

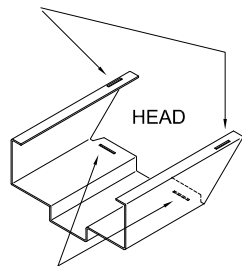
# ASSA ABLOY FRAME INSTALLATION

## 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.

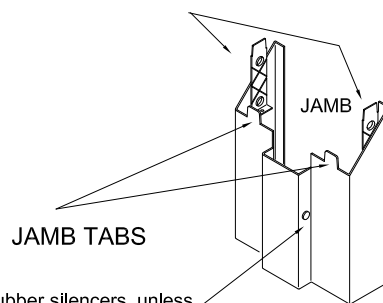
### ASSEMBLY of KD (Knock Down) FRAME

SLOTS FOR  
CORNER TABS



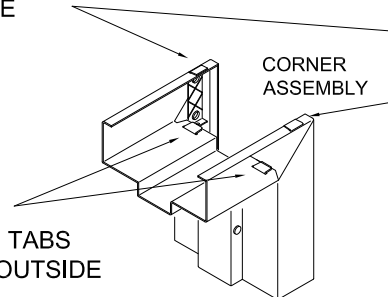
SLOTS FOR  
JAMB TABS

CORNER TABS



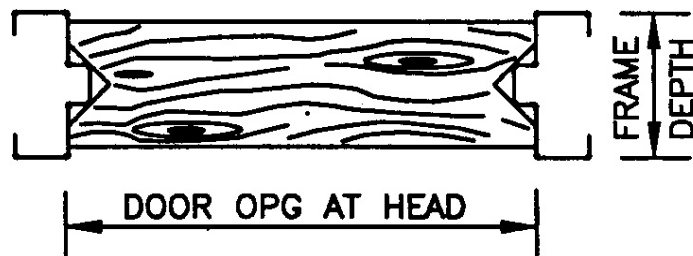
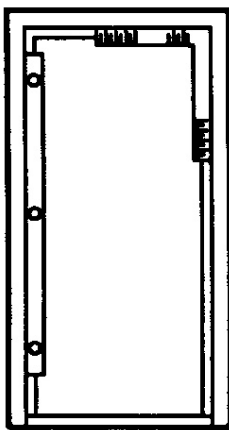
Install rubber silencers, unless  
stop mounted seals are being  
installed.

BEND CORNER TABS  
TOWARDS INSIDE OF  
FRAME



BEND JAMB TABS  
TOWARDS OUTSIDE  
OF FRAME

### PLUMBING of FRAME



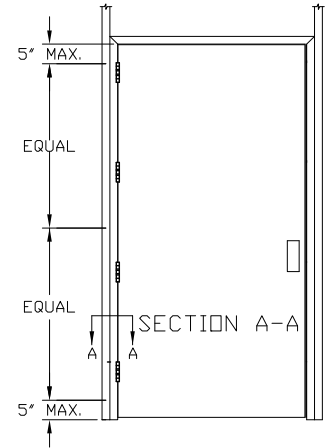
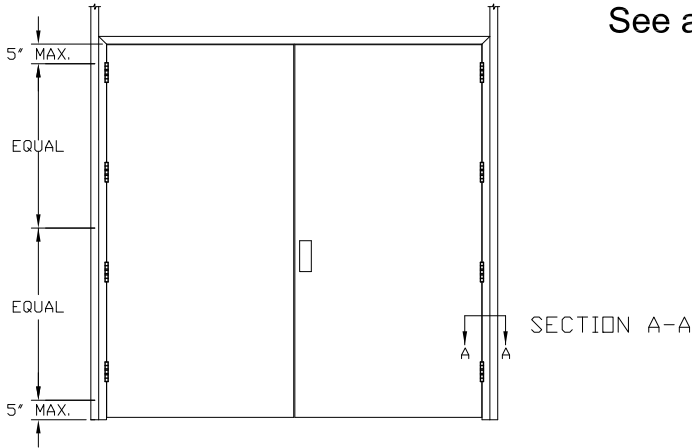
The installer should use wood spreaders (as described at right), a carpenter's level (the longer the better), and a carpenter's square (the bigger the better). Set the frame in the desired location. Level head and plumb jamba. Shim under jamba if necessary.

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.

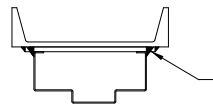
# FRAME INSTALLATION

## FIRE RATED WELD TO STEEL BUILDING STRUCTURE WELDING INSTRUCTIONS AND LOCATIONS

See all notes listed below

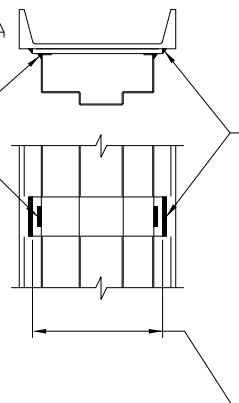


SECTION A-A



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.



Optional 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. Max. shim space  $\frac{1}{4}$ " for one side of opening width. Max. rough opening is  $\frac{3}{8}$ " larger than overall frame width.

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

### 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 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.