

GENERAL: This document defines **SIGNUM 120 Minute Lead Lined Imber Fire Resistant Door specifications** which meet **IS 3614 and BS 476 Part 22** standards for Fire Resistance. The product conforms to **integrity criteria for 120 minutes and insulation criteria for 120 minutes (FD120 ID Fully Insulated Classification)** as mentioned in IS 3614/ BS 476 Part 22. It includes proprietary design and performance specifications.

MATERIALS

Timber used for frame and shutter shall be seasoned hardwood or other species as per requirements. Core shall be sandwich type multi layered non-combustible composite. Lead Sheet shall be of thickness 2.0 mm. Intumescent strip shall be Rigid PVC type of size 10 mm x 4 mm and 20 mm x 4 mm. Frame Anchor fastener shall be of size M8 x 100 mm, with galvanized countersunk carbon steel screw. Vision Panel (optional) shall be of necessary construction to achieve a fire rating of 120 minutes and high lead content as per standards.

CONSTRUCTION

Frame: Timber frames shall have a single rebated profile of 120 mm x 55 mm constructed from seasoned timber. Frames shall be treated with proprietary fire retardant chemical FRPT100 and seasoned till maximum moisture content is less than 15%. Grooves for intumescent strip of size 20 mm x 4 mm shall be provided on both vertical and horizontal jambs of the frame. Frames shall be factory-assembled with mitered joints ready for direct installation at site. Support strip shall be provided on bottom of frame between vertical jambs to prevent warping/ damage during transport or installation. 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: Timber shutters shall be 50 mm thick, fully flush double skinned, finished with PVC/ timber edge band on all four edges. Grooves for intumescent strip of size 10 mm x 4 mm shall be provided on all three edges of the shutter except bottom edge. Shutters shall have no visible screws or fasteners on either face. Shutters shall be constructed out of 43mm thick Composite Core Combination of 6mm Non Combustible Boards on Both Sides with Mineral Wool Insulation Infill, factory pressed with 3.5 mm commercial composite boards on both sides. Lead sheet of thickness 2.0 mm, un-pierced type, shall be provided inside the shutter covering full width of shutter, to provide protection from harmful radiation. Shutter shall be press finished with veneer or laminate on both faces and shall be provided with machined cut-outs for iron mongery such as lock body, concealed door closer, flush bolts, drop down gaskets etc. Reinforcement timber blocks 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. Beading for vision panel shall be square or rectangular in shape with an HDHMR angled profile of 30 x 30 mm, with both sides bonded to the shutter face. 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 19 mm.

FINISHES

Timber Frames shall be suitably prepared and a coat of anti-termite paint (black) applied to face in contact with walls. All other faces shall be polished and coated with melamine/ PU Clear or duly primed and finished with top coat of PU Paint to match laminate on shutter or machine-pressed with laminate to match shutter faces. **Shutter** surfaces shall be suitably prepared and finished with polish and coat of melamine/ PU Clear in case of veneers or primed with top coat of PU paint in case of ply or laminated and edges painted/edge banded to match laminate shade as per project requirement. Paint shade shall be of approved RAL colour shade for the project and wherever used, primer shall be 35 microns DFT and top coat of two component polyurethane paint also 35 microns DFT.

QUALITY ASSURANCE

Timber Fire rated doors shall be manufactured by a unit having valid BIS License and ISI Label/ Mark and certified for its quality systems as per ISO 9001: 2015 standards from a recognized certifying authority and to comply with IS 3614 specifications and shall have a fire rating label, to indicate fire resistance of door as well as door identification number and date of manufacturing. Timber door unit shall be GreenPro certified to be eco-friendly by CII-IGBC (Indian Green Building Council).

TESTING

Entire fire door assembly complete with iron mongery shall be type tested and certified for its fire rating by CBRI or CPRI. Type test reports shall be submitted for all projects with no further testing required, unless agreed to between the client and SIGNUM.

PACKAGING

Frames and shutters shall be covered with 3 mm foam sheets and wrapped with clear stretch film to prevent damages to surface finish during transportation and at site. Packaging 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 and shutters flat/ vertically on top of bolsters in clean, dry, well-ventilated areas.