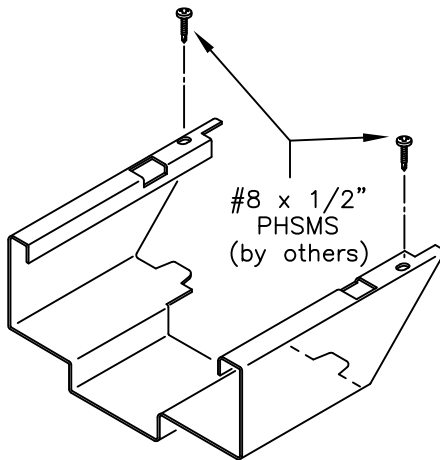


# ASSA ABLOY FRAME INSTALLATION

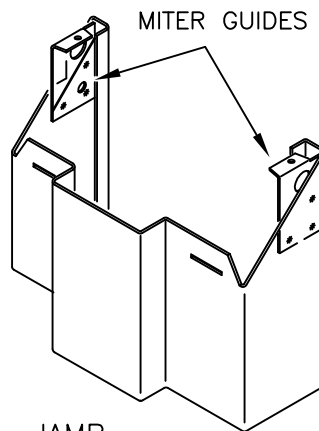
LABELED & NON-LABELED

SERIES B BEFORE the DRYWALL-FRAME  
(KD OR WELDED FRAMES ASSEMBLED AND  
ERECTED BEFORE WALL FRAMING)

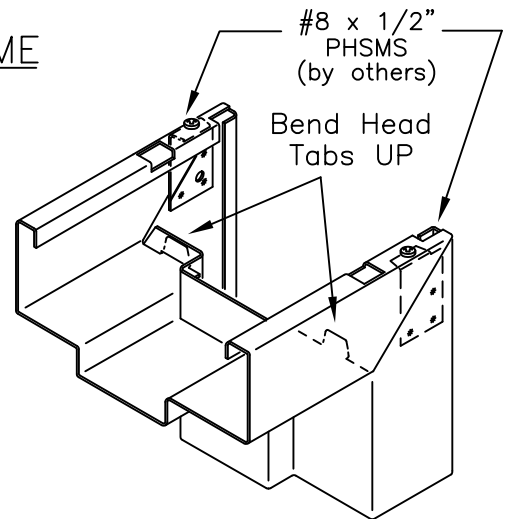


HEAD

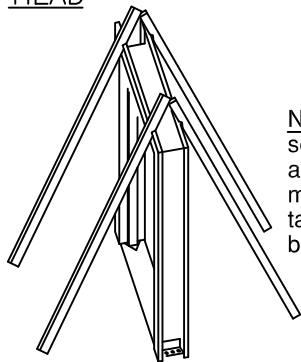
## ASSEMBLY OF KD FRAME



JAMB

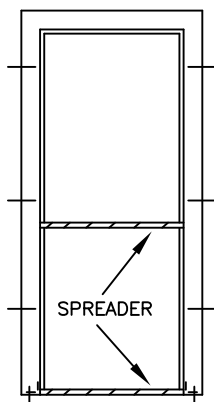


CORNER ASSEMBLY



BRACING THE  
FRAME

**NOTE:** If frame is received setup and welded, remove and discard the temporary metal supports that are tackwelded to jambs at sill before starting installation.



PLUMBING AND SQUARING  
THE FRAME

## INSTALLATION INSTRUCTIONS

- STEP 1** Assemble KD components (head and jambs) by slipping ends of head over miter guides attached to the top of jambs. Draw corner joint closed. Fasten head to jamb (through miter guides) with #8 x 1/2" PHSMS (4) places total (by others). BEND HEAD TABS UP AS SHOWN.
- STEP 2** If not already welded in place, install jamb anchors at hinge levels and directly opposite at strike jamb. Position anchors in throat of frame and tap in with a hammer.
- STEP 3** Erect and brace frame as shown. Plumb and square jambs, level head, and shim jambs as necessary. Set temporary wood spreaders at bottom and at mid-point to maintain a constant door opening width from head to sill. Wood spreaders must be square and at least 1" thick. Length of spreader equals door opening width at head. Spreader must be nearly as wide as frame depth. Install vertical brace to support head at openings over 4'-0" wide.
- STEP 4** Attach jambs to floor through floor anchors.
- STEP 5** Construct wall rough-opening by assembling wall framing members and butt tightly against frame anchors.
- STEP 6** Bend anchor tabs around wood stud and nail or screw tabs to stud using (4) fasteners per anchor --or-- fasten metal stud to anchor flange with (2) #6 x 3/8" (min) sheet metal or self tapping screws from the backside of studs. Check plumb and square of frame after attaching jamb anchors to studs. Install mutes in holes provided in the strike jambs, or head if double door opening.

