



Leaders in aluminum office openings.

2018 Catalog

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Table of Contents

Section A: General Information		Section J: Installation Instructions	74
Company Profile	5	General Construction Information	75
LEED Information	5	Door Frame	76
Aluminum Frames	5	Full Height to Drywall Sidelight	78
Aluminum Swing Doors	6	Partial Height to Drywall Sidelight	79
Alumaglide® Sliding Door System	6	Full Height to Ceiling Grid Sidelight	80
Pocket Frame Profile	6	Partial Height to Ceiling Grid Sidelight	81
Warranty Information	7	Borrowed Light	82
		90 Minute Door Frame	84
Section B: Frame Material & Finishes	8	4 Sided Cased Opening	86
Material Availability List	9	3 Sided Cased Opening	87
Trim Variations	10	Pocket Frame	88
Standard Finishes	12	Alumaglide®	90
		Section K: Specifications & Fire Rating Information	91
Section C: Elevations	13	Specifications (Section 08 11 16)	92
		20 Minute Fire Rating Information	99
Section D: 300 Series Details	18	90 Minute Fire Rating Information	100
300 System w/ Recessed Pocket Glazing showing 302 (1") Reveal Trim	19		
300 System w/ Recessed Pocket Glazing showing 304-1 (1-1/2") Full Face Trim	24		
300 System w/ Recessed Pocket Glazing showing 304-2 (2") Full Face Trim Glass/Vinyl Information	29		
Section E: 400 Series Details	35		
Series 400 Variable Width Door Frame and Applied Stop Glazing	36		
400 System w/ Applied Stop Glazing showing 302 (1") Reveal Trim	36		
400 System w/ Applied Stop Glazing showing 304-1 (1-1/2") Full Face Trim	42		
400 System w/ Applied Stop Glazing showing 304-2 (2") Full Face Trim	48		
Section F: 90 Minute Aluminum Door Frame	54		
Section G: Pocket Frames	56		
Section H: Other Miscellaneous Information (Frames)	59		
Standard Hinge & Strike Locations	60/62		
Machine Detail Forms	61/63		
Rough Opening Information	64		
Other Information	65		
Section I: Aluminum Swing & Sliding Doors	66		
Alumaglide® Interior Trackless Sliding Door System	67		
Aluminum Swing Doors	71		
Bi-Pass Door Frame	72		

GENERAL INFORMATION

Company Profile

Founded in 1975 as a pioneer in aluminum interior products for commercial office openings, we have continued to enhance our industry leadership by innovation, growth and service.

Our corporate offices and main manufacturing facility are located in Southern California. For take-offs, shop drawings, product details, quotes and other services, we have a National Project Management Office in Oklahoma.

In 2013, we began manufacturing a line of swing doors as well as the Alumaglide® trackless sliding door system.

In 2017, we opened an additional manufacturing facility in Northern California, further enhancing our ability to meet your needs.

We pride ourselves on being large enough to handle any size job, yet small enough to take a personal interest in you and your business.

LEED Information

Western Integrated Materials aluminum products are made of the 6063 alloy, and finished either with anodic coating or water-based baked enamel. Our aluminum products are fully recyclable. All scrap that is accumulated during our manufacturing process is removed and recycled off-site.

Our production facilities are located in Long Beach, California and Santa Clara, California. These facilities are located within 500 miles of our extrusion suppliers. Additional information is available upon request.

Aluminum Frames

Our aluminum frames lead the way on quality, aesthetics and availability. We carry a wide range of throat sizes to meet your needs. We also provide a custom size option for non-standard wall sizes.

Western Integrated Materials Series 300 door frames are offered in a wide range of wall thicknesses, from 3-3/8" through 7-1/4".

When non-standard wall conditions are present, we offer the **Series 400** to match any throat size from 3-0/0" through 9-1/2". These frames are fabricated in our factory to the specifications provided in your order. The installation process and the exposed profile of the 400 Series are the same as the 300 Series.

Our **Series 300 and 400** door frames from 3" wall thickness and up, can be labeled with a 20 Minute Negative or Positive rated fire label and can be used where walls are required to be of one hour construction. (Some wall size restrictions apply - see page vii for details)

Our **Series 700** door frames can be used for any wall thickness from 3-3/4" to 8-3/8" and provide a 90 Minute Positive fire rating.

We provide standard anodized finishes in clear, bronze or black as well as custom anodized finishes. Baked-on enamel finishes are also available in white and black, and any custom color can be matched in our in-house paint shop.

All frames are factory mortised for hinges and strike plates, minimizing field error and labor. The frame is fastened along the outside edge with fasteners which are then covered with snap-on trim. The installation alleviates the problem of securing the frames through the face which, on occasion, allows the frame to twist on the wall.

Frames are shipped knock down complete with backup plates securely staked in place and include vinyl or mohair mute as needed. Thread-in vinyl is factory installed to save field labor. Frames are individually packaged and identified

Aluminum Swing Doors

Western Integrated Materials introduced a full line of 1-3/4" interior aluminum swing doors in 2014.

Narrow, medium, and wide stiles are available with a complete range of available hardware preps and can accommodate 1/4", 3/8", or 1/2" glass.

Heavy duty construction using 6063 T-6 aluminum alloy with welded joint corners ensures a strong quality product.

Our interior aluminum swing doors are ADA Title 24 compliant as well as LEED Certified - MR4.

Alumaglide® Sliding Door System

Our Alumaglide® sliding door system features a concealed bottom track and floor guide virtually eliminating sliding noise, while providing a dependable and aesthetically pleasing foundation.

The roller system is a durable and quiet. The head track is provided with a snap-on trim cover that allows quick and easy access to the roller system for door adjustment.

Our design allows for a cased opening and sidelight system with optional vertical mullions and horizontal muntins. This sliding door frame wraps the wall just like our standard framing system.

The sliding door for the Alumaglide® sliding system is available in narrow, medium, and wide stiles and can accommodate 1/4" or 3/8" glass.

Pocket Door Frame Profile

Our pocket door frame system is formed from slim, smooth-faced aluminum sections (except for the concealed galvanized steel pocket), giving an elegant, clean and graceful appearance to any office, reception area, conference room, or other interior setting.

To save on installation costs, the frame and pocket are shipped pre-assembled. Snap-on casing is applied after installation.

The snap-on casing can be easily removed to allow for installation or replacement of the door.

Warranty Information

Western Integrated Materials, Inc. expressly warrants all components manufactured by Western Integrated Materials, Inc. to be free of defects in material and workmanship subject to the following terms, conditions and limitations:

(a) The components must have been installed and maintained in strict accordance with all applicable safety codes, building standards and Western Integrated Materials, Inc. installation instructions and recommendations and be used under normal conditions and service.

(b) The warranty is for a term of two (2) years from date of substantial shipment providing that a written notification defining such defects is received by Western Integrated Materials, Inc. within that two (2) year period.

(c) Western Integrated Materials, Inc. only liability for breach of this expressed warranty is, at Western Integrated Materials, Inc. cost, to repair or replace such defective components.

(d) Western Integrated Materials, Inc. makes no other warranties or representations, either expressed or implied, concerning a product's fitness for a particular purpose. In no event will Western Integrated Materials, Inc. be liable for direct, indirect, special or consequential damages including but not limited to loss of profits or use.

(e) Items manufactured by others and supplied by Western Integrated Materials, Inc. carry the manufacturer's warranty only. In replacing defective items manufactured by others, Western Integrated Materials, Inc. will not assume charges for freight or labor.

(f) Materials used or installed cannot be returned for credit unless approved in writing, by Western Integrated Materials, Inc. or our agents.

MATERIALS AND FINISHES

Material Availability

300 series door frame material is available in the standard throat sizes as follows:

313 series -- 3-3/8" **	330 series -- 4-3/4" *	321 series -- 5-1/2" *
315 series -- 3-3/4"	318 series -- 4-7/8"	325 series -- 6-0/0" *
316 series -- 3-7/8" *	319 series -- 5-0/0"	327 series -- 7-1/4" ***
	320 series -- 5-1/4"	

300 series cased opening material is available in the throat sizes as follows:

313 series -- 3-3/8" **	315 series -- 3-3/4"	318 series -- 4-7/8"
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400 series door frame material (manufactured to size) is available in the throat sizes as follows:

400 series -- 3-0/0" to 5-15/16"	401 series -- 6-0/0" to 7-7/16"	402 series -- 7-1/2" to 9-1/2"
----------------------------------	---------------------------------	--------------------------------

400 series cased opening material (manufactured to size) is available in the throat sizes as follows:

404 series -- 3-0/0" to 5-15/16"	405 series -- 6-0/0" to 10-1/2"
----------------------------------	---------------------------------

700 series door frame material (90 minute fire rated) is available in the throat sizes as follows:

700 series -- 3-3/4" to 5-7/16"	701 series -- 5-1/2" to 8-3/8"
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300 series recessed pocket glazing material is available in the throat sizes as follows:

315 series -- 3-3/4"	319 series -- 5-0/0"	320 series -- 5-1/4"
316 series -- 3-7/8" *	219 series -- 5-0/0"	321 series -- 5-1/2" *
318 series -- 4-7/8"	(w/ pocket for 1/2" glass)	327 series -- 7-1/4" ***

Applied stop glazing material is available to be used with any 300 or 400 series door frame.

800 series pocket door frame material is available in the throat sizes as follows:

818 series -- 4-7/8"

300 series bi-pass door frame material is available in the throat sizes as follows:

318BP series -- 4-7/8" *

Alumaglide® sliding door frame is available in the throat sizes as follows:

318 series -- 4-7/8" *	319 series -- 5-0/0" *
------------------------	------------------------

1-3/4" Interior aluminum sliding and swing doors are available in the sizes as follows:

Narrow stile -- 2-0/0"	Medium stile -- 3-1/2"	Wide stile -- 5-0/0"
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(stiles available as beveled, squared, radius, or w/mohair)

Swing doors available in clear, bronze, black anodized and painted. Sliding doors available in clear anodized and painted.

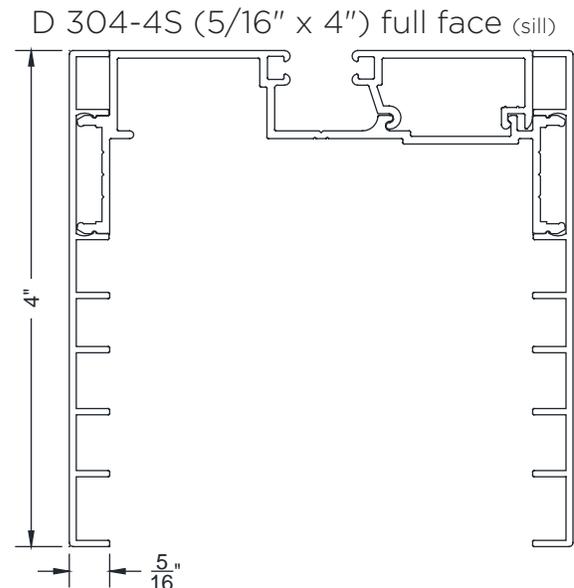
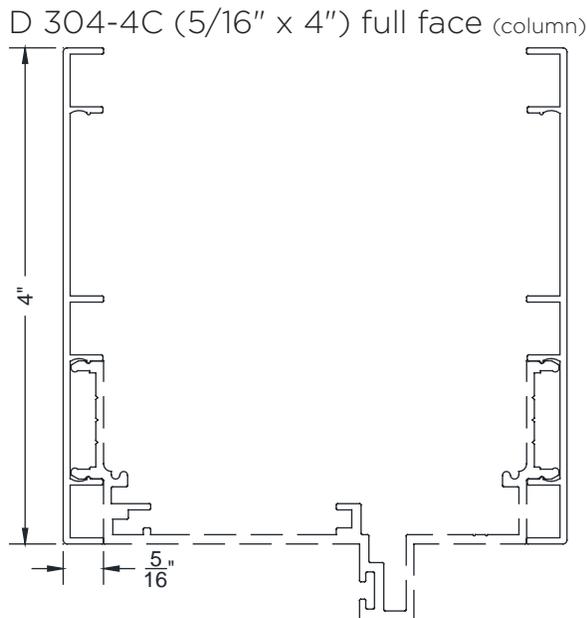
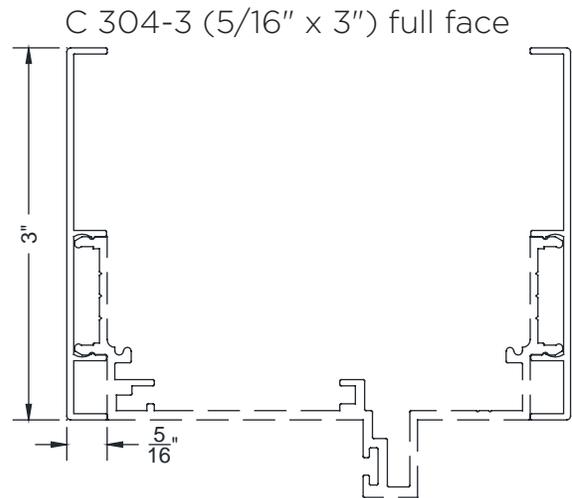
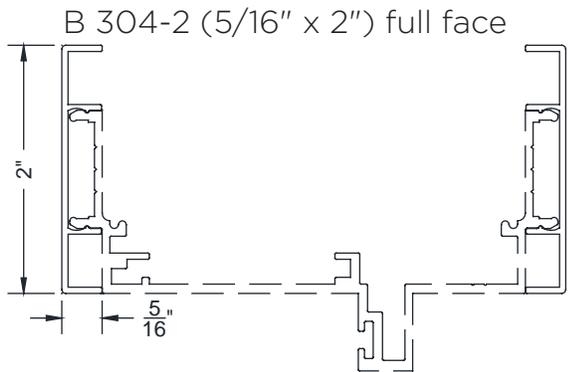
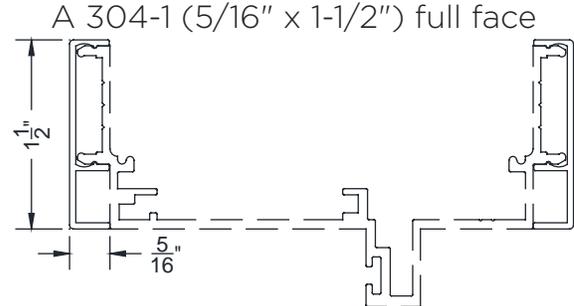
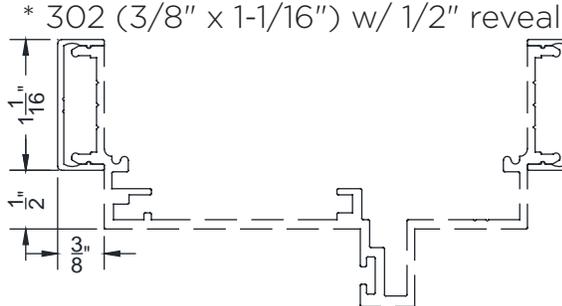
Top & Bottom Rails: 2-1/8", 3-1/2", 5-0/0", 6-1/2", & 9-1/2" (add 1/2" for glass stop for overall profile)

* Stocked in Clear Anodized only ** Stocked in Clear and Bronze Anodized only

*** Stocked in Clear and Black Anodized only

Snap on Trim Casing Availability

	302 (3/8" x 1-1/16") w/ 1/2" reveal	F	305 (5/16" x 1-1/2") w/ 1/2" reveal
A	304-1 (5/16" x 1-1/2") full face	G	303 (5/8" x 1-1/4") w/ 3/8" reveal
B	304-2 (5/16" x 2") full face	H	306 (3/8" x 1-7/16") w/ 1/4" reveal *
C	304-3 (5/16" x 3") full face	J	302-375 (3/8" x 1-1/4") w/ 3/8" reveal *
DC	304-4C (5/16" x 4") full face for column	K	307 (5/16" x 1-1/4") w/ 1/4" reveal
DS	304-4S (5/16" x 4") full face for sill		

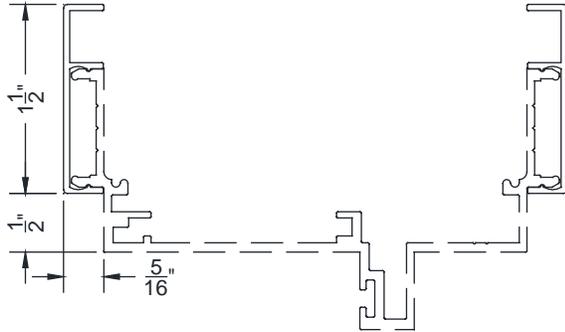


Snap on Trim Casing Availability

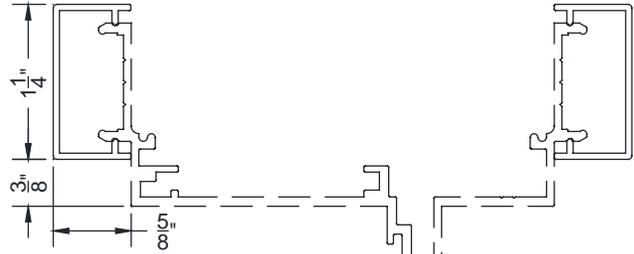
302 (3/8" x 1-1/16") w/ 1/2" reveal
 A 304-1 (5/16" x 1-1/2") full face
 B 304-2 (5/16" x 2") full face
 C 304-3 (5/16" x 3") full face
 DC 304-4C (5/16" x 4") full face for column
 DS 304-4S (5/16" x 4") full face for sill

F 305 (5/16" x 1-1/2") w/ 1/2" reveal
 G 303 (5/8" x 1-1/4") w/ 3/8" reveal
 H 306 (3/8" x 1-7/16") w/ 1/4" reveal *
 J 302-375 (3/8" x 1-1/4") w/ 3/8" reveal *
 K 307 (5/16" x 1-1/4") w/ 1/4" reveal

