



# **AMPCO PRODUCTS, LLC**

## **TECHNICAL SPECIFICATIONS**

### **ALUMINUM ADJUSTABLE DOOR FRAMES SECTION 08100**

#### **PART I - GENERAL**

##### **A. Work Included**

1. Furnish all aluminum adjustable door frames as manufactured by Ampco Products, LLC., Miami, FL 33167

##### **B. Work Not Included**

1. Wood, hollow metal, tubular aluminum or other nonadjustable aluminum frames.
2. Finish hardware.

##### **C. Quality Assurance**

1. All frames shall be manufacture by a company having at least five years experience as an aluminum adjustable frame manufacturer.

##### **D. Submittals**

1. Provide a schedule of all aluminum adjustable frames for approval indicating size, mark, location, swing, construction, wall conditions, fire rating and hardware set.
2. Provide elevation and section details.
3. Provide manufacturer's standard finish selections.

##### **E. Handling**

1. Handle all frames with care in a manner to avoid damage to the product.

##### **F. Guarantee**

1. Guarantee all frames to be free from defects in materials and workmanship for the lifetime of the installation.
2. Repair or replace all defective frames.

#### **PART II - PRODUCTS**

##### **A. Design**

1. Frames shall be designed to be adjustable for wall thickness in 1" increments for walls from 2 ½" thru 10" thick.
2. Frames shall be designed to install into rough opening over finished walls.
3. Frames shall be designed to have all installation fasteners concealed upon final assembly.
4. Frames shall be designed to be removable and relocatable.

##### **B. Material**

1. Frames shall be manufactured from aluminum extrusions; 6063-T5 alloy. All exposed frame parts shall be pre-finished. Extrusions may vary in thickness except that structural portions shall be at least 3/16" thick at attachment of hinge screws. Typical wall thickness of door side shall be minimum .080". Typical wall thickness of adjuster trim side shall be minimum .062" casing or face shall be 1 -5/8".

### C. Finish

1. All frames shall be factory pre-finished in clear satin anodized (or in hardcoat Duranodic anodized, medium bronze color; in electrostatically applied baked enamel, medium bronze color, or for other colors contact factory.)

### D. Construction

1. Frames shall be assembled in two sections, door side (master section) and adjuster side (trim section), with snap-on type stop cover plates. Assembly of each section shall be with mitered corners attached with 14 gage galvanized steel corner gussets staked into position at the face, ribbed .57" aluminum drive fit corner keys at the rabbet and .062" riveted corner angles at the inside concealed legs.

2. Internal hardware reinforcement for hinges and lock strike shall be aluminum extrusions, mill finish, staked in position. Hinge and lock strike reinforcements shall be adjustable by a least 1/8". Head face shall be reinforced with 14 gage galvanized steel plate 18" long for closer arms where required. Head and jamb internal alignment parts shall be aluminum extrusions, mill finish, staked in position.

3. Hardware mortise lips extrusions shall be .134" high, notched at location of hinges, strikes and other mortise hardware. Rabbet shall be punched with slotted holes for adjustability of hinges and lock strikes.

4. Frame shall be provided with a black vinyl bulb gasket around the entire perimeter of the door opening, staked into position at concealed locations.

5. Door side and adjuster side shall be assembled at the factory forming a complete frame.

### E. Hardware Preparations

1. Frames shall be reinforced, drilled and tapped for hinges and lock strike. Reinforce only for surface mounted hardware. Holes for extension flush bolts shall be drilled in the field by installer after installation of doors and flush bolt.

2. Hardware items attaching to the snap-on stops caps must be attached thru clearance holes in the cap (field drilled by installer) with screws of sufficient length to attach directly to the back of the door section of the frames. Nonstandard screws may be required by finish hardware supplier or installer.

3. Frame is not designed for use with top/bottom pivot hinges or double acting doors.

### F. Wall Preparations

1. Provide rough openings in finished walls for installation of door frame. Rough opening sizes and details to be provided by the frame manufacturer.

2. Wall openings shall be provide with wood studs or minimum 16 gage steel studs at the jambs. Light gage steel studs may be used at the head.

3. Masonry walls shall be provided with a 2 x 4 or similar wood stud finished with gypsum wallboard both sides for attachment of the frame.

### G. Frame Installation

1. Install frames in strict accordance with manufacturer's installation instructions.

2. Manufacturer to provide all necessary installation materials for installation in wood or steel stud walls. Provide all screws and shims as required for a complete installation.

3. All installation materials are to be fully concealed upon completion of the installation.

#### H. Fire Rating

1. All frames shall be provided with fire rating of 20 minutes or 3/4 HR 'C' where listed on the door schedule. Attach labels from an approved testing laboratory for all frames that comply with the manufacturer's procedure and NFPA 80. Openings that do not comply fully with the requirements of an aluminum fire rated frame shall be listed on the shop drawing schedules and shall be furnished with a certification label attached.

#### I. Sidelites & Borrowed Lites

1. Attached sidelite and/or separate borrowed lite frames shall be of the same material and adjustable construction as the door frame. Mullions shall be provided where required. Provide glass stops.

### PART III - EXECUTION

#### A. Storage

1. Store frames in unopened cartons off the floor.

#### B. Installation & Inspection

1. Install frames into rough openings that comply with manufacturer's recommendations. If inspection reveals deficiencies in the opening, correct before installing frames.

2. Install frame in strict accordance with manufacturer's installation instructions.

3. Carpenter or furniture clamps shall be used to secure the frame return tight against the wall during installation.

#### C. Adjustments & Cleaning

1. Adjust frames to plump and square condition. Snap-on jamb stop cover plates are to be installed after all final adjustments have been made.

2. Adjust all fire labeled frames to tolerances required by NFPA 80, section 2-5.4.

3. Clean aluminum frames with a mild commercial cleaner or with mineral spirits. Dry wipe with a soft cloth to remove all cleaner.