

**STAINLESS STEEL DOORS AND FRAMES
SECTION 081130**

PART I GENERAL

1.01 SUMMARY:

- A. Description: This section includes interior and exterior Stainless Steel Doors and Frames, related sidelites, transoms lites and Windows where applicable.
- B. Related work not included in this section:
 - 1. Finish Hardware including lock cylinders and Thresholds.
 - 2. Glass and glazing.
 - 3. Caulking between frames and masonry
 - 4. Structural members

1.02 QUALITY ASSURANCE:

- A. Applicable standards of the following as referenced herein:
 - 1. AAMA, American Architectural Manufacturers Association.
 - 2. ASTM, American Society for Testing and Materials.
 - 3. ADA, Americans with Disabilities Act.
 - 4. NAAMM/HMMA, National Association of Architectural Metals Manufacturers.
- B. Quality is based on the products manufactured by **StileLine™** a division of Stiles Custom Metal (www.StileLine.com)
- C. Manufacturer shall have been regularly engaged in manufacturing bronze doors and frames for a period of ten years. Door and frame shall be fabricated by a single manufacturer. The manufacturer must have an effective quality control system in place.
- C. Allowable Tolerances as stated in NAAMM/HMMA Technical Manual.

1.03 SUBMITTALS:

- A. Shop drawings: Indicate in elevation with sections and details to scale. Include glass and metal thicknesses, joining details, field connections, anchorage, concealed and exposed fastening methods, door and framing reinforcement, and metal finishes. Indicate compliance with specified design criteria.
- B. Finish samples: Submit two (minimum 5" x 7") samples indicating texture to be expected of finished work.
- C. Maintenance data: Give instructions for general maintenance and repair of surfaces and finishes.

1.04 WARRANTY: Warrant Stainless Steel Doors, Frame and Window assemblies against defect in materials and workmanship for three (3) years from date of shipment when handled, stored, and installed in accordance with manufactures instruction and NAAMM/HMMA Technical Manual. Adjustments made necessary by shifting or settling of building structure shall not be covered by warranty. Clear coat manufacturer's warranty applies.

PART II PRODUCTS

2.01 DOORS:

- A. Acceptable Stainless Steel Door products as manufactured by **StileLine™** a division of Stiles Custom Metal (www.StileLine.com)
- B. Stainless Steel Materials: (choose one) AISI Type [304], [316] or [430].
 - 1. Frames: (choose one) [0.060" 16 gauge] or [0.072" 14 gauge].
 - 2. Doors: (choose one) [0.060" 16 gauge] or [0.072" 14 gauge].
- C. Finish Texture: (Choose one) [#4 satin], [#8 polished], [non-directional], [angel-hair], [bead blasted], [random swirl] other finishes and embossing also available.
- D. Design of stile and rail profiles: As indicated on drawings. Door thickness (choose one) [1-3/4"] or [2"]. Code may stipulate bottom rail height.
- E. Door Construction: Doors shall be unitized construction with continuous forms reinforcement stiffening channels welded into door body. Hardware reinforcement: seven gauge at hinges, eleven gauge at lock/latch preparations welded into door body.

1. Stile and rail doors shall be blanked out from one sheet of metal. No welding shall be performed on door faces. Exposed seams on door faces or edges are not acceptable. Fabrication with bolt, screw or tie rod connections are not acceptable.
 2. Door edge construction (choose one) [Stiles replaceable Air-Tek integral weather-strip] [Hairline seam] [Continuous Welded Seamless]. Adhesive or screw applied weather strip shall not be accepted.
 3. Stainless Steel cladding over aluminum, steel or wood constructed shall not be accepted.
- F. Glass Lite Kits: (choose one)
- [Molding type lite kit with mitered corners welded, finished smooth and re-grained to match. Exterior side of door to be concealed welded. Interior side to include #8 oval head sheet metal screws].
 - [Internal channel type, flush glass moldings, securely welded to the inside face of the door skin. Removable glass channel stops shall be butted at corner joints, secured to the door with concealed, #8, sheet metal screws. Exposed fasteners shall not be accepted].

2.02 FRAMES:

- A. Construction:
1. Stainless Steel Materials: (choose one) AISI Type [304], [316] or [430].
 2. Stainless Steel thickness: (choose one) [0.060" 16 gauge] or [0.072" 14 gauge].
 3. Frames shall be welded units of the sizes and types shown on approved shop drawings. Knocked-down frames shall not be accepted. Jamb, header; mullion and sill profiles shall be in accordance with the frame schedule and as shown on the approved submittal drawings. All welds shall be finished smooth and regained to match.
 4. Windows shall be provided with fixed and removable stops. Loose stops shall be channel type with butted corners and attached with counter sunk, oval head, stainless steel, sheet metal screws.
- B. Fasteners shall be stainless steel. Exposed fasteners shall be countersunk and shall match entrances and framing in color.
- C. Exterior door frames shall have "Seal-Tek" integral weather-strip at vertical jambs and head. For details see www.StileLine.com

2.03 FINISH HARDWARE:

1. Doors and frames shall be mortised, reinforced, drilled and tapped at the factory for completely templated mortised hardware only, in accordance with the final approved hardware schedule and templates provided by the hardware supplier. Where surface mounted, anchor hinges, or non template, mortised hardware is to be applied, doors shall be reinforced, with all drilling and tapping done by others in the field. Reinforcement steel shall comply with NAAMM/HMMA 830 and 861.

PART III EXECUTION

3.01 CLEARANCES AND TOLERANCES shall be in compliance with NAAMM / HMMA standards.

3.02 SITE STORAGE AND PROTECTION OF MATERIALS

- A. Deliver and store materials to prevent damaging and marring finishes.
- B. Protection: Protect metal surfaces from contact with lime, mortar, cement, acids, and other harmful surfaces and from careless handling, storage or machining.

3.03 INSTALLATION:

- A. Framing systems shall be installed per **StileLine™** instructions and NAAMM / HMMA 840. Install frames without use of exposed fasteners, except where indicated on shop drawings.
- B. Door Installation: Install doors and hardware in accordance with manufacturer's product data. Adjust hardware for proper operation. Adjust door closers for smooth operation throughout swing.

3.04 CLEANING: Clean doors and frames in accordance with manufacturer's special instructions.

3.05 MAINTENANCE: Instruct the Owner's Maintenance Personnel regarding the operation and maintenance of these doors.

END OF SECTION