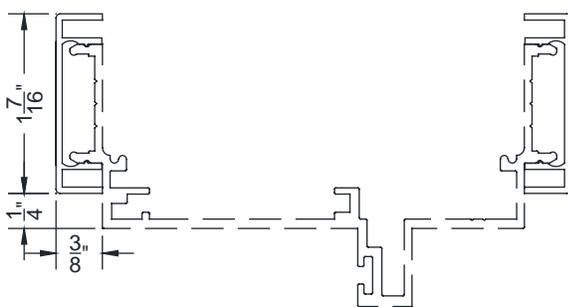
F 305 (5/16" x 1-1/2") w/ 1/2" reveal



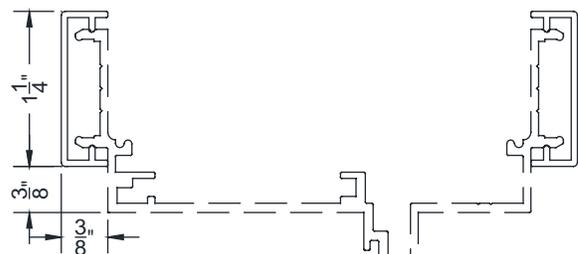
G 303 (5/8" x 1-1/4") w/ 3/8" reveal



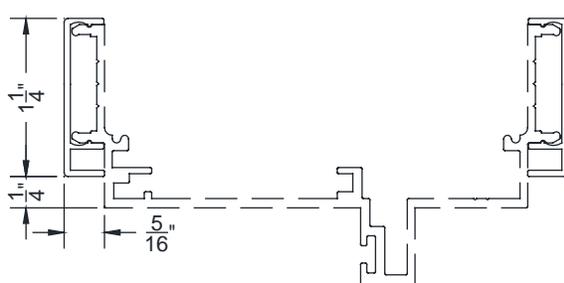
H 306 (3/8" x 1-7/16") w/ 1/4" reveal



J 302-375 (3/8" x 1-1/4") w/ 3/8" reveal



K 307 (5/16" x 1-1/4") w/ 1/4" reveal



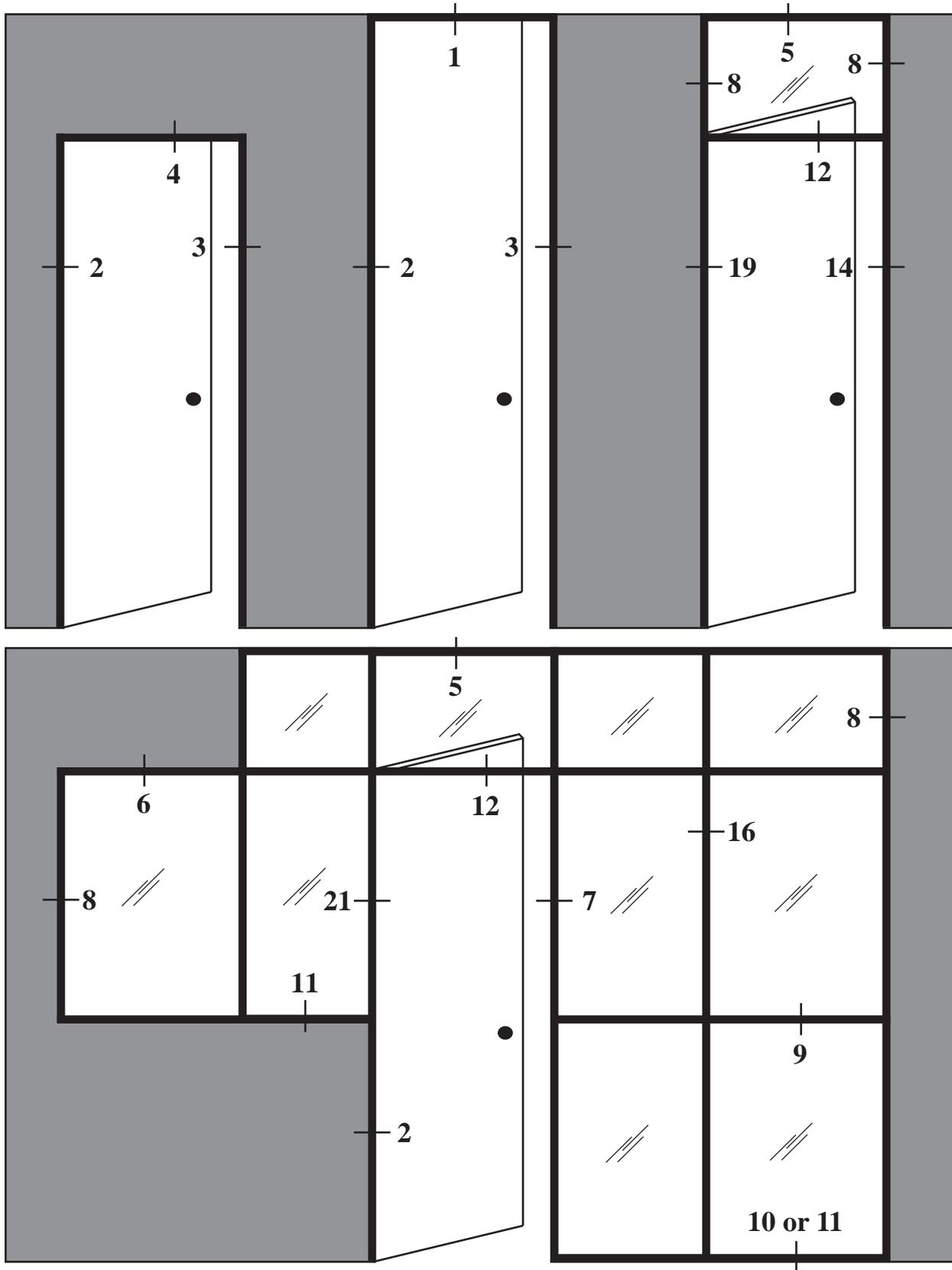
- * Stocked in Clear Anodized only
- ** Stocked in Clear and Bronze Anodized only
- *** Stocked in Clear and Black Anodized only

Standard Finishes

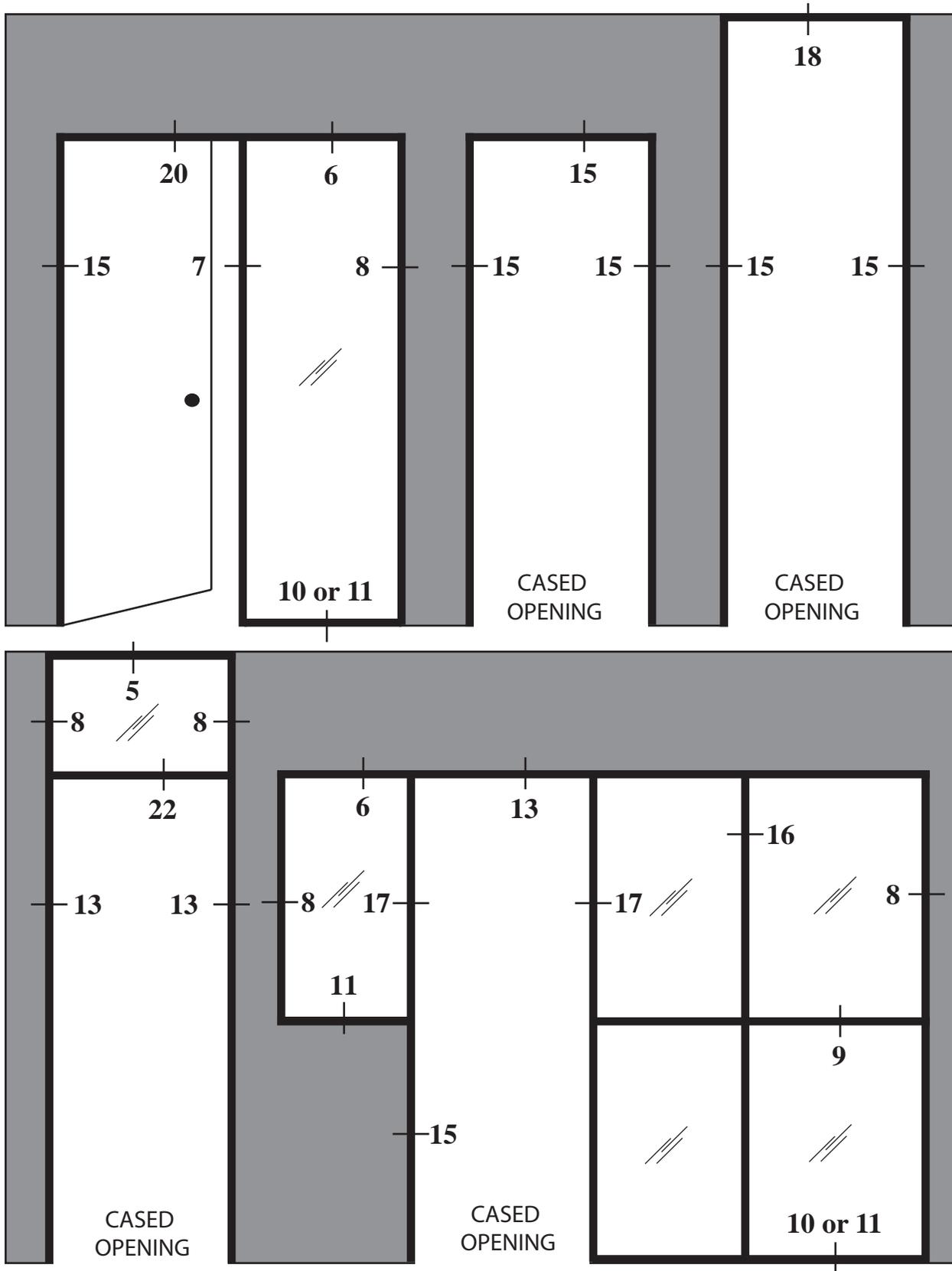
Finish Number	Description	Aluminum Association Finish Designation
1	Commercial Clear Anodize	AA-M12-C22-A21
2	Commercial Grade A.A.M.A. Manual 603.5	Paint Specification
4	Class II Dark Bronze Anodize	AA-M12-C22-A34
8	Class II Black Anodize	AA-M12-C22-A34

ELEVATIONS

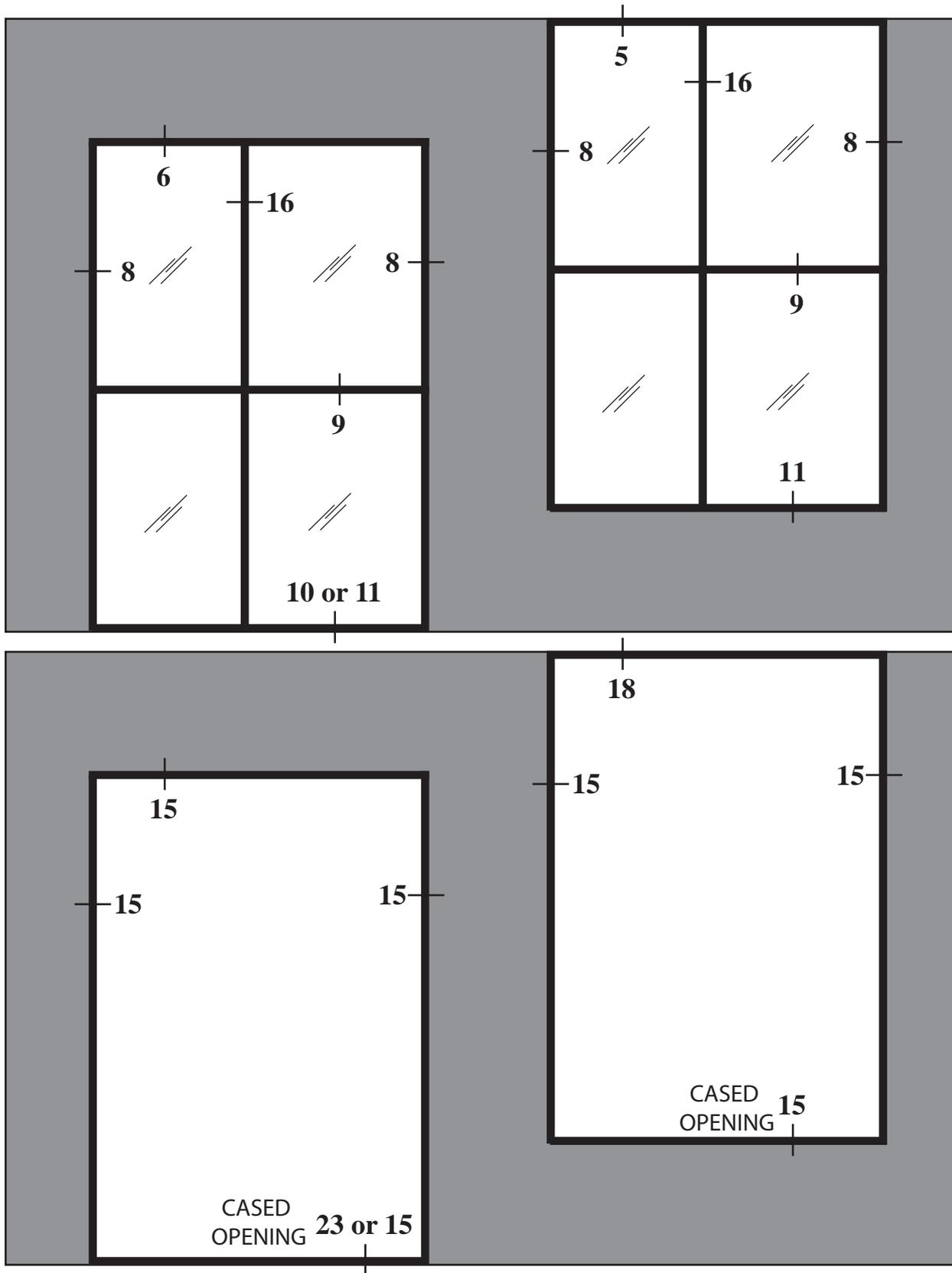
Elevations with Detail Numbers



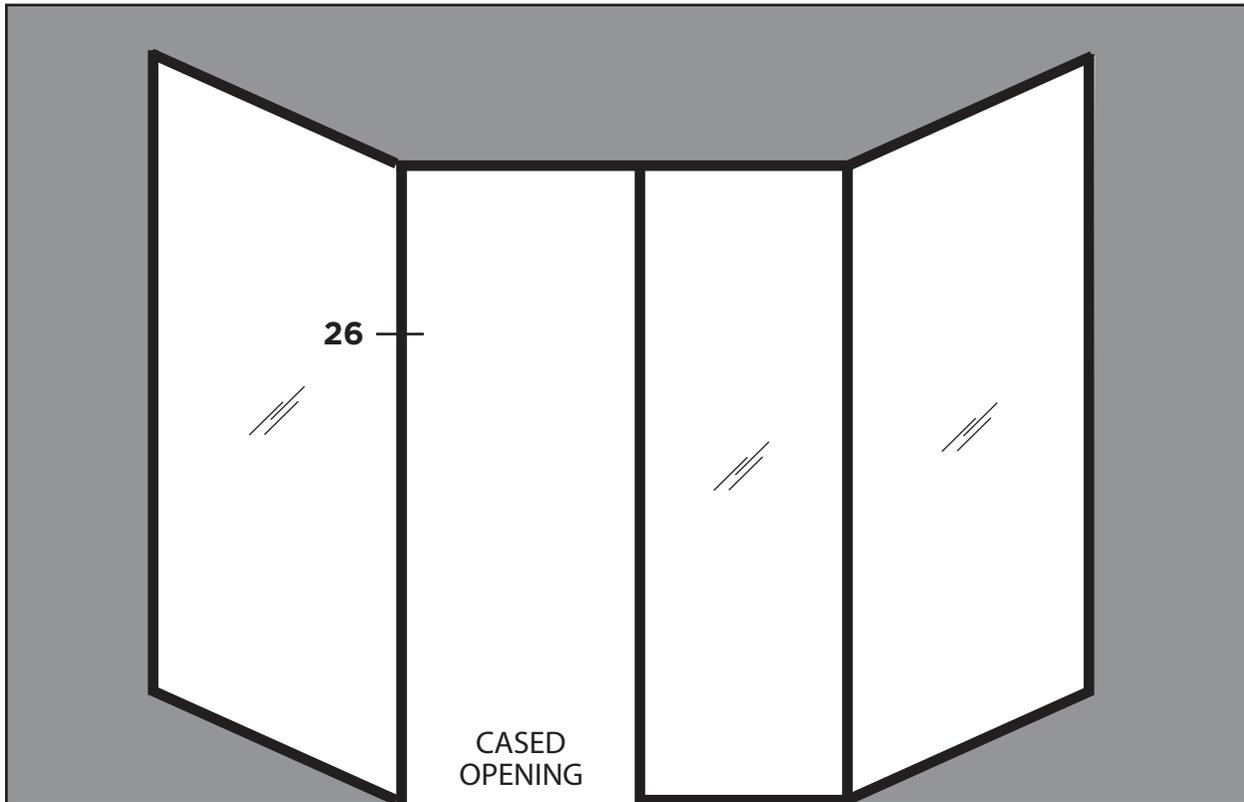
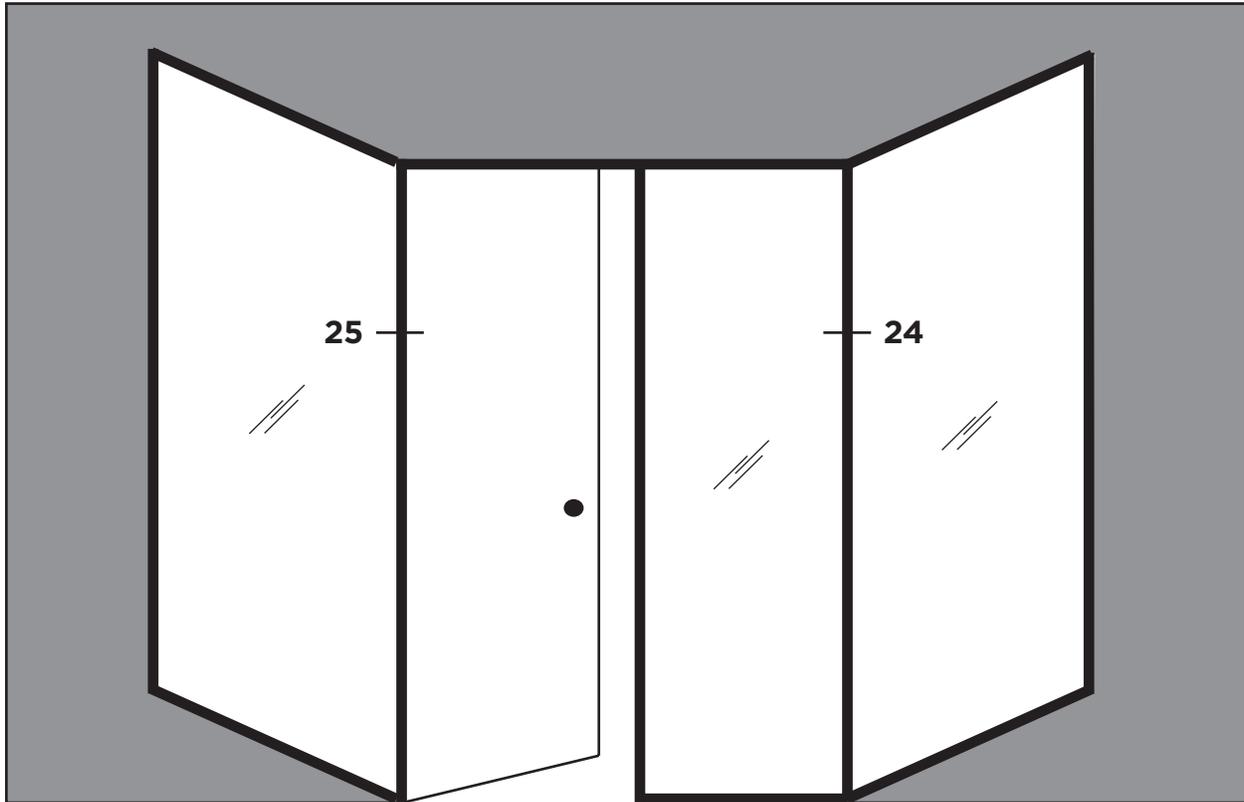
Elevations with Detail Numbers



