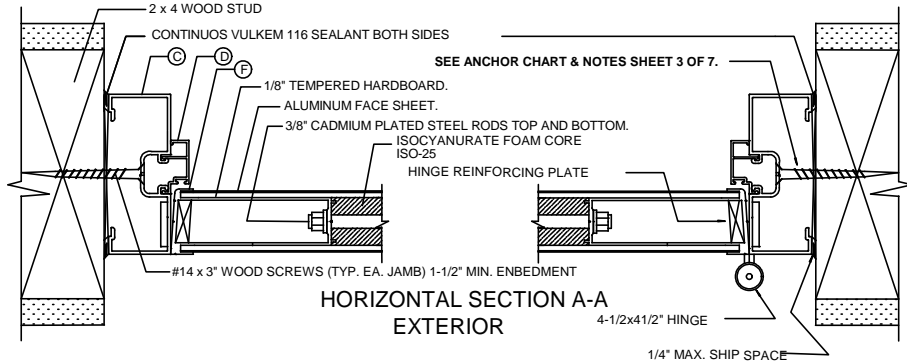
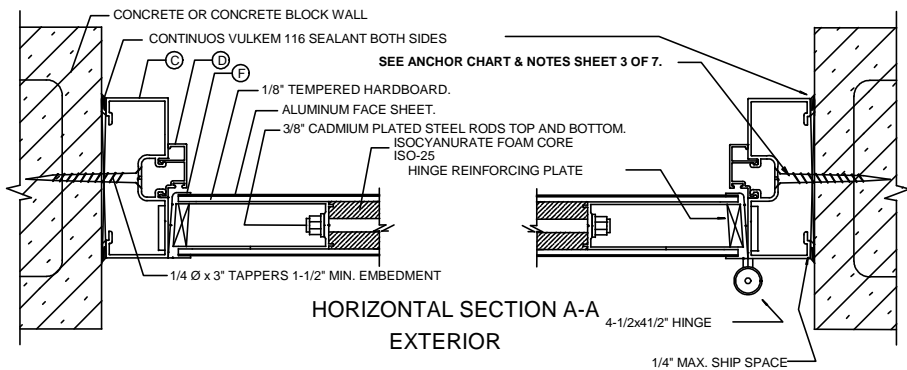


HORIZONTAL SECTION A-A  
EXTERIOR



HORIZONTAL SECTION A-A  
EXTERIOR



HORIZONTAL SECTION A-A  
EXTERIOR

**ALUMINUM FRAME:** ALUMINUM DOOR FRAMES SHALL BE SERIES FR450S 1-3/4" X 4-1/2" OPEN BACK WITH A SNAP ON DOOR STOP.

**MATERIAL:** FRAME MEMBERS SHALL BE MADE OF 6063 -T6 EXTRUDED ALUMINUM ALLOY WITH A MINIMUM WALL THICKNESS OF 0.090" FOR THE FR450S FRAME AND A MIN. YIELD STRENGTH OF 28,750 PSI. ALL SCREWS AND MISCELLANEOUS FASTENERS SHALL BE STAINLESS STEEL, OR OTHER CORROSION RESISTANT MATERIAL. WEATHERSTRIPPING SHALL BE COMPOUND SANTOPRENE BULB.

**CONSTRUCTION:** FRAME SHALL BE SQUARED CUT TO PROVIDE NEAT HAIRLINE JOINTS. JAMBS AND HEADER SHALL BE FASTENED WITH STAINLESS STEEL SCREWS. ALL FRAMES SHALL BE MORTISE FOR HINGES AND LOCK STRIKE PLATES. SUFACE MOUNTED HARDWARE SHALL BE DRILLED AND TAPPED IN THE FILED. HINGE, LOCK AND STRIKE REINFORCING PLATE SHALL BE MADE OF 1/4" ALUMINUM PLATE 6063-T6 ALLOY.

**INTSALLATION:** INSPECT WALL CONDITION, IF NECESSARY MAKE ANY WALL REPAIRS ORADJUSTMENTS BEFORE INSTALLATION OF DOOR FRAME. ASSEMBLE DOOR FRAME BY ATTACHING JAMBS TO HEADER USING (2) # 8 x 1 ON THE FR450S" FRAME (DO NOT FIL LED JAMBS OR HEADER WITH MORTAR). ERRECT HINGE JAMB TO WALL WITH 5 TAP - CONS PER JAMB. AFTER HINGE SIDE IS INSTALLED START WITH LOCK SIDED AND REPEAT THE SAME PROCEDURE.USE SHIMS AT HINGE AND LOCK SIDE TO PROPERLY LEVELED, SQUARED AND PLUMBED FRAME IF NECESSARY (MAXIMUN SHIM SPACE TO BE 1/4").

**HARDWARE:** EACH DOOR AND FRAME WITH (4) 12 -24 FLAT HEAD MACHINE SCREW. (1) YALE 5407 CYLINDRICAL LOCK 2 -3/4" BACKSET AND 2-1/8" BORE WITH A 4-7/8" STAINLESS STEEL STRIKE PLATE, (1) BUMPER THRESHOLD 1" HIGH. AND (1) DOOR SWEEP # DS - 10 OR EQUAL.

**PROTECTION & CLEANING:** AFTER ERECTION, THE GENERAL CONTRACTOR SHALL ADEQUATELY PROTECT EXPOSED PORTIONS OF ALUMINUM SURFACES FROM DAMAGE BY PLASTER, LIME, ACID, CEMENT, OR OTHER HARMFUL COMPOUNDS. AFTER INSTALLATION, ALL ALUMINUM SHALL BE CLEANED WITH SOAPY WATER OR OTHER MILD CLEANING SOLUTION.



ALUTECH CORPORATION  
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FAX: 305/591-8481

## FR450 FRAME

DATE:	DRAWN BY: A.P.
JOB No.:	SHEET No.:
DWG No.:	