

GENERAL: This document defines **SIGNUM Pressed Steel Door Frame specifications**. It includes proprietary design and performance specifications.

REFERENCES

IS 513: Cold Reduced Low Carbon Steel Sheet and Strip
IS 277: Galvanized Steel Sheets (Plain and Corrugated) - Specifications
IS 4351: Steel Door Frames - Specifications
IS 13871: Powder Coatings - Specification

MATERIALS

Steel sheets for frame sections and shutter skin shall conform to IS 277 with Z 120 coating and to IS 513 for its base physical and chemical properties. Frame Anchor fastener shall be of size M8 x 100 mm, with countersunk carbon steel screw for corrosion resistance

CONSTRUCTION

Steel frames shall have a single/double rebated profile as per Table 1 (below) constructed from minimum sheet thickness of 1.0 mm.

Frames shall be fabricated at factory pre-equipped with iron-mongery preparation and reinforcements. Frames shall be in knock down form with miter joints to be rigidly fixed together by mechanical means using self-tabs directly at site. Provision for anchor bolt fasteners on each vertical jamb for fixing to Wall/ RCC surface shall be made. Center to center distance between the anchor fasteners shall not be more than 600 mm. As the frame is transported in knock-down condition providing base ties is not required.

Table 1: Frame Profiles

Sl. No.	Profile	Rebate
Profile A	90 x 60 mm	Single
Profile B	105 x 60 mm	Single
Profile C/ D	125 x 60 mm	Single/ Double
Profile E	165 x 60 mm	Double
Profile F	100 x 57 mm	Single
Profile G/ H	143 x 57 mm	Single/ Double

MANUFACTURE

SIGNUM frames shall be manufactured to be rigid and free from defects such as warping and buckling. Clearances at jambs and heads shall not be more than 3 mm between the frame and shutter. Tolerance of ± 1 mm on all the profile dimensions shall be accepted.

FINISHES

Frame surface shall be suitably prepared and cleaned with solvents prior to coating. After pre-treatment, frames shall be finished powder coated at factory as per manufacturer available colour shade chart. The dry film thickness (DFT) for the powder coating shall be not less than 50 microns as per IS 13871.

IRON MONGERY PROVISIONS

Frames shall be provided with 3 mm thick hinge reinforcement plates welded inside the punched slot of the frame with M6 nuts pre-fixed to receive hinges for screw mounted fixing at site.

Concealed encasings or brackets using steel sheets of minimum 1 mm thickness shall be provided at all pre-punched cut-outs as reinforcement and with pre-drilled holes for iron mongery such as lock strike plates, concealed door closer tracks/ guide channels.

All cut-outs including hinge plates, lock strike plates shall have mortar guard covers from inside constructed using steel sheets of minimum 1 mm thickness to prevent grouting material, dirt, and dust ingress into cut-outs during installation.

QUALITY ASSURANCE



SIGNUM

Ref. PMF
Rev. 1.0, 1 April 2021

Steel Frames shall be manufactured by a unit certified for its quality systems as per ISO 9001: 2015 standards from a recognized certifying authority.

Steel door unit shall be designed and manufactured to comply with IS 4351 specifications.

Each frame unit shall have a label, to indicate identification number and date of manufacturing.

TESTING

Frames shall be type tested as per IS 4351 at BIS (Bureau of India Standards) certified laboratory. Type test reports shall be submitted for all projects with no further testing required, unless agreed to between the client and SIGNUM.

WARRANTY

SIGNUM warrants that for 18 months from the date of dispatch or 12 months from the date of installation, whichever is earlier, its manufactured products shall be free from defects in material, workmanship and construction and in accordance with the approved shop drawings submitted. Any items not manufactured by SIGNUM are only as warranted by the manufacturer of such items, otherwise all such items are sold on an AS IS basis. If examination by SIGNUM discloses that the product has been defective, provided the product was used as intended and appropriately maintained, then our obligation is limited to repair or replacement, at our option, of the defective parts or entire product, free of charge to the client. Manufacturer's warranty shall exclude losses caused by improper or insufficient maintenance, normal wear and tear, any improper operating, storage, handling, installation, modification after handing over of product to client. Manufacturer's liability for incidental, consequential, or damages, including commercial or other loss, resulting from any defective product, is strictly limited to repair and/ or replacement as stated above. Please refer website for detailed updated warranty policy. For details please feel free to contact us:

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TRANSPORTATION, UNLOADING AND STORAGE

Frames shall be wrapped with surface protection PE film to prevent damages to surface finish during transportation and at site. Labels shall be applied to each set as per project schedule for easy identification at site.

Additional protection such as side bolsters from card-board paper shall be used to protect during transit and at-site storage.

All frames shall be stacked flat in clean, dry, well-ventilated areas.

DISCLAIMER: All functionality, features, specifications and other product information provided in this document including, but not limited to design, components, performance, availability and capabilities of the product are subject to change without notice or obligation.

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