Elevations with Detail Numbers



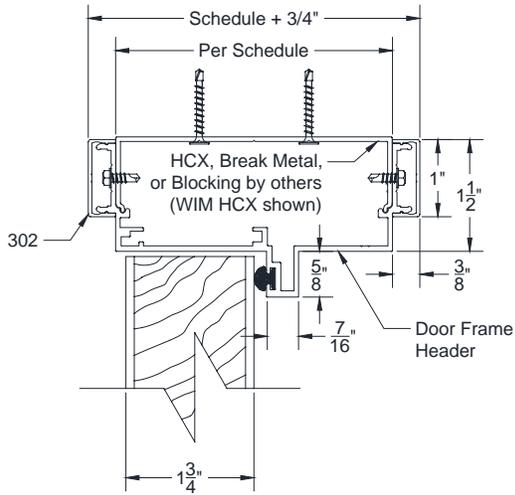
Corner Elevations with Detail Numbers



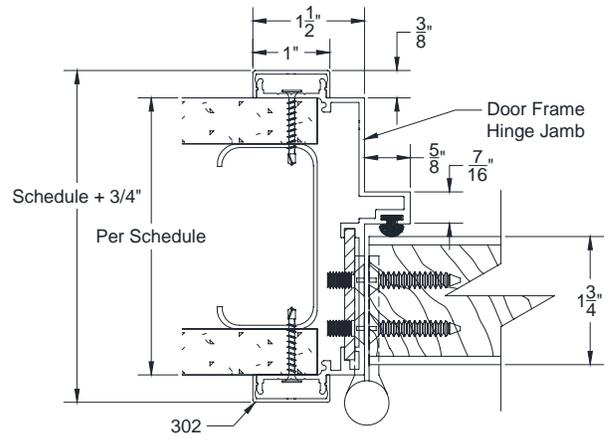
300 SERIES DETAILS
STANDARD-WIDTH DOOR
FRAME & POCKET GLAZING

300 System w/ Recessed Pocket Glazing w/ 302 (1") Reveal Trim

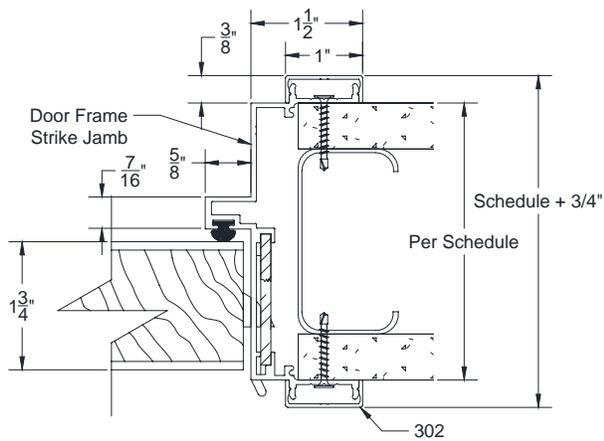
DETAIL 1



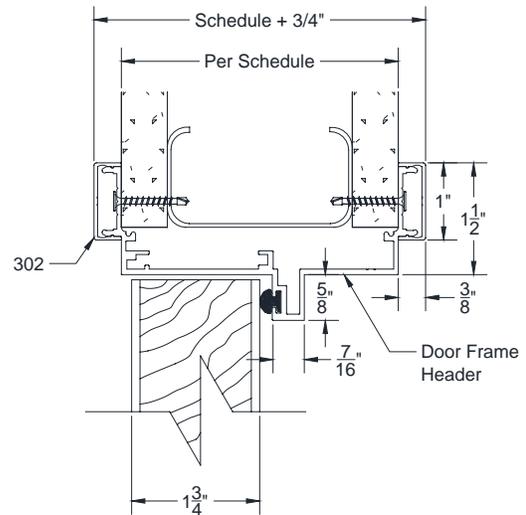
DETAIL 2



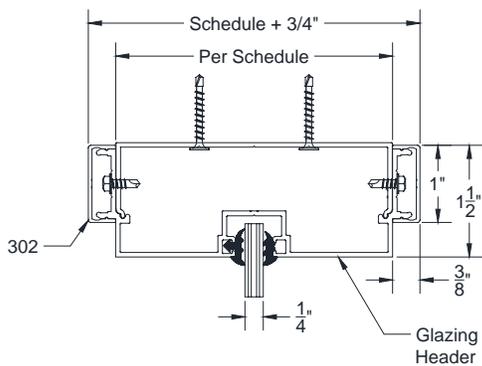
DETAIL 3



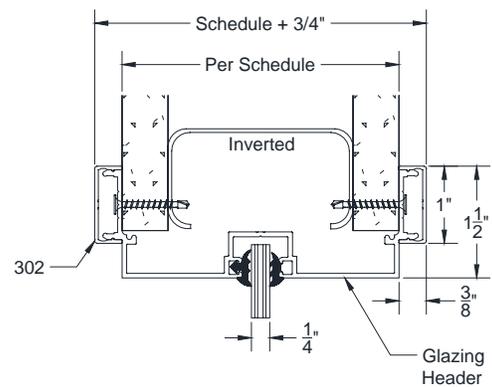
DETAIL 4



DETAIL 5

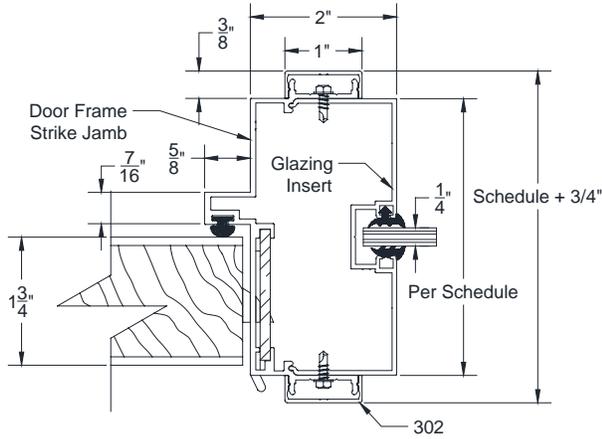


DETAIL 6

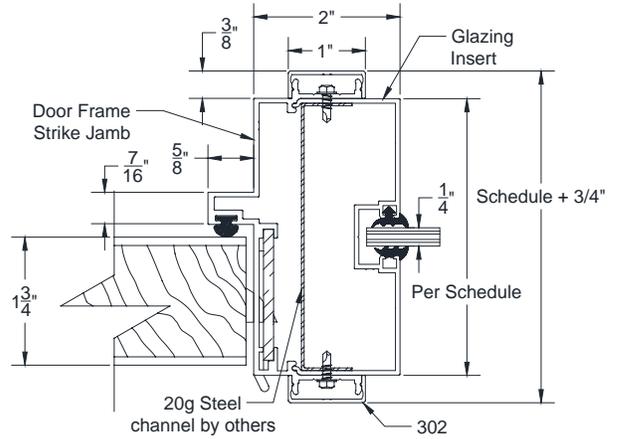


300 System w/ Recessed Pocket Glazing w/ 302 (1") Reveal Trim

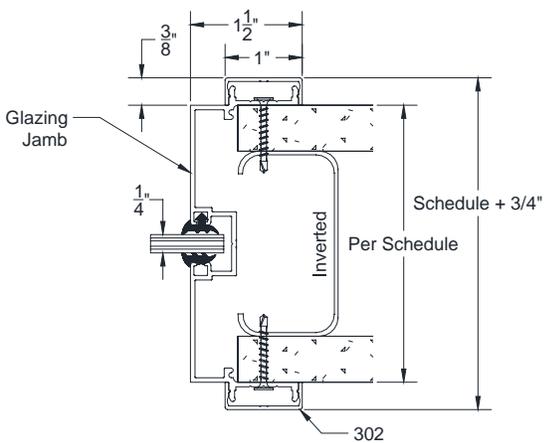
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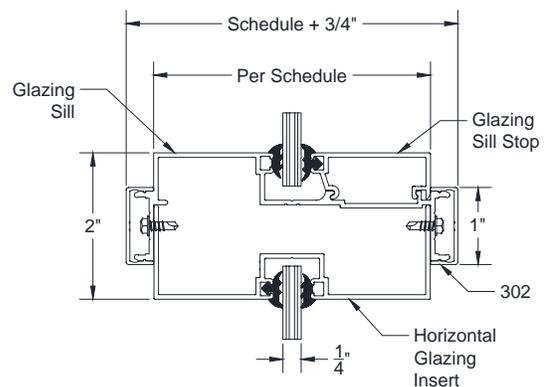
DETAIL 7 ST



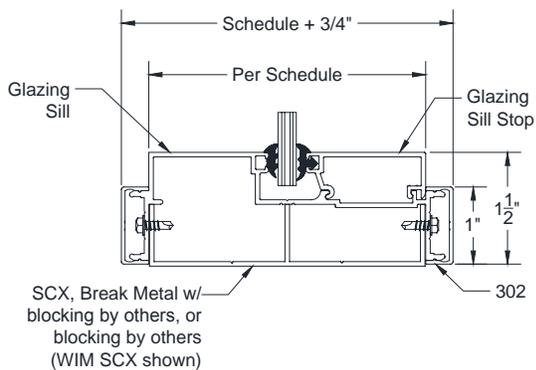
DETAIL 8



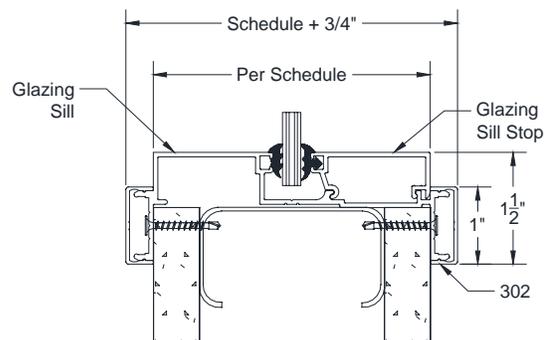
DETAIL 9



DETAIL 10

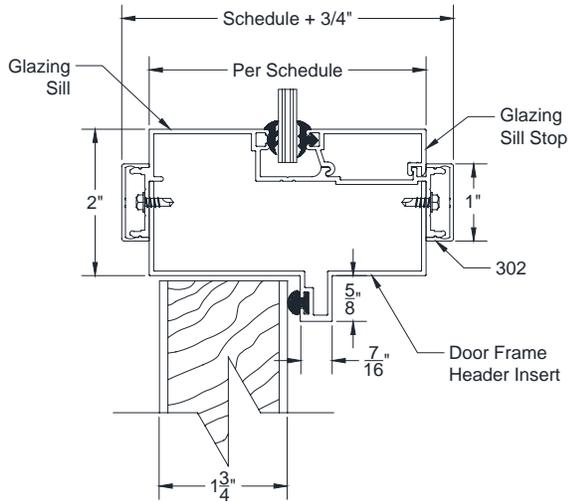


DETAIL 11

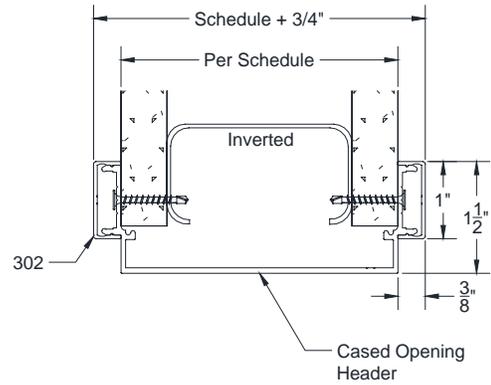


300 System w/ Recessed Pocket Glazing w/ 302 (1") Reveal Trim

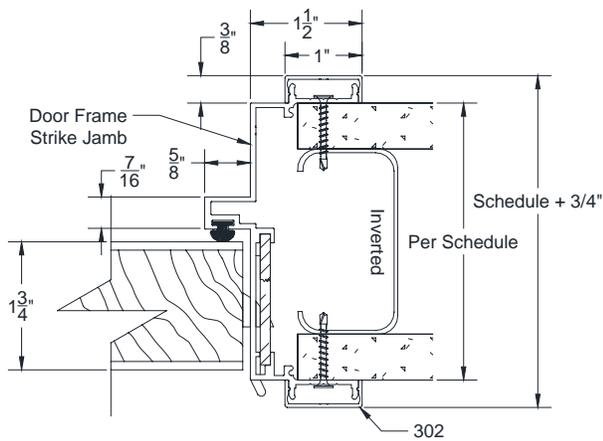
DETAIL 12



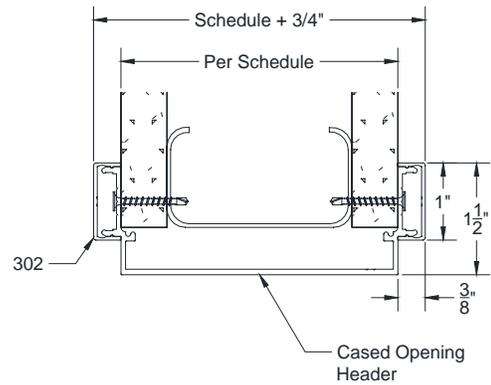
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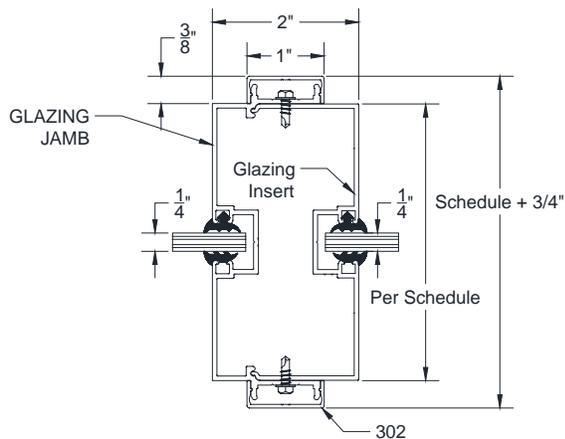
DETAIL 14



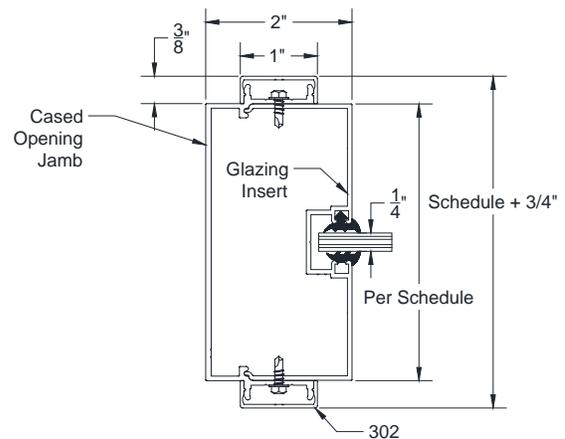
DETAIL 15



DETAIL 16

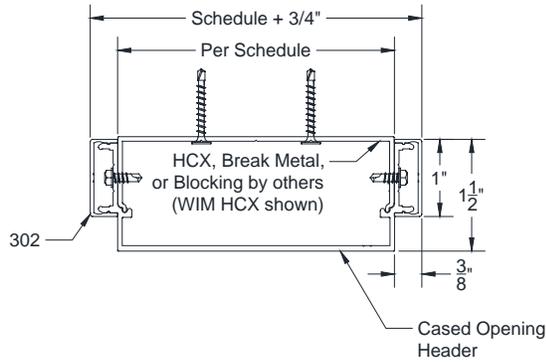


DETAIL 17

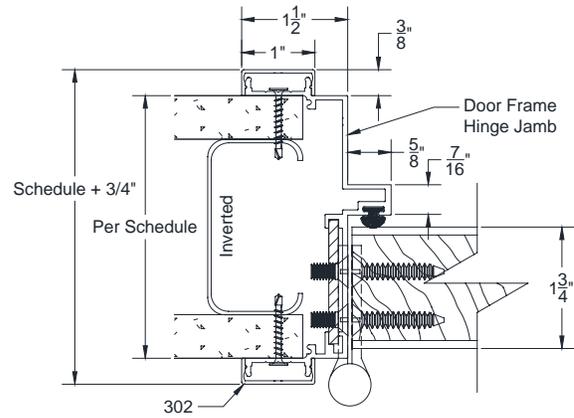


300 System w/ Recessed Pocket Glazing w/ 302 (1") Reveal Trim

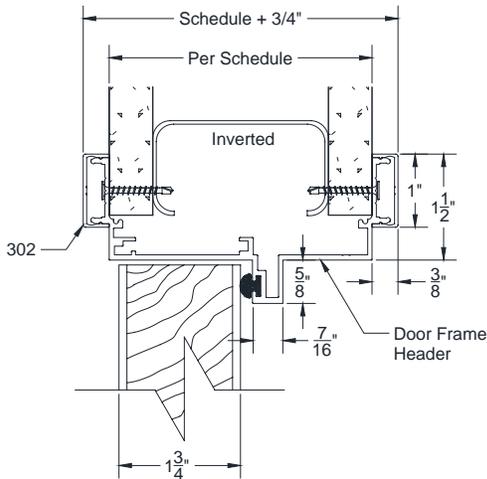
DETAIL 18



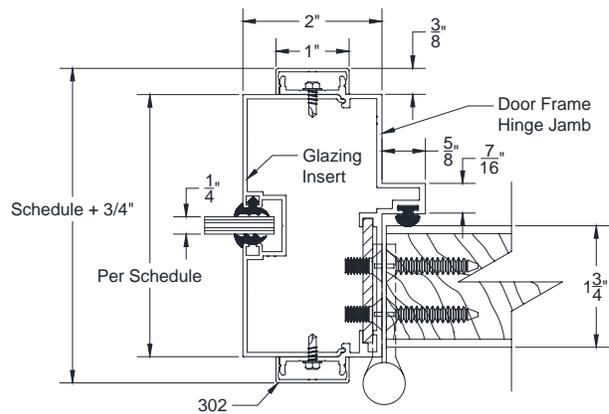
DETAIL 19



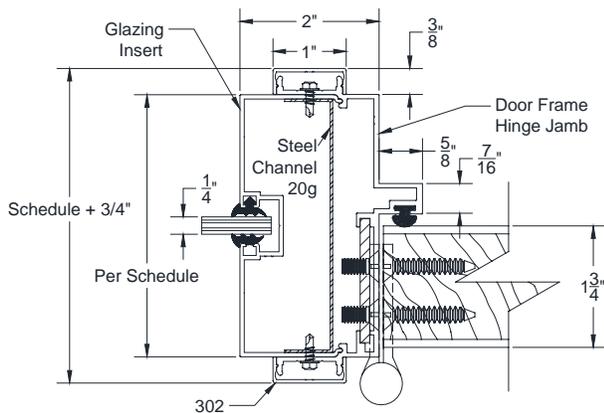
DETAIL 20



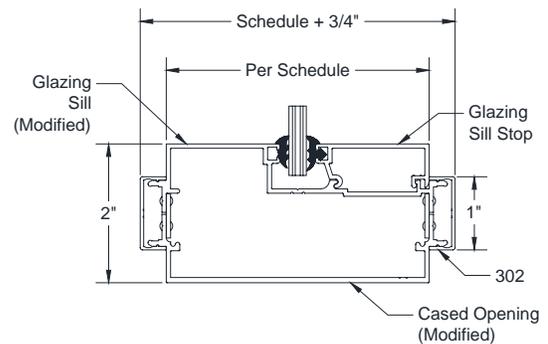
DETAIL 21



DETAIL 21 ST

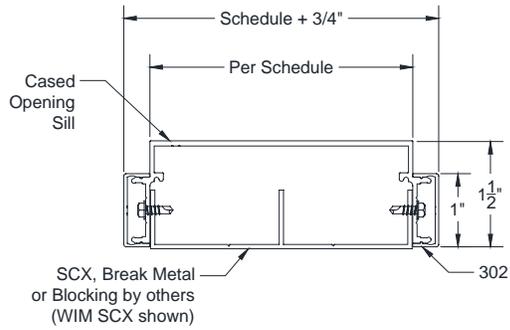


DETAIL 22

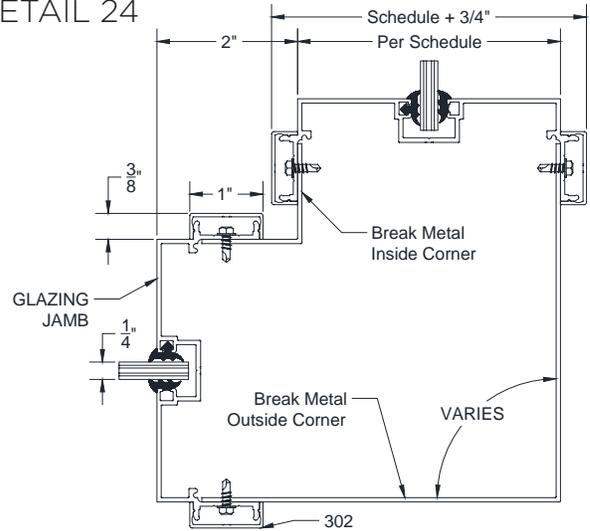


300 System w/ Recessed Pocket Glazing w/ 302 (1") Reveal Trim

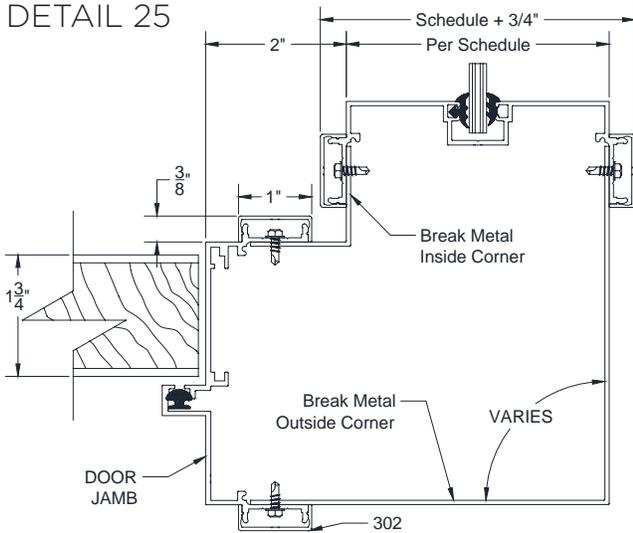
DETAIL 23



DETAIL 24

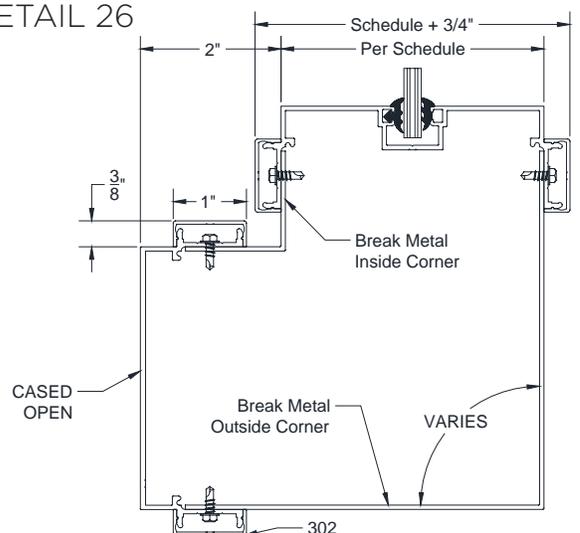


DETAIL 25



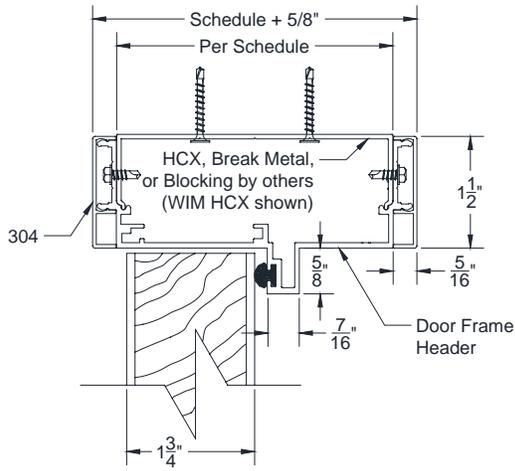
Note: This configuration must be reinforced on site.

