

GENERAL: This document defines **SIGNUM Pressed Steel Door Frame specifications** which conform to **IS 4351**. It includes proprietary design and performance specifications.

MATERIALS

Galvanized Steel sheets for frame sections and shutter skin shall conform to IS 277 with zinc coating of 120 g/m² (total of both sides). Frame Anchor fastener shall be of size M8 x 100 mm, with countersunk galvanized carbon steel screw.

CONSTRUCTION

Signum Pressed 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. Reinforcements shall be as per IS 4351. 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 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	125 x 55 mm (Grooved)	Single
Profile G	150 x 55 mm (Grooved)	Double
Profile H	125 x 70 mm (Architrave)	Single
Profile J	150 x 70 mm (Architrave)	Double
Profile K	150 x 40 mm (Double swing)	-
Profile L	150 x 70 mm	Triple

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.

QUALITY ASSURANCE

Steel Frames 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. Steel frames 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.

PACKAGING

Frames shall be supplied in knock-down form and 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.