



GENERAL: This document defines **SIGNUM Steel Flush Door 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 16074: Steel Flush Door Shutters — Specification

IS 4351: Steel Door Frames - Specification

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.

Core shall be Honeycombed Kraft paper/ Mineral wool/ Steel stiffened hollow core as per requirements

Frame Anchor fastener shall be of size M8 x 100 mm, with countersunk carbon steel screw for corrosion resistance

Vision Panel (optional) shall be float glass or toughened glass as per requirements

CONSTRUCTION

Frame: Steel frames shall have a single rebated profile of 100 mm x 57 mm with bending radius of 1.4 mm constructed from sheet thickness of 1.0 mm. Other frame profiles as per IS 4351 shall also be manufactured as per client requirements. 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 assembled 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

Shutter: Steel shutters shall be minimum 30 mm (± 2 mm) thick, press formed, double skin type construction with folded interlocking seam joints at stile edges, with minimum sheet thickness of 0.8 mm

Shutters shall have no screwed, welded/ fuse-jointed or riveted joints on either face.

Shutters shall be provided with honeycombed kraft paper core/ mineral wool core to be bonded to the inner surfaces of the shutter using suitable permanent glue. Shutters shall be factory prepared with pre-punched cut-outs and reinforcements to receive iron mongery.

FABRICATION

Steel door units - frames and shutters shall be fabricated to be rigid and free from defects such as warping and buckling. Separate top and bottom channels (top channels shall be flush with top door edge and bottom channels shall be inverted) shall be welded to the shutter to act as reinforcement and to prevent ingress from external particles.

Flange for vision panel shall be square or rectangular in shape with a profile of 40 x 6 mm, with one side welded to the shutter face and the other side shall be clip-on type, with no visible screws on flange/ glass-beading.

Clearances at jambs and heads shall not be more than 3 mm between the frame and shutter. Floor level to shutter bottom clearance i.e. undercut shall not be more than 5 mm.

FINISHES

Frame and Shutter surfaces shall be suitably prepared and cleaned with solvents prior to coating. Frames and shutters shall be finished powder coated at factory as per approve RAL colour shades. The dry film thickness (DFT) for the powder coating shall be not less than 50 microns as per IS 13871.

Alternatively frames and shutters can be finished using anticorrosive zinc rich two component epoxy stoving primer (35 microns DFT) and top coat of two component polyurethane paint (35 microns DFT) of approved RAL colour shade for the project

IRON MONGERY PROVISIONS

Frames: Frames shall be provided with 3 mm thick hinge reinforcement plates with M6 nuts pre-fixed to receive hinges for screw mounted fixing at site.

Concealed encasings or brackets using steel plates 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 to prevent grouting material, dirt, and dust ingress into cut-outs during installation.



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Shutters: Shutters shall be provided with 3 mm thick hinge reinforcement plates with M6 nuts pre-fixed to receive hinges for screw mounted fixing.

Concealed encasings or brackets using steel plates shall be provided at all pre-punched cut-outs as reinforcement and with pre-drilled holes for iron mongery such as lock body, concealed door closer, flush bolts, drop down gaskets etc.

Reinforcement plates shall also be provided at necessary locations (as per approved drawings) to support surface mounted iron mongery items such as doors closers, all drops, pull handles.

QUALITY ASSURANCE

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

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

Steel door unit shall be GreenPro certified to be eco-friendly by CII-IGBC (Indian Green Building Council).

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. For details please feel free to contact us:

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TRANSPORTATION, UNLOADING AND STORAGE

Frames and shutters shall be covered with adhesive based PE sheets 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 knocked down frames shall be stacked flat and shutters flat/ vertically on top of card-board/ other bolsters 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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