DETAIL 26

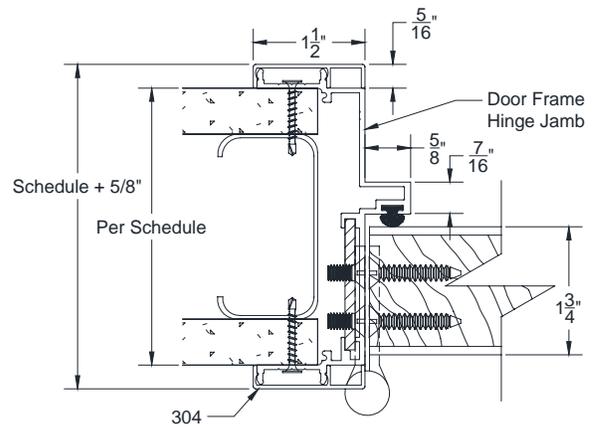


300 System w/ Recessed Pocket Glazing w/ 304-1 (1-1/2") Flush Trim

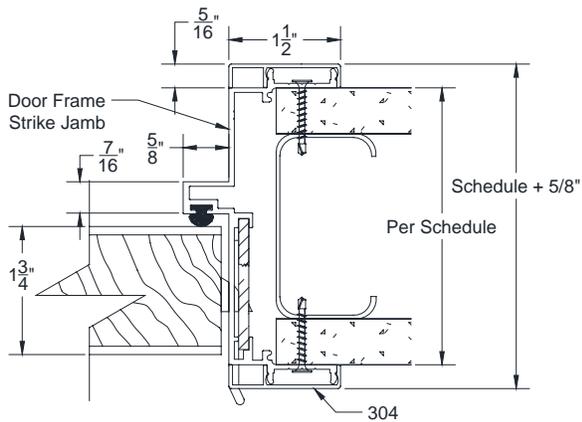
DETAIL 1A



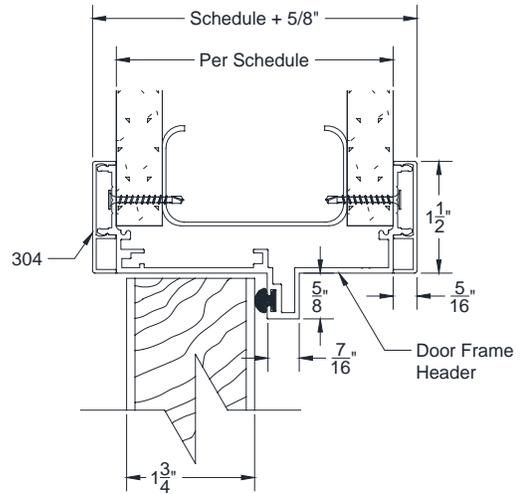
DETAIL 2A



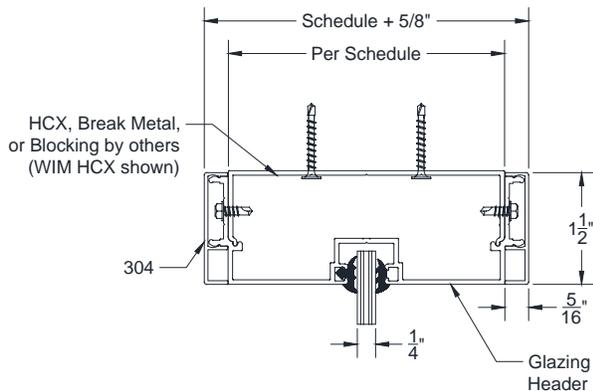
DETAIL 3A



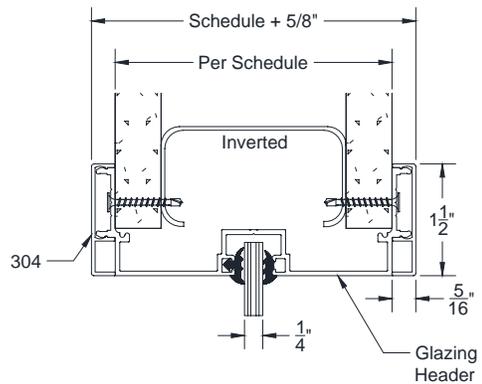
DETAIL 4A



DETAIL 5A

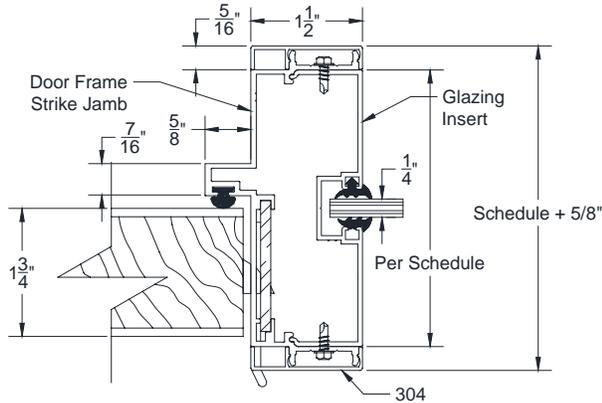


DETAIL 6A



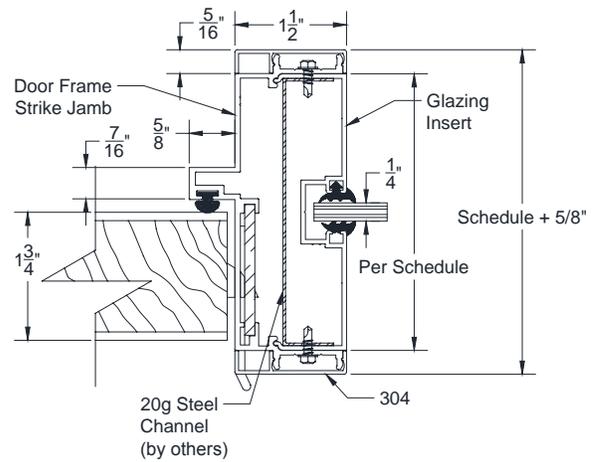
300 System w/ Recessed Pocket Glazing w/ 304-1 (1-1/2") Flush Trim

DETAIL 7A

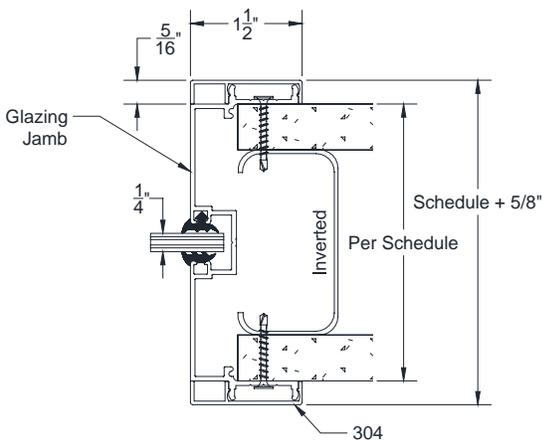


Note: 1-5/8" extended lip strike plate required (by others).

