minimum of $\frac{3}{4}$ " greater than frame depth.

Optional A36 steel shims ($\frac{1}{4}$ " max., $\frac{3}{16}$ " min. thick x 2" wide typical) welded to structural building member on both ends of shim with fillet welds measuring 2" long and sized to the same thickness as the shim using E6018 electrodes. Max. shim space $\frac{1}{4}$ " for one side of opening width. Max. rough opening is $\frac{3}{8}$ " larger than overall frame width.

NOTES:

- 1) All elevation anchor weld locations are to the centerline of welds.
- 2) This anchoring option applies to all frame profiles and frame series, three or four sided frames, transom, sidelite & window frames.
- 3) The anchor spacing will be the same for all frame heights.
- 4) Anchor option doesn't apply to slip-on drywall frames.
- 5) Mixing of anchor types on the same jamb or frame is not allowed. Both jambs must be welded to shims or building structure. Frame head is not required to be anchored or welded to building structure.
- 6) Four hinges are shown, but are not a requirement on all opening sizes.
- 7) Three or four sided frames with KD or welded corners are allowed.
- 8) Shims are provided by others.