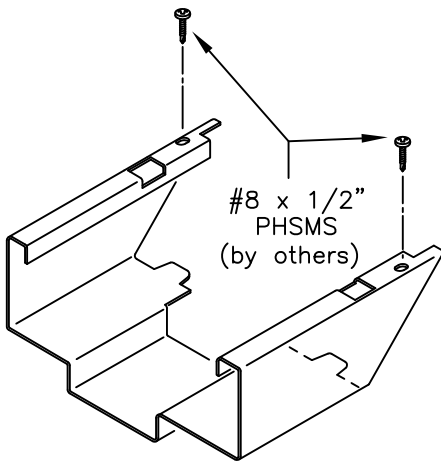
# FRAME INSTALLATION

LABELED & NON-LABELED

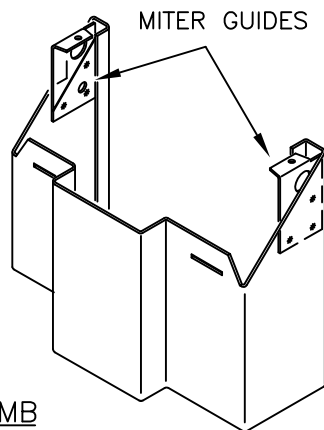
SERIES B BEFORE the DRYWALL-FRAME  
(KD OR WELDED FRAMES ASSEMBLED AND  
ERECTED AFTER WALL FRAMING)

ROUGH OPENING: ADD 1/8" TO OVERALL FRAME HEIGHT AND  
ADD 3/8" TO OVERALL FRAME WIDTH

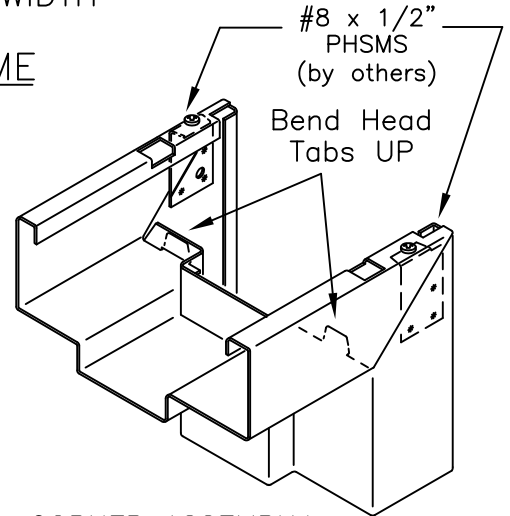
## ASSEMBLY OF KD FRAME



HEAD



JAMB

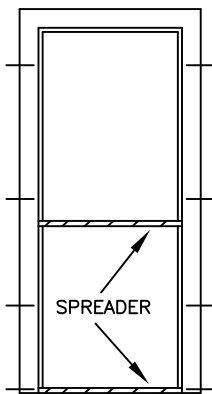


CORNER ASSEMBLY

**NOTE:** If frame is received setup and welded, remove and discard the temporary metal supports that are tackwelded to jambs at sill before starting installation.

## INSTALLATION INSTRUCTIONS

- STEP 1** Construct and size rough opening in wall framework as indicated above.
- STEP 2** Assemble KD components (head and jambs) by slipping ends of head over miter guides attached to the top of jambs. Draw corner joint closed. Fasten head to jamb (through miter guides) with #8 x 1/2" PHSMS (4 places total (by others)). BEND HEAD TABS UP AS SHOWN.
- STEP 3** If not already welded in place, install jamb anchors (including one at sill) at hinge levels and directly opposite at strike jamb. Position anchors in throat of frame and tap in with a hammer.
- STEP 4** Erect and center door frame in rough opening. Plumb and square jambs and level head. Shim jambs as necessary. Set temporary wood spreaders at sill and at mid-point to maintain constant door opening from head to sill. Wood spreaders must be square and at least 1" thick. Length of spreaders equals door opening width at head. Spreaders must be nearly as wide as frame depth. Install vertical brace to support head at openings over 4'-0" wide.
- STEP 5** Bend anchor tabs around wood stud and nail or screw tabs to stud using (4) fasteners per anchor --or-- fasten metal stud to anchor flange with (2) #6 x 3/8" (min) sheet metal or self tapping screws from the backside of studs. Check plumb and square of frame after attaching jamb anchors to studs. Install mutes in holes provided in the strike jambs, or head if double opening.



PLUMBING AND SQUARING  
THE FRAME