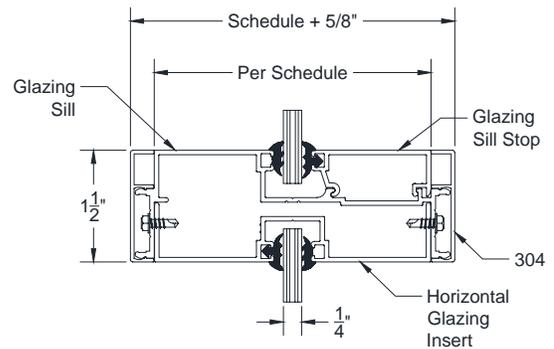
DETAIL 7A ST



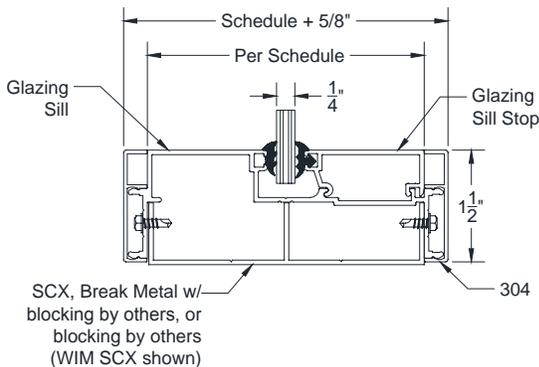
DETAIL 8A



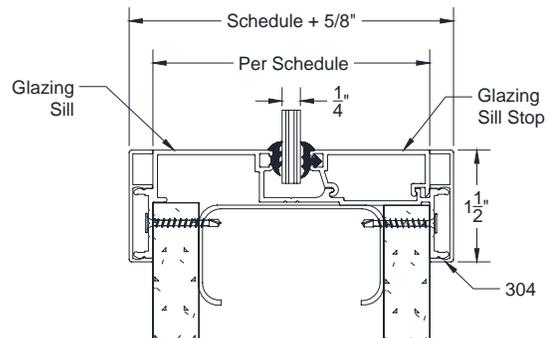
DETAIL 9A



DETAIL 10A

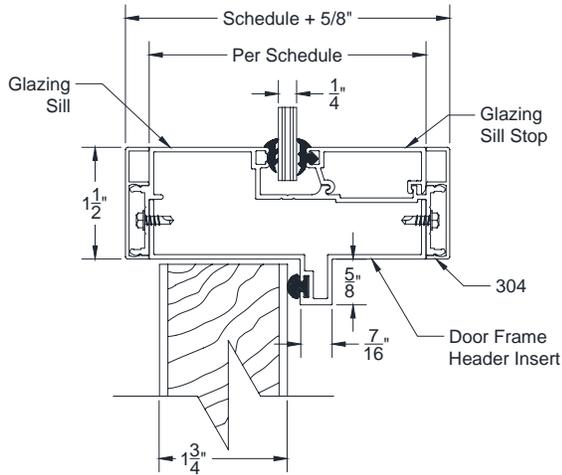


DETAIL 11A

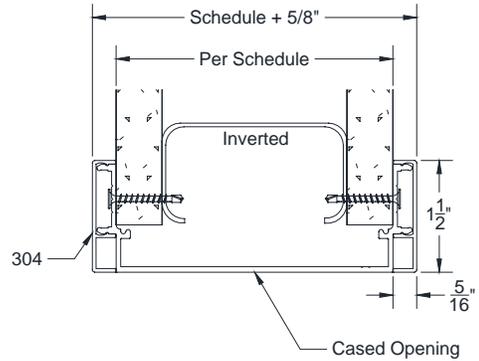


300 System w/ Recessed Pocket Glazing w/ 304-1 (1-1/2") Flush Trim

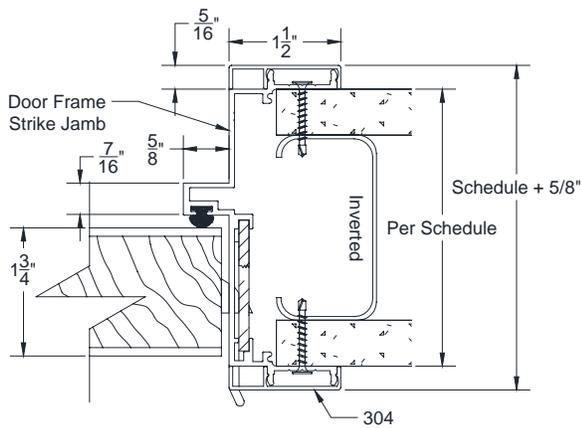
DETAIL 12A



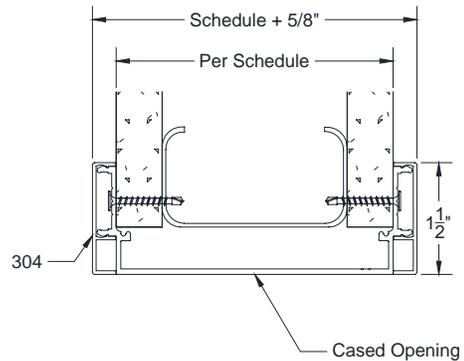
DETAIL 13A



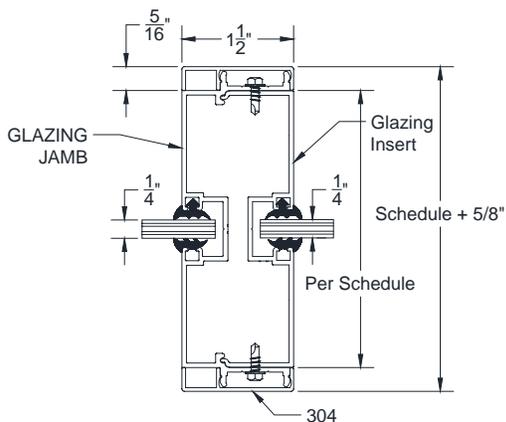
DETAIL 14A



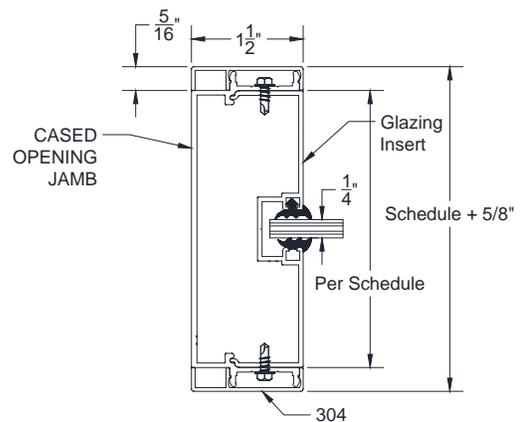
DETAIL 15A



DETAIL 16A

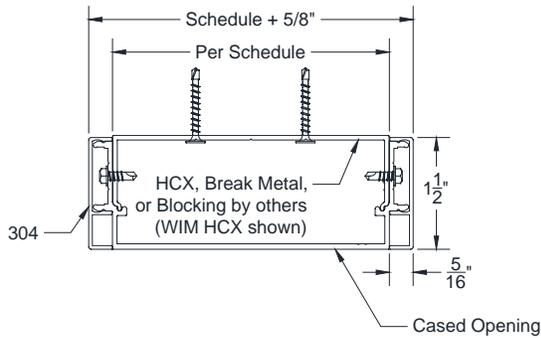


DETAIL 17A

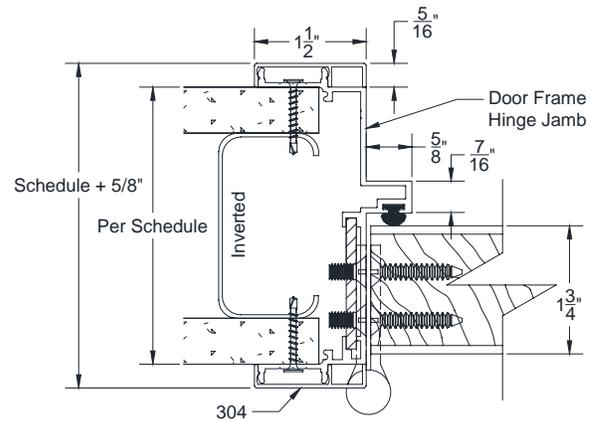


300 System w/ Recessed Pocket Glazing w/ 304-1 (1-1/2") Flush Trim

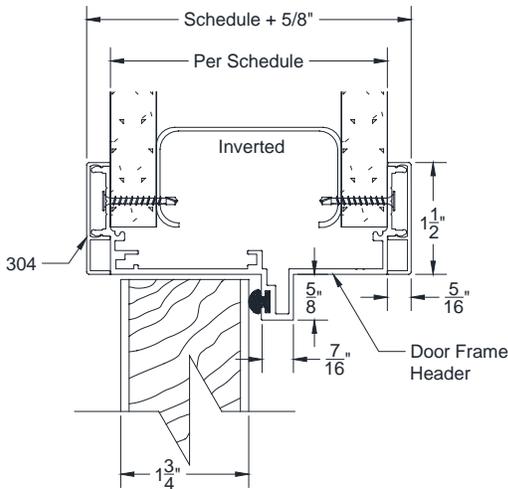
DETAIL 18A



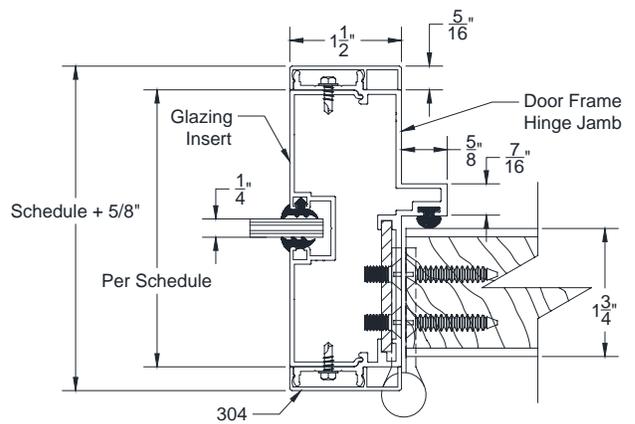
DETAIL 19A



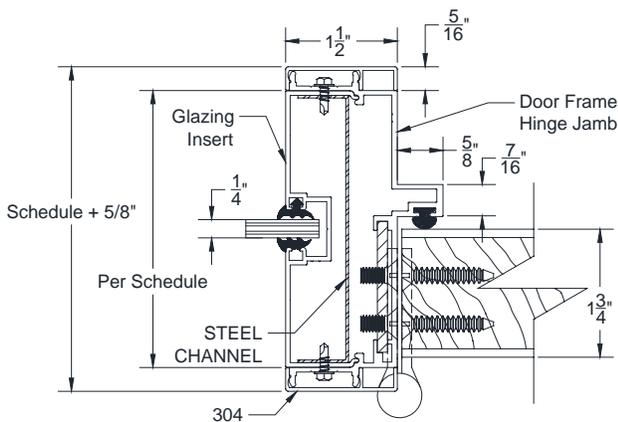
DETAIL 20A



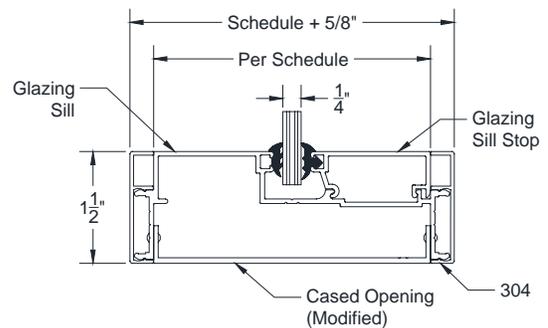
DETAIL 21A



DETAIL 21A ST

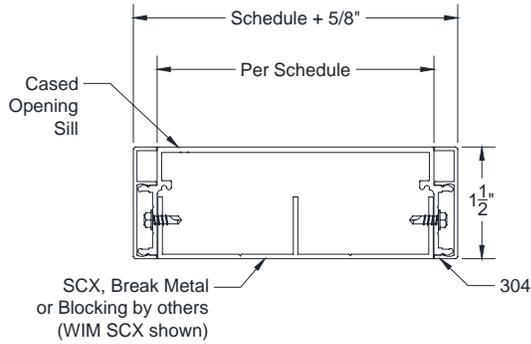


DETAIL 22A

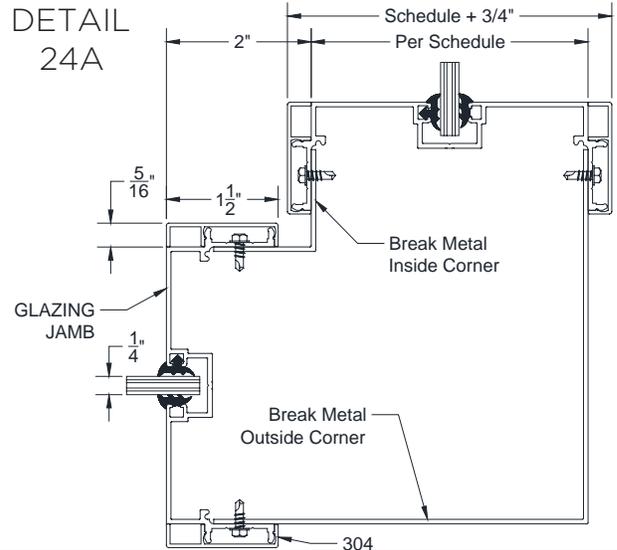


300 System w/ Recessed Pocket Glazing w/ 304-1 (1-1/2") Flush Trim

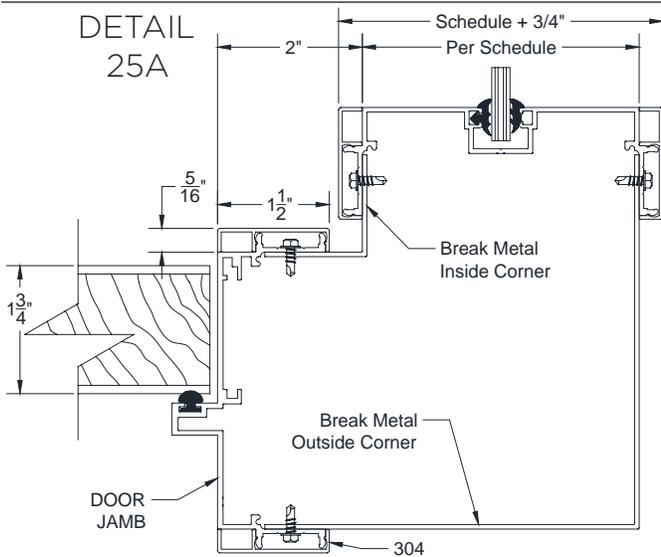
DETAIL
23A



DETAIL
24A

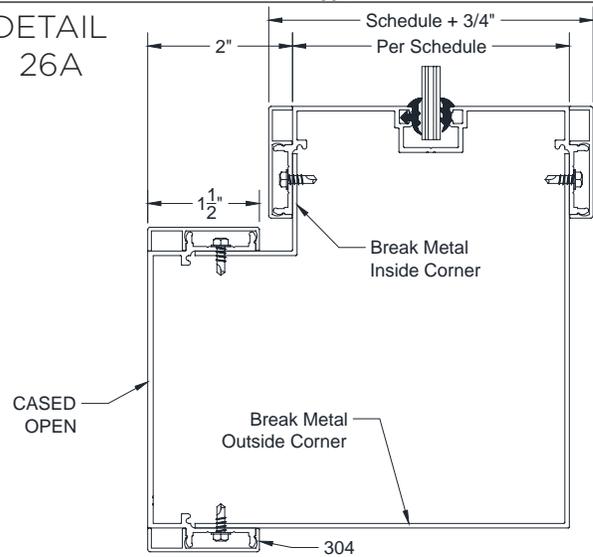


DETAIL
25A



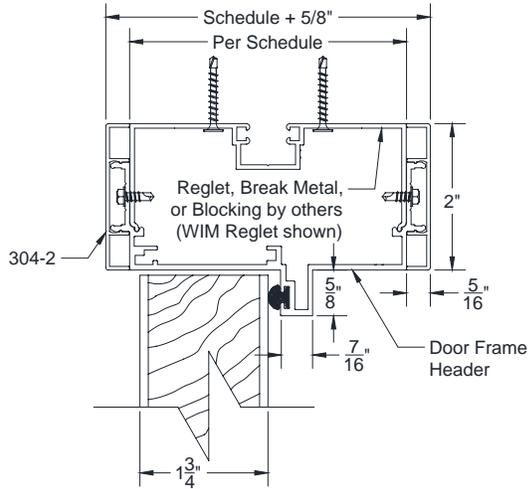
Note: This configuration must be reinforced on site.

DETAIL
26A

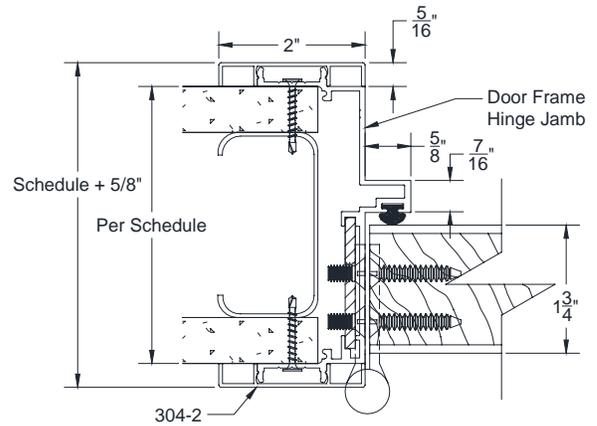


300 System w/ Recessed Pocket Glazing w/ 304-2 (2") Flush Trim

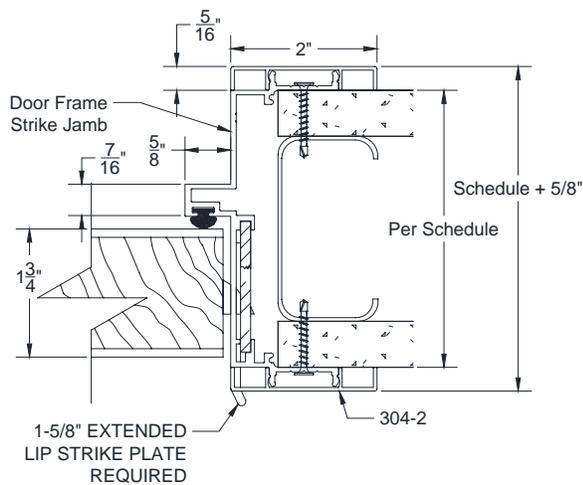
DETAIL 1B



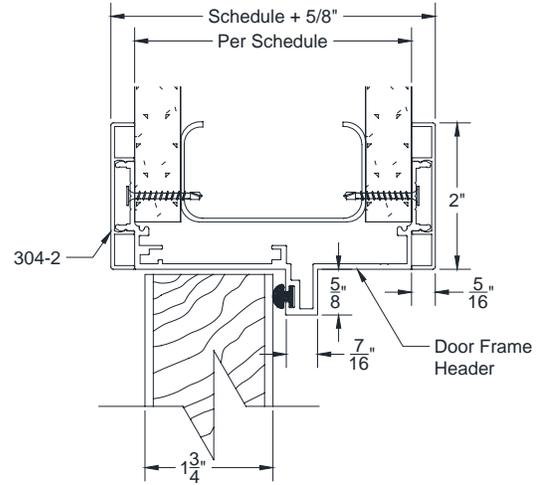
DETAIL 2B



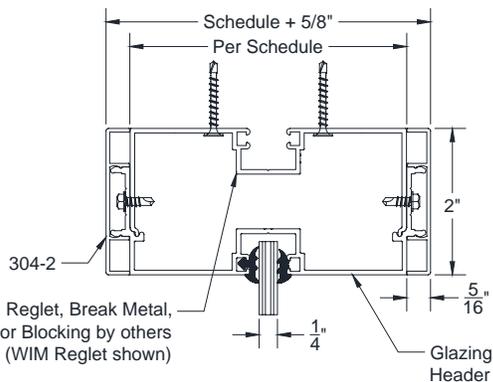
DETAIL 3B



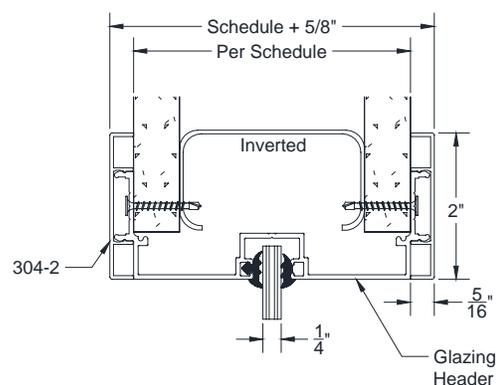
DETAIL 4B



DETAIL 5B

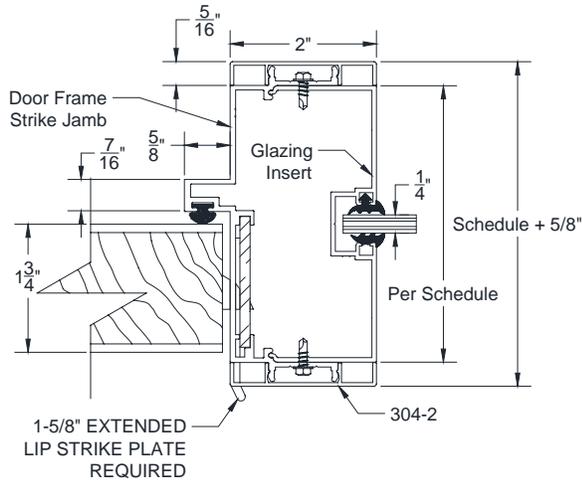


DETAIL 6B

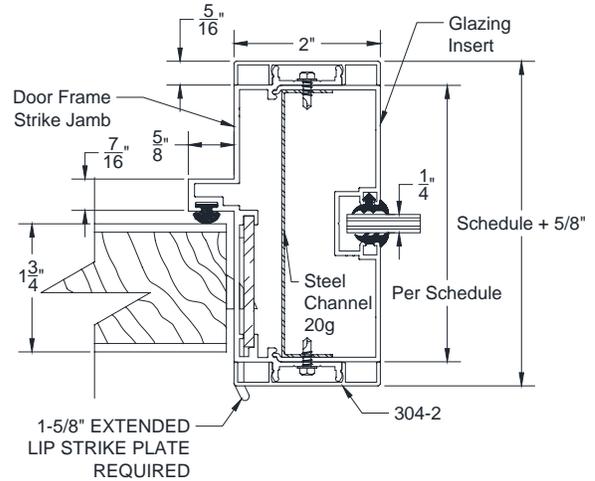


300 System w/ Recessed Pocket Glazing w/ 304-2 (2") Flush Trim

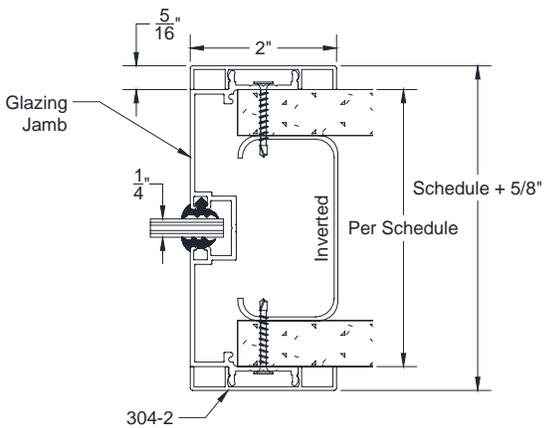
DETAIL 7B



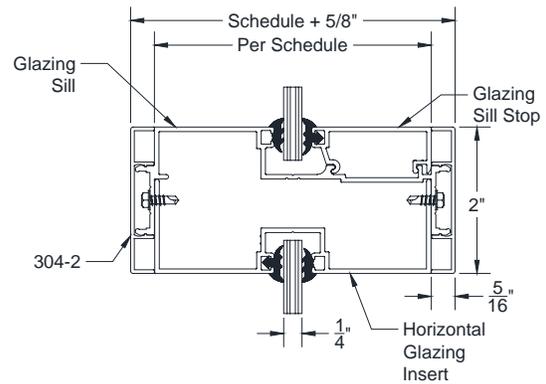
DETAIL 7B ST



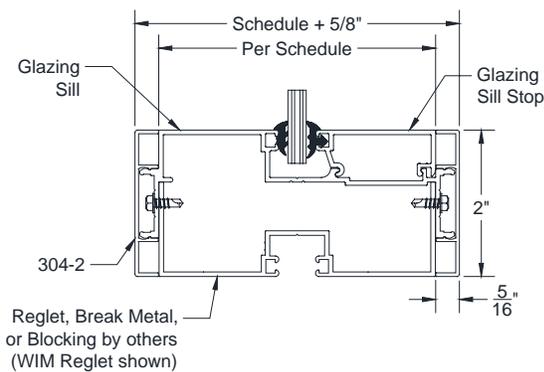
DETAIL 8B



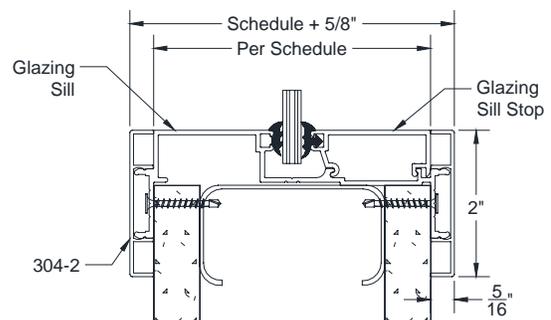
DETAIL 9B



DETAIL 10B

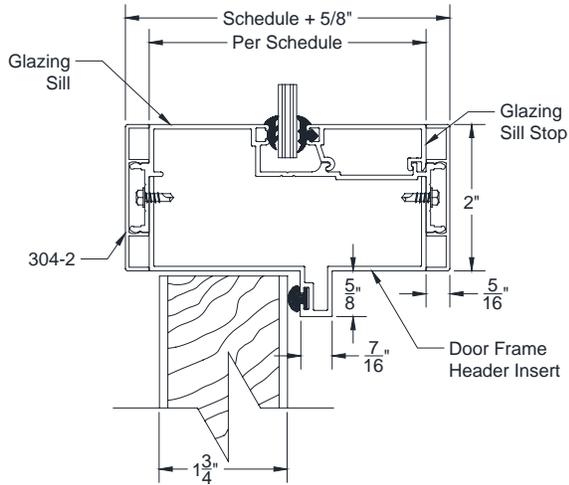


DETAIL 11B

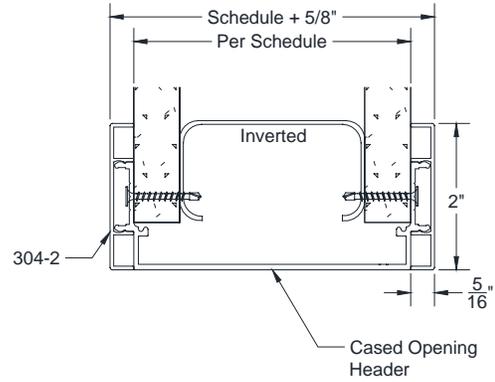


300 System w/ Recessed Pocket Glazing w/ 304-2 (2") Flush Trim

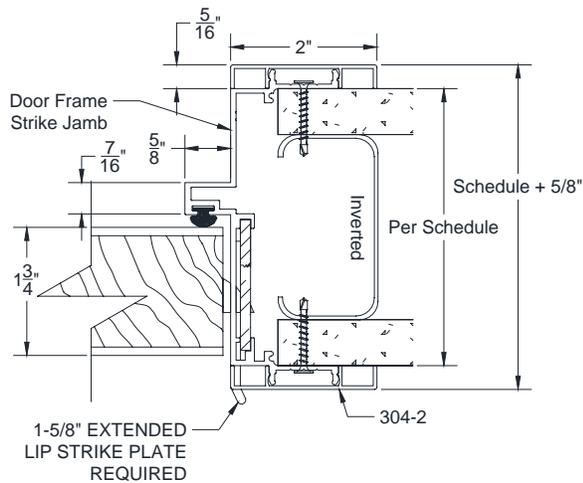
DETAIL 12B



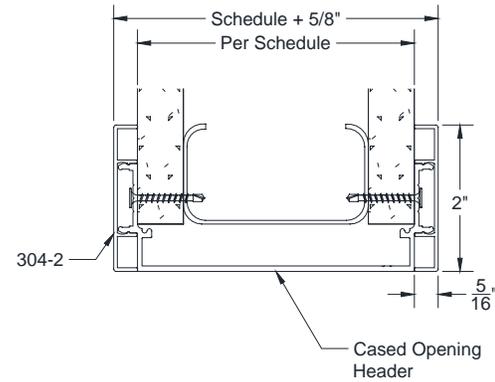
DETAIL 13B



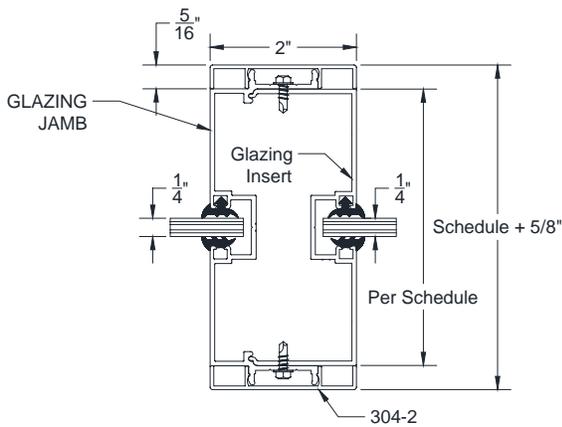
DETAIL 14B



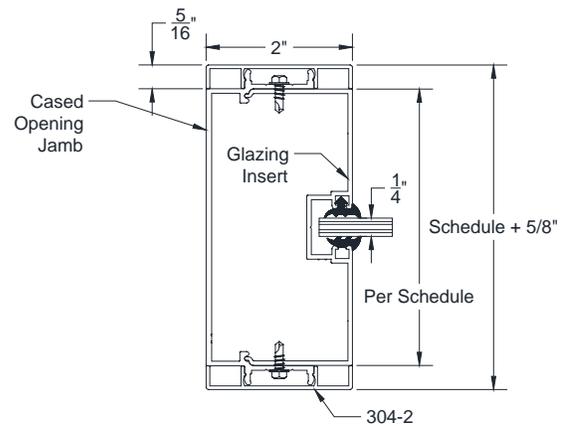
DETAIL 15B



DETAIL 16B

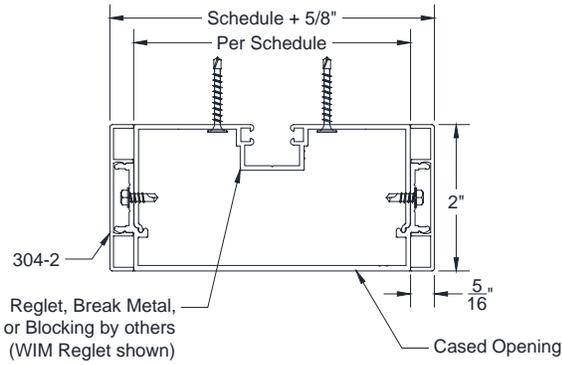


DETAIL 17B

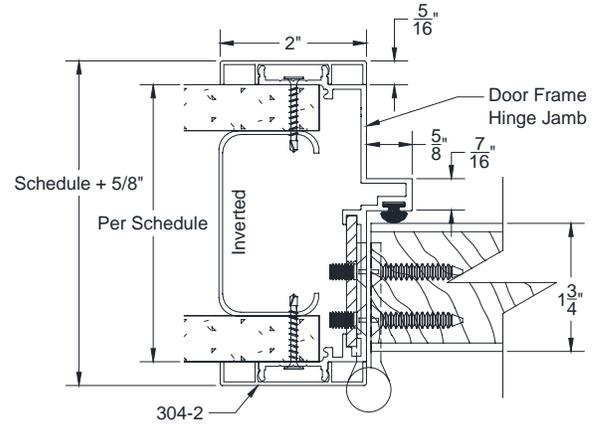


300 System w/ Recessed Pocket Glazing w/ 304-2 (2") Flush Trim

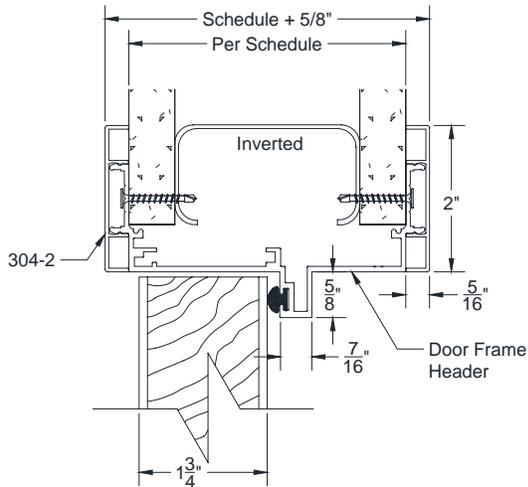
DETAIL 18B



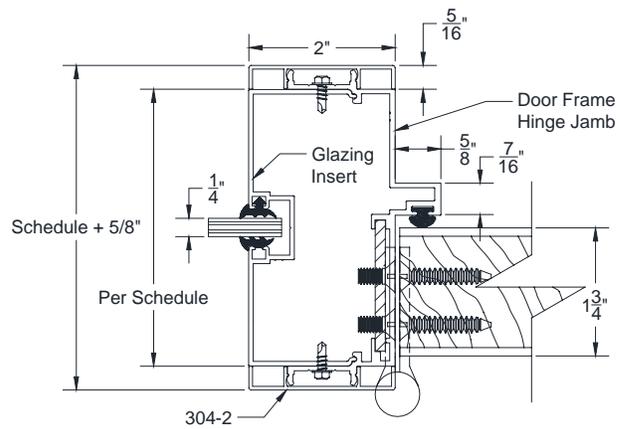
DETAIL 19B



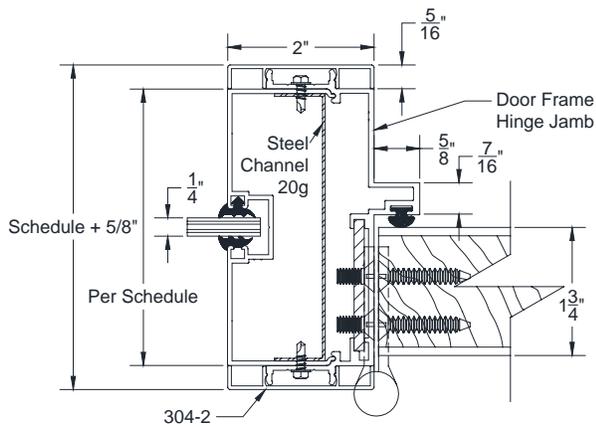
DETAIL 20B



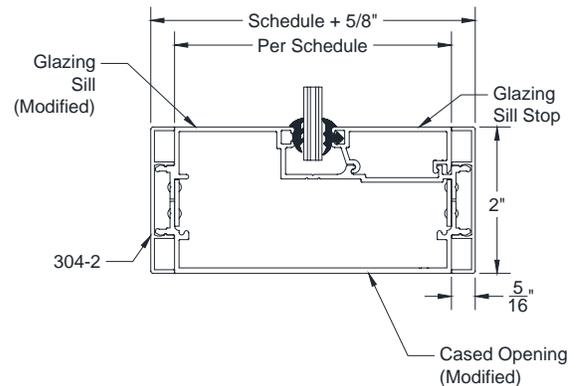
DETAIL 21B



DETAIL 21B ST

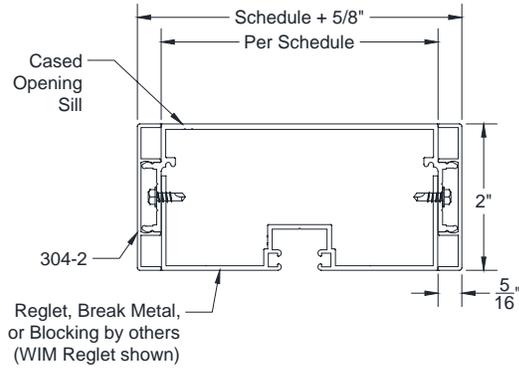


DETAIL 22B

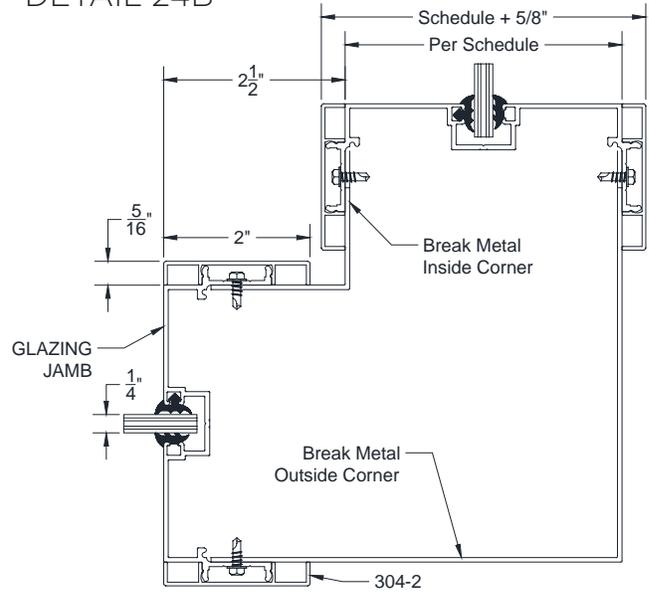


300 System w/ Recessed Pocket Glazing w/ 304-2 (2") Flush Trim

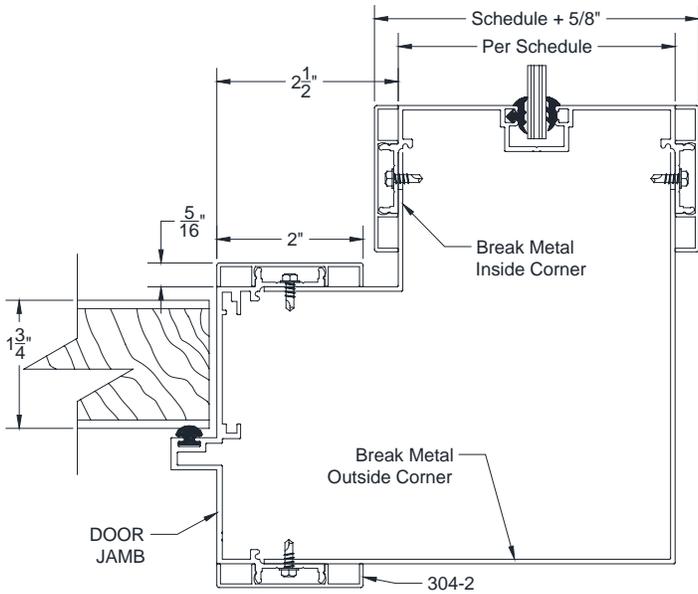
DETAIL 23B



DETAIL 24B

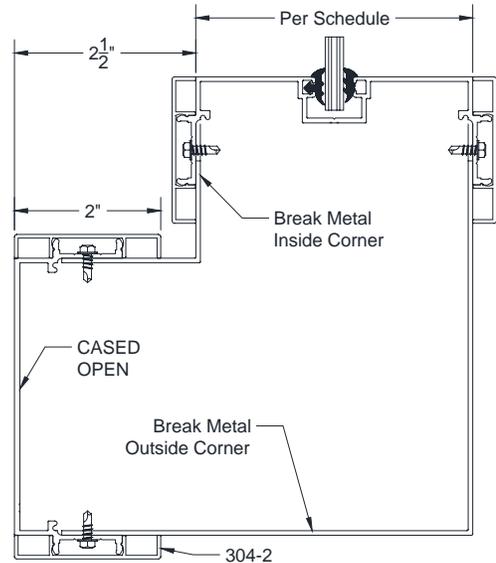


DETAIL 25B

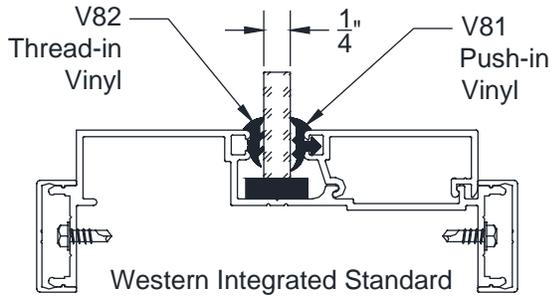


Note: This configuration must be reinforced on site.

DETAIL 26B

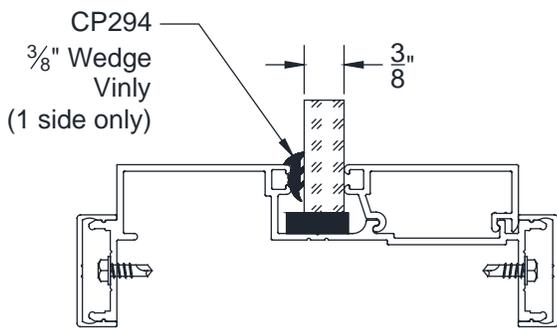


Glazing Vinyl Information



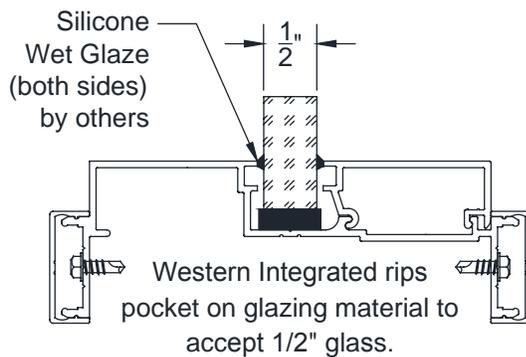
This information does not take into account glass tolerances.

Consult glass manufacturer before ordering glass.



Glass size is:

Daylight Opening + 7/16"
(both height & width)



Color options are:

Black (WIM Standard)
Gray
White

*219 series has an expanded pocket and uses standard vinyl with 1/2" glass.
Available in 5" throat size.*

400 SERIES DETAILS
VARIABLE-WIDTH DOOR FRAME
& APPLIED STOP GLAZING

400 Series Variable Width Door Frame /Glazing System

Western Integrated Materials, Inc. offers a variable-width door frame and glazing system for wall sizes not carried in our standard widths. The frames are fabricated and assembled in our plant to suit your needs

Series 400 for special wall thickness from 3" to 5-15/16" throat wall.

Series 401 for special wall thickness from 6" to 7-7/16" throat wall.

Series 402 for special wall thickness from 7-1/2" to 9-1/2" throat wall.

Series 404 (Cased Opening) for special wall thickness from 3" to 5-15/16" throat wall.

Series 405 (Cased Opening) for special wall thickness from 6" to 10-1/2" throat wall.

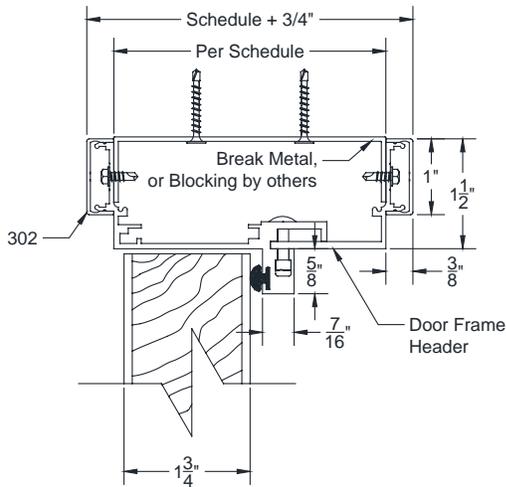
Note: Applied Stop glazing is field-installed to accommodate varying glass widths.

(see pages 14-17 for detail reference)

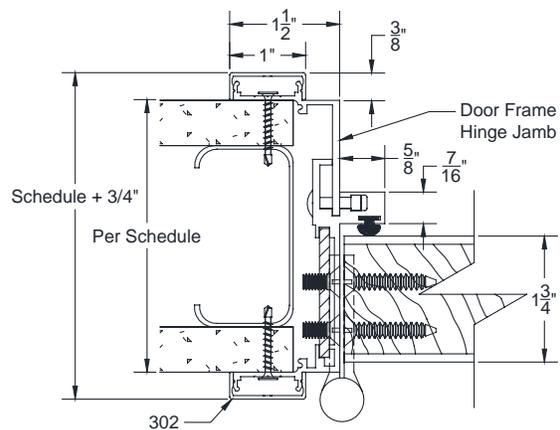
GLASS SIZE IS (DAYLIGHT OPENING - 1/2")

400 System w/ Applied Stop Glazing w/ 302 (3/8" x 1") Reveal Trim

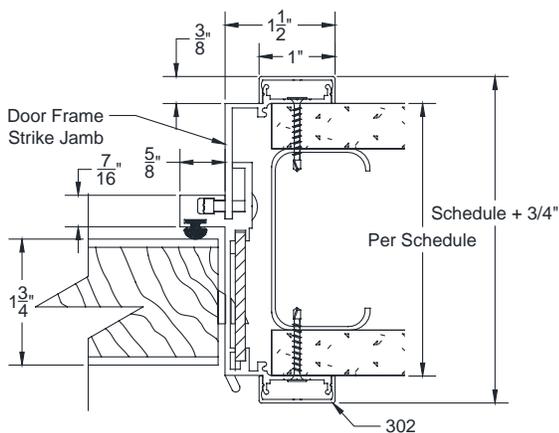
DETAIL 4-1



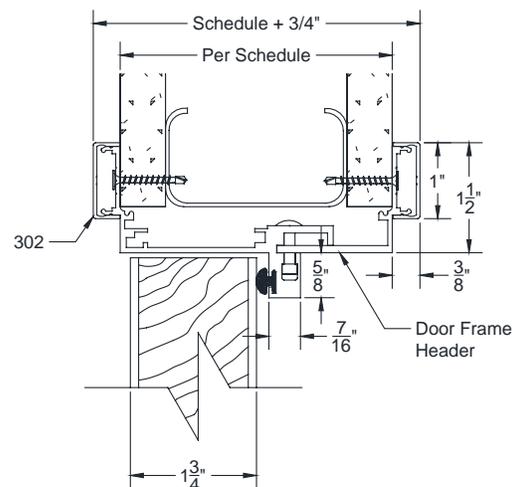
DETAIL 4-2



DETAIL 4-3

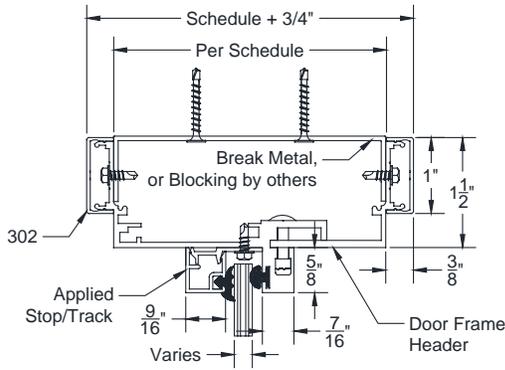


DETAIL 4-4

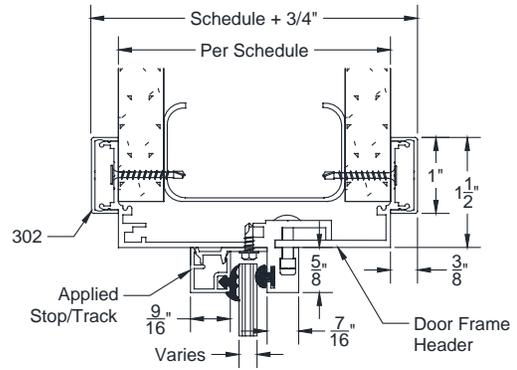


400 System w/ Applied Stop Glazing w/ 302 (3/8" x 1") Reveal Trim

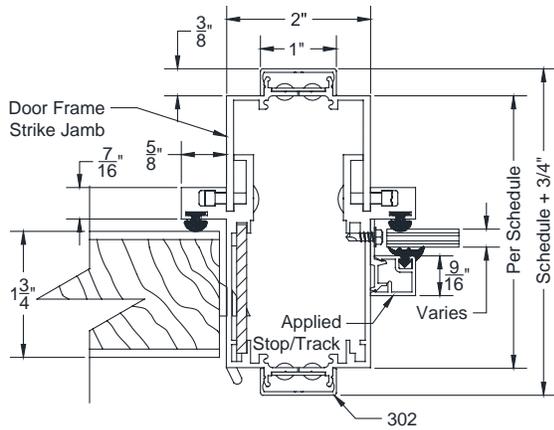
DETAIL 4-5



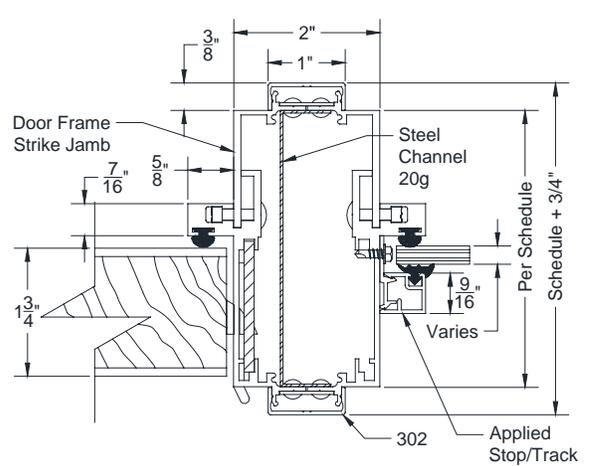
DETAIL 4-6



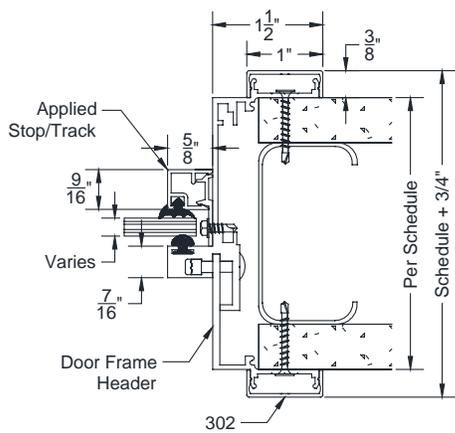
DETAIL 4-7



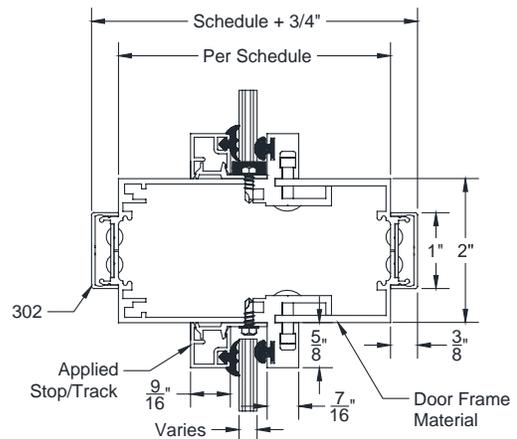
DETAIL 4-7st



DETAIL 4-8

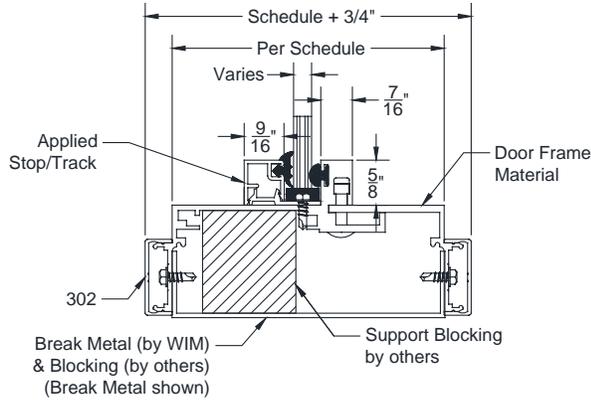


DETAIL 4-9

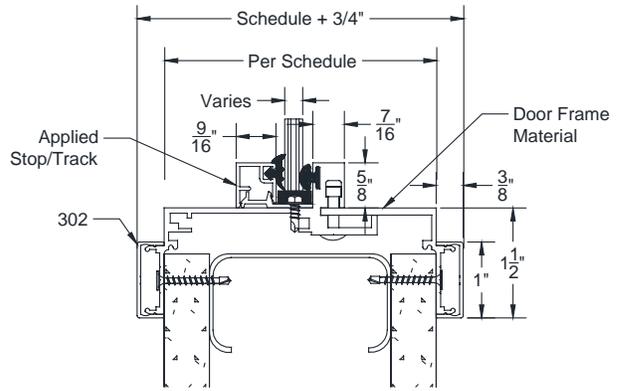


400 System w/ Applied Stop Glazing w/ 302 (3/8" x 1") Reveal Trim

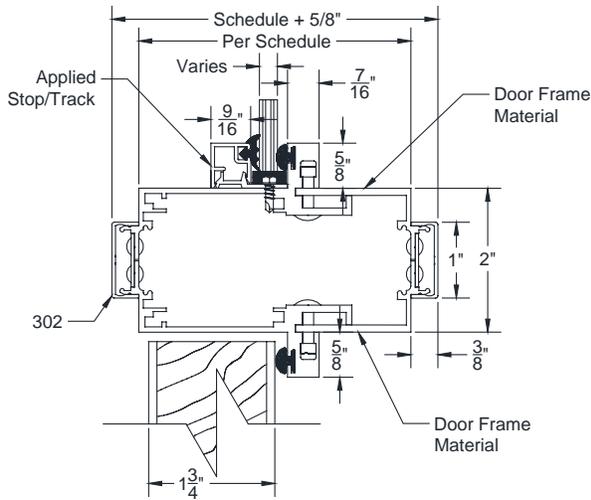
DETAIL 4-10



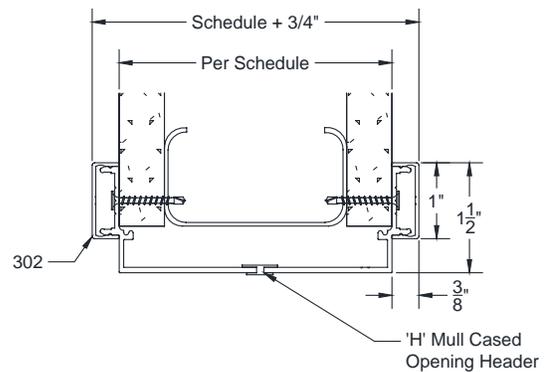
DETAIL 4-11



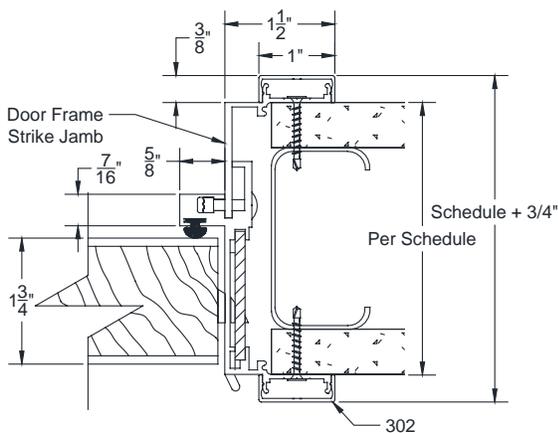
DETAIL 4-12



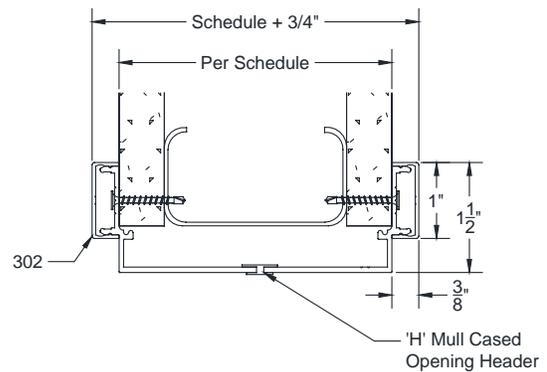
DETAIL 4-13



DETAIL 4-14

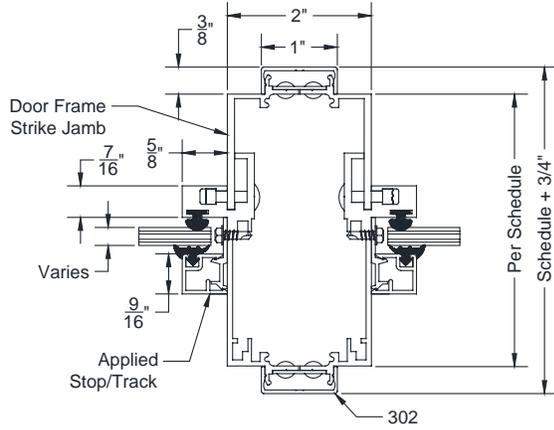


DETAIL 4-15

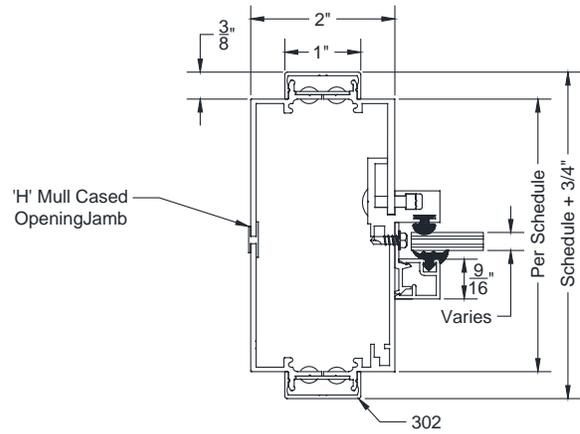


400 System w/ Applied Stop Glazing w/ 302 (3/8" x 1") Reveal Trim

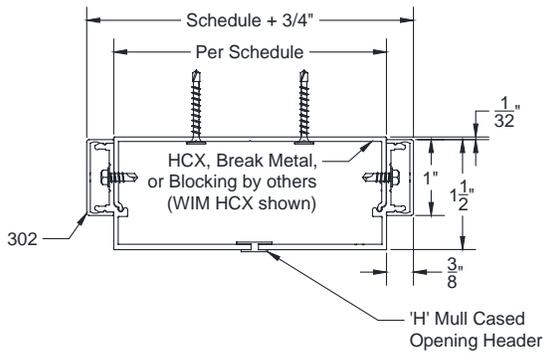
DETAIL 4-16



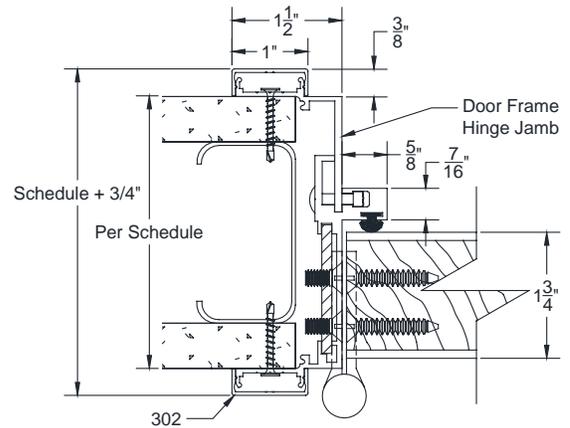
DETAIL 4-17



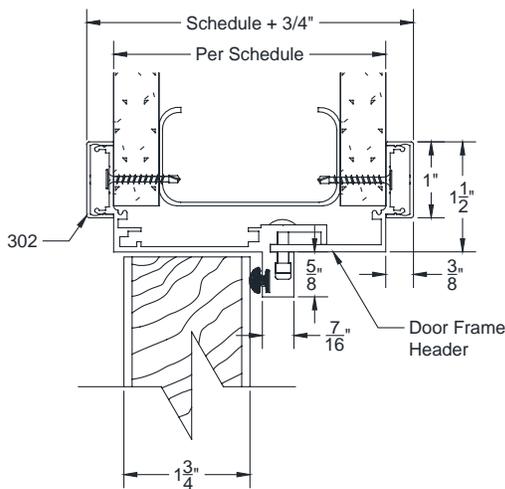
DETAIL 4-18



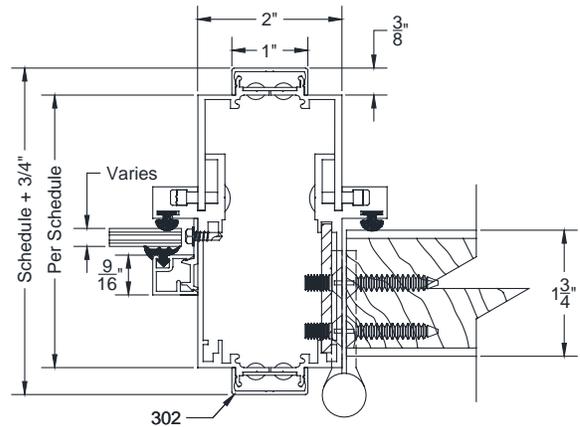
DETAIL 4-19



DETAIL 4-20

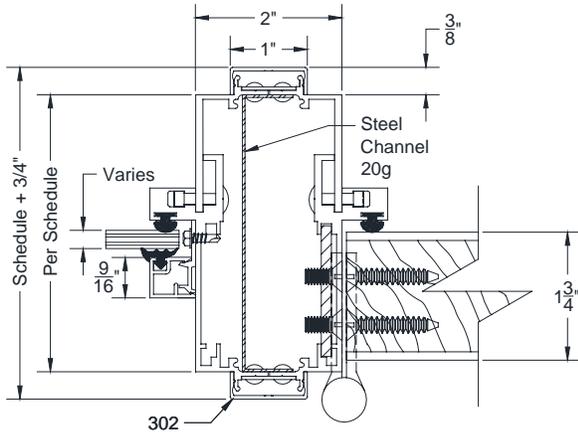


DETAIL 4-21

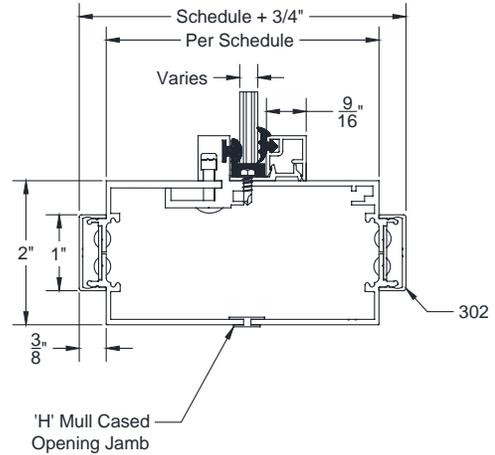


400 System w/ Applied Stop Glazing w/ 302 (3/8" x 1") Reveal Trim

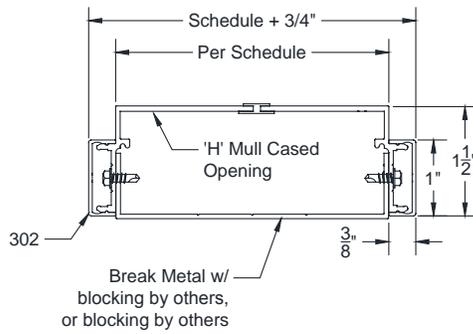
DETAIL 4-21st



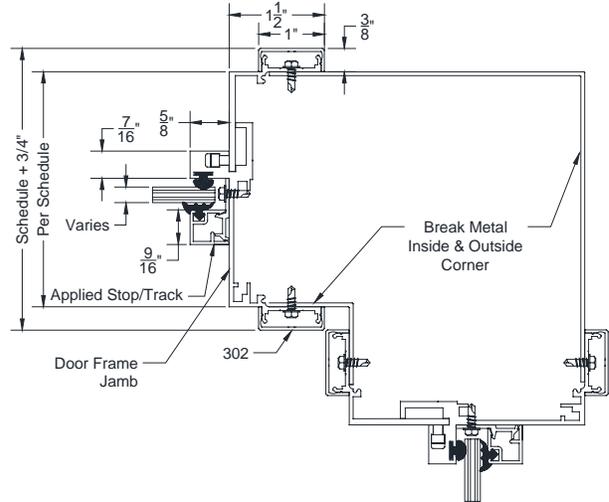
DETAIL 4-22



DETAIL 4-23

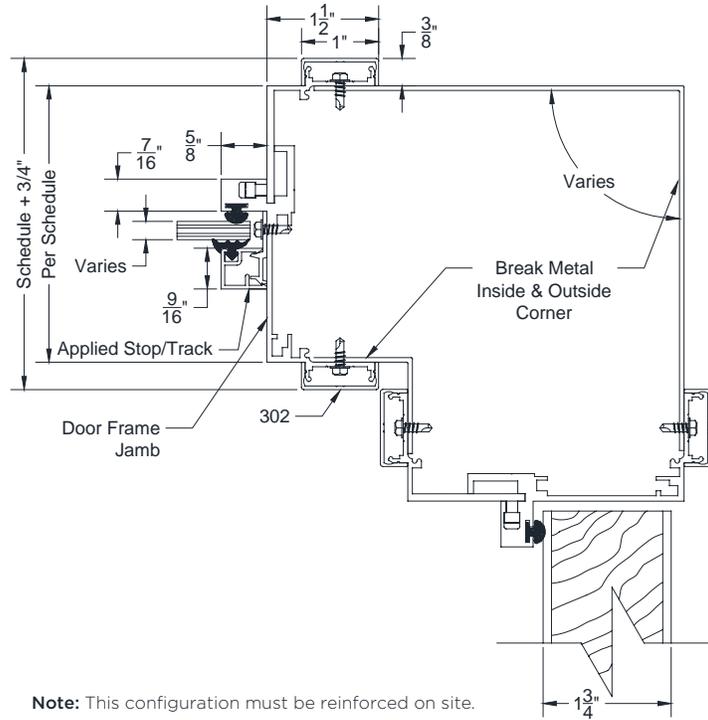


DETAIL 4-24

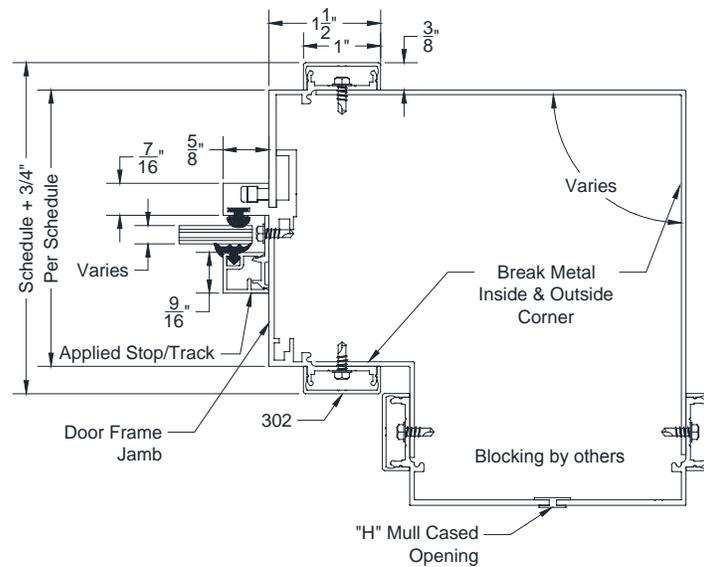


400 System w/ Applied Stop Glazing w/ 302 (3/8" x 1") Reveal Trim

DETAIL 4-25

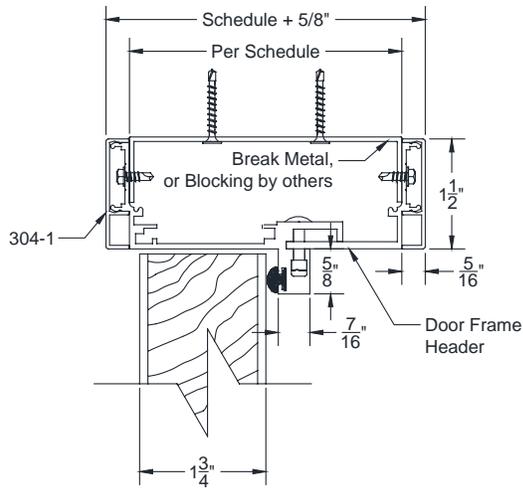


DETAIL 4-26

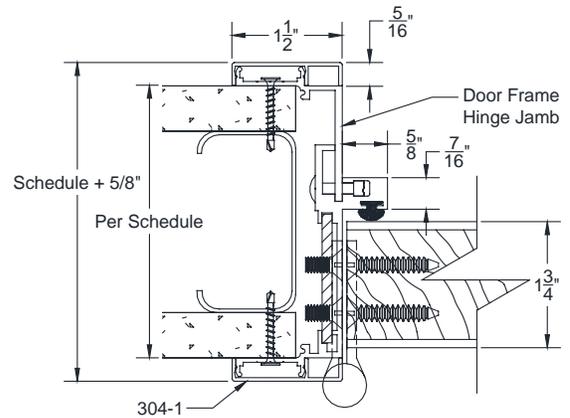


400 System w/ Applied Stop Glazing w/ 304 (5/16" x 1-1/2") Flush Trim

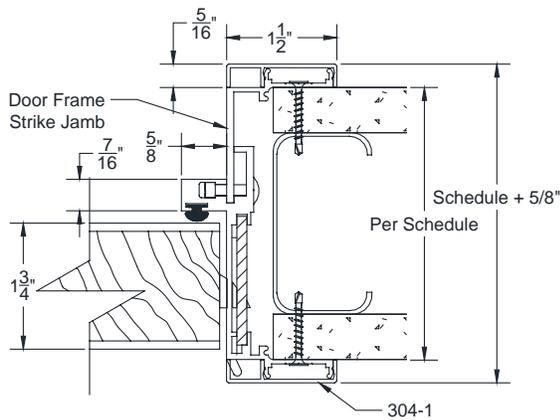
DETAIL 4-1A



DETAIL 4-2A

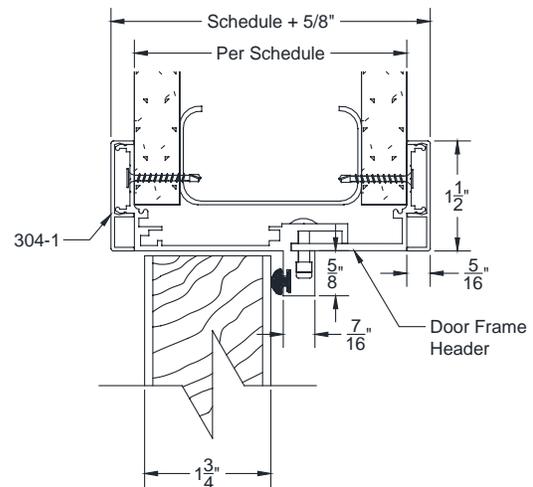


DETAIL 4-3A

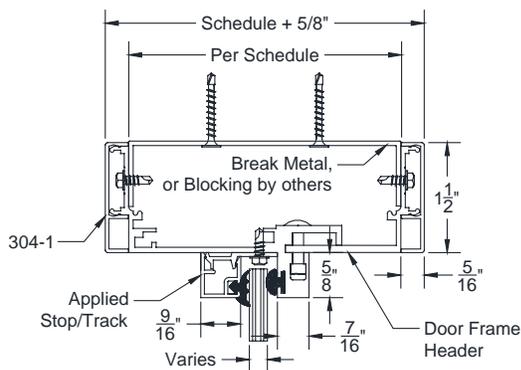


Note: Extended lip strike required.

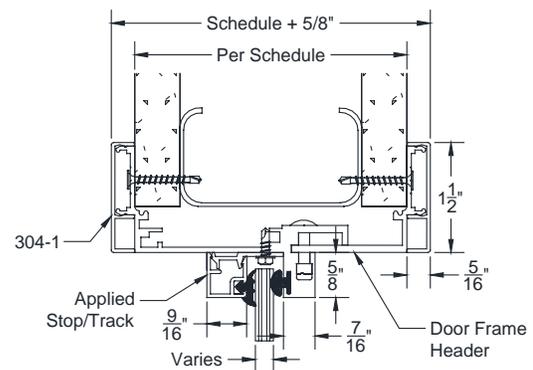
DETAIL 4-4A



DETAIL 4-5A

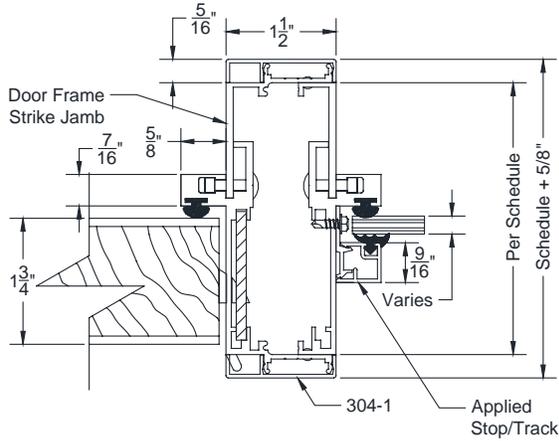


DETAIL 4-6A

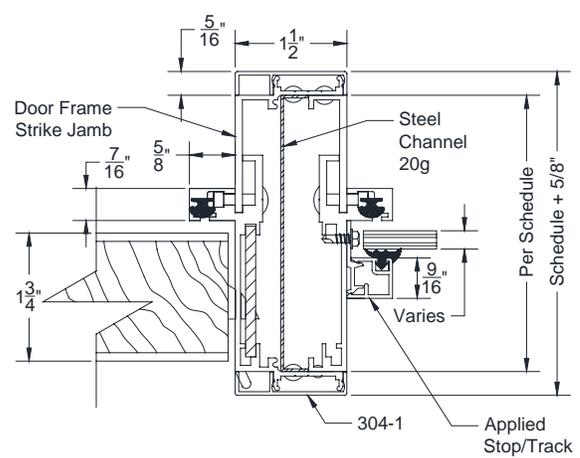


400 System w/ Applied Stop Glazing w/ 304 (5/16" x 1-1/2") Flush Trim

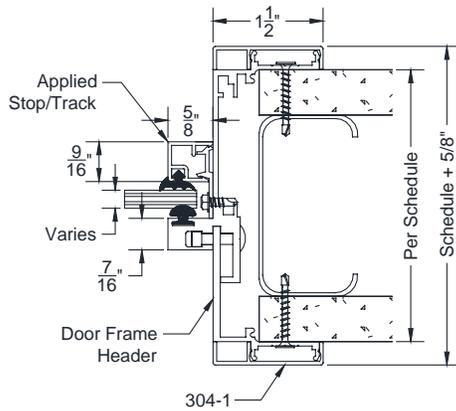
DETAIL 4-7A



DETAIL 4-7Ast

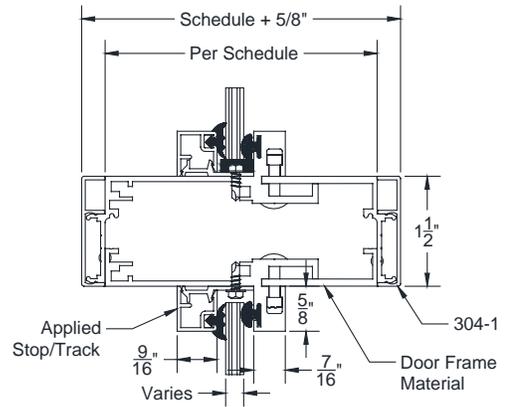


DETAIL 4-8A

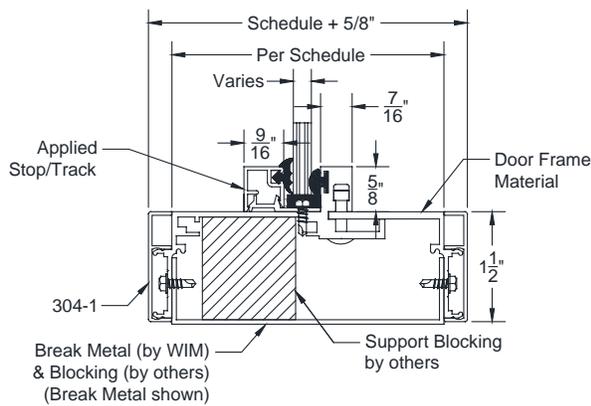


Note: Extended lip strike required.

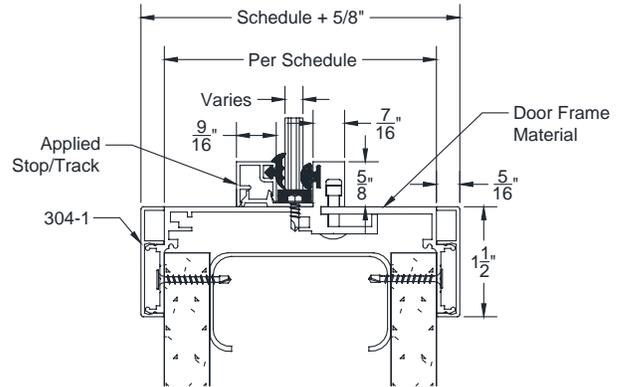
DETAIL 4-9A



DETAIL 4-10A

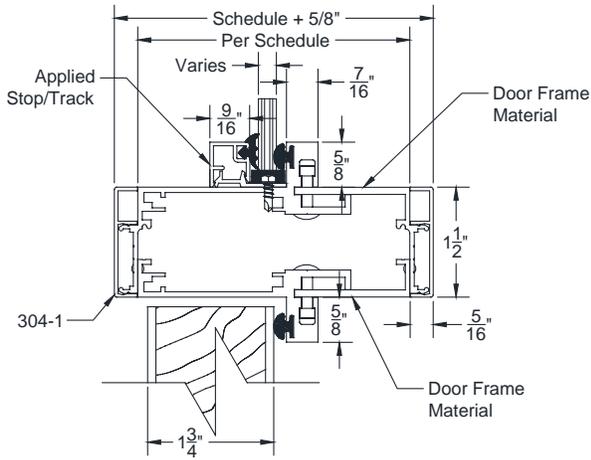


DETAIL 4-11A

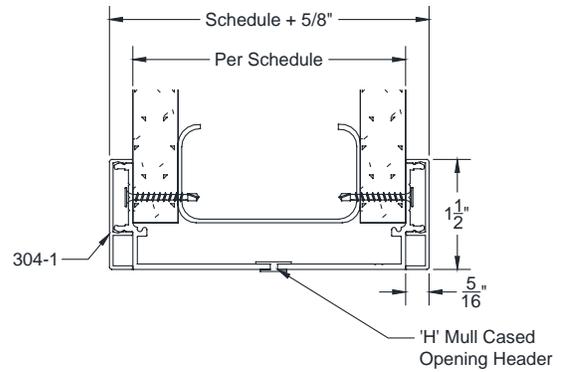


400 System w/ Applied Stop Glazing w/ 304 (5/16" x 1-1/2") Flush Trim

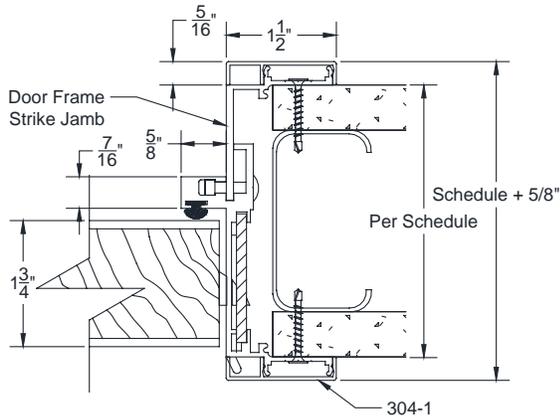
DETAIL 4-12A



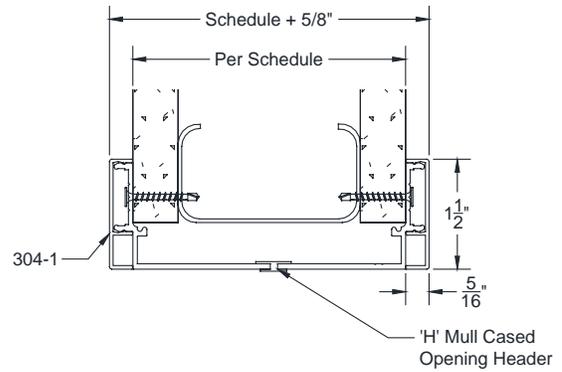
DETAIL 4-13A



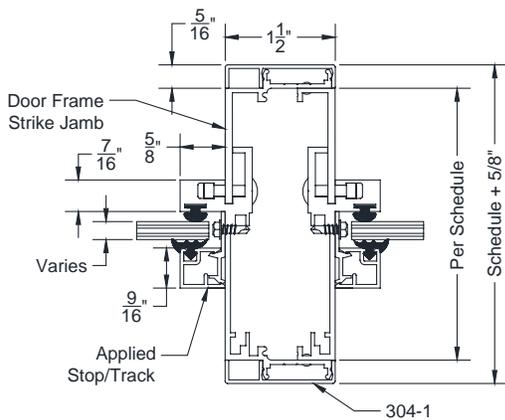
DETAIL 4-14A



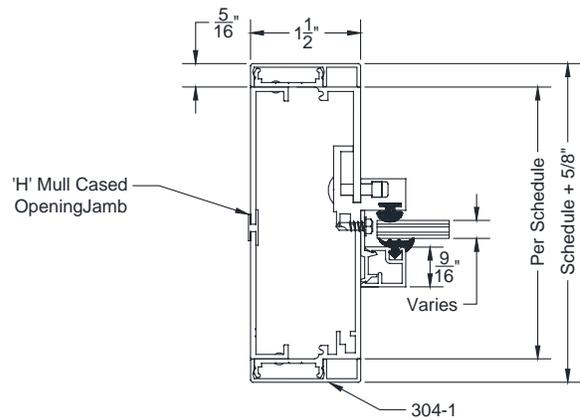
DETAIL 4-15A



DETAIL 4-16A

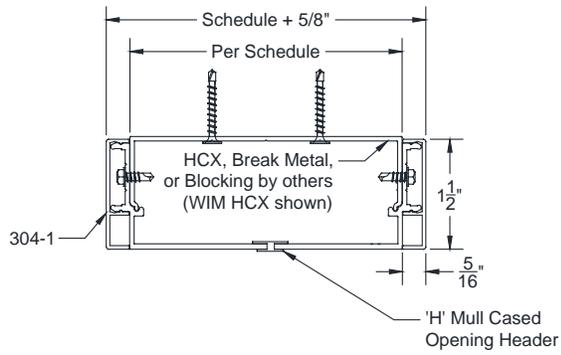


DETAIL 4-17A

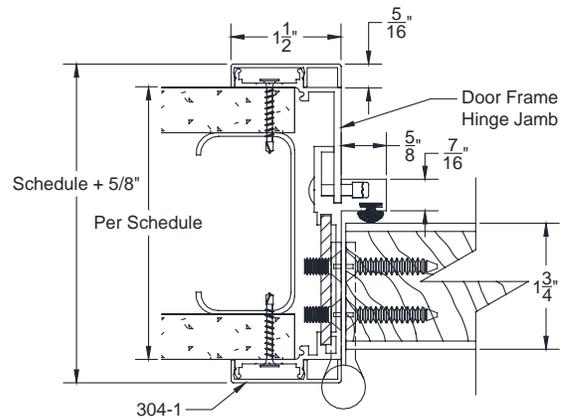


400 System w/ Applied Stop Glazing w/ 304 (5/16" x 1-1/2") Flush Trim

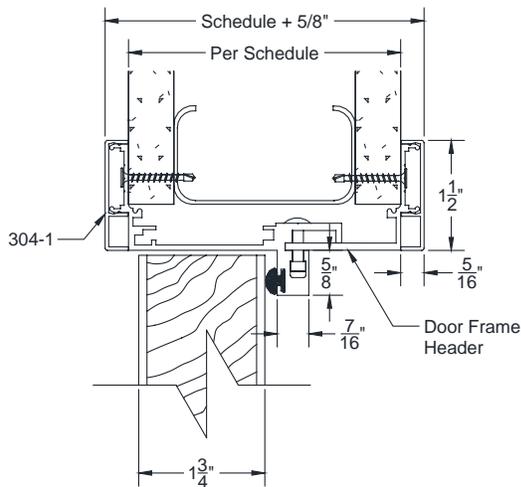
DETAIL 4-18A



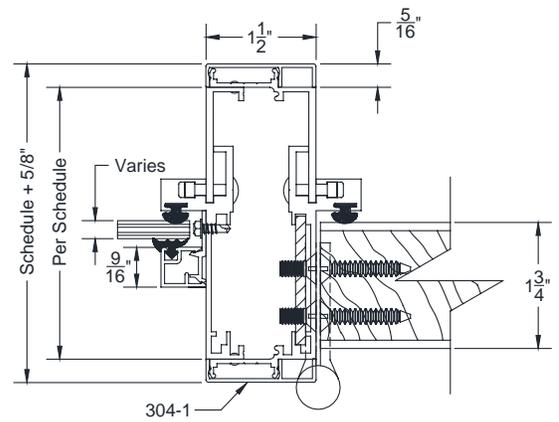
DETAIL 4-19A



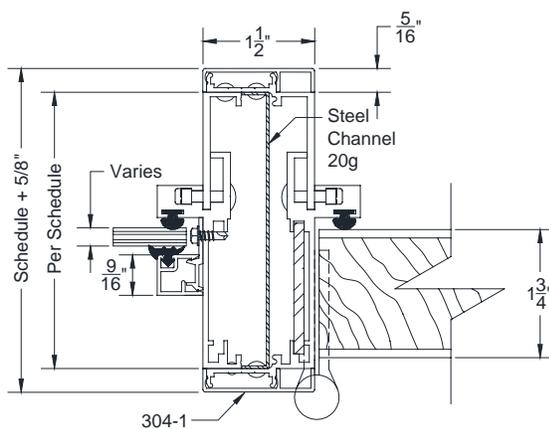
DETAIL 4-20A



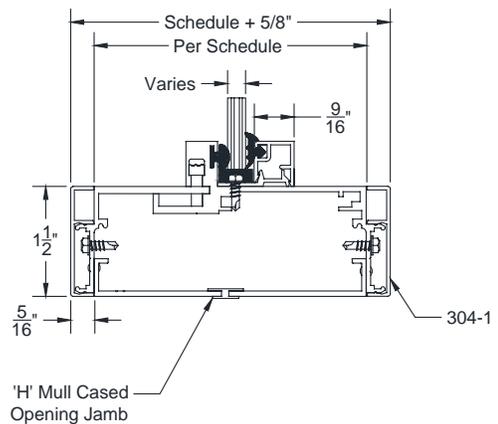
DETAIL 4-21A



DETAIL 4-21Ast

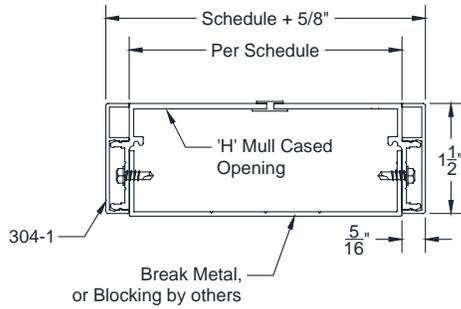


DETAIL 4-22A

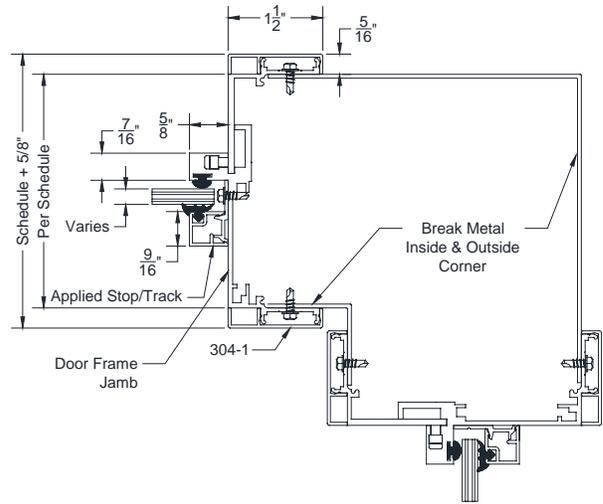


400 System w/ Applied Stop Glazing w/ 304 (5/16" x 1-1/2") Flush Trim

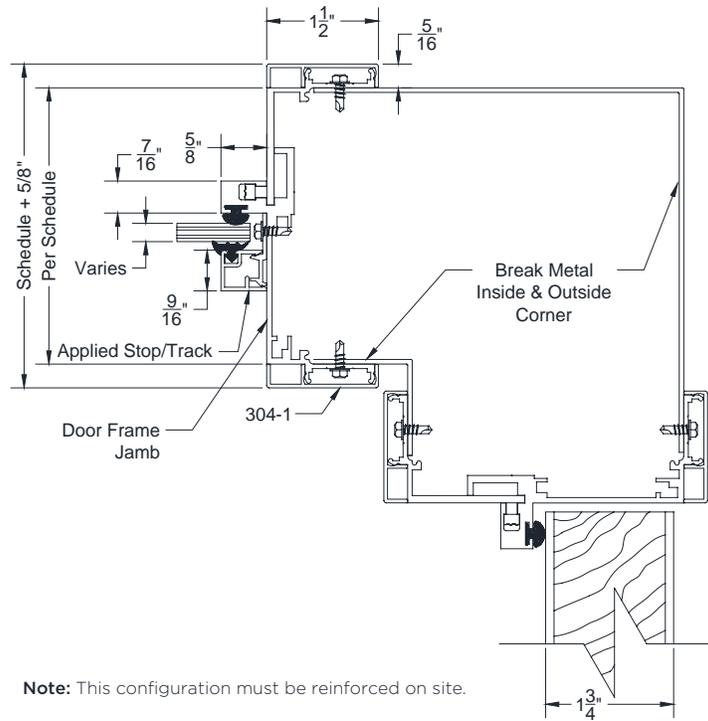
DETAIL 4-23A



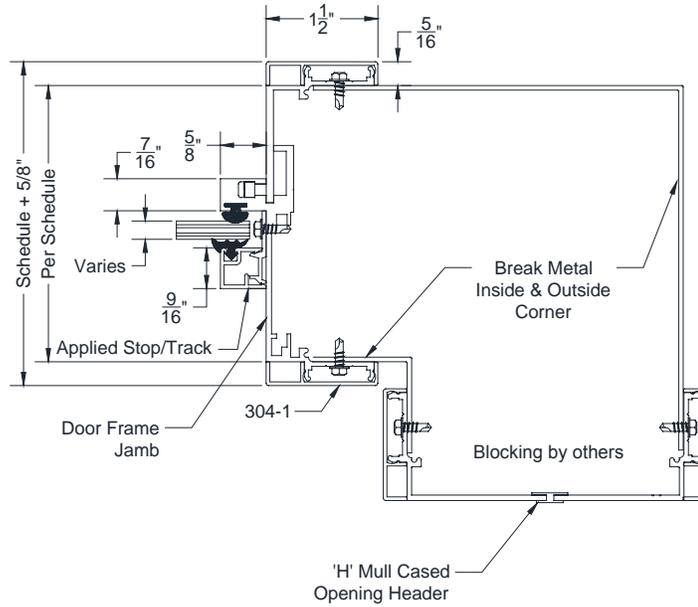
DETAIL 4-24A



DETAIL 4-25A

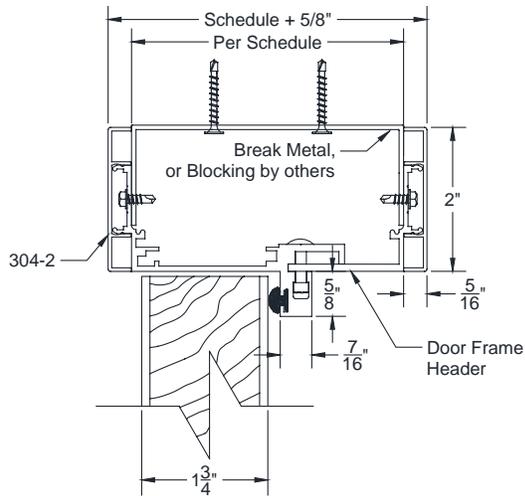


400 System w/ Applied Stop Glazing w/ 304 (5/16" x 1-1/2") Flush Trim
DETAIL 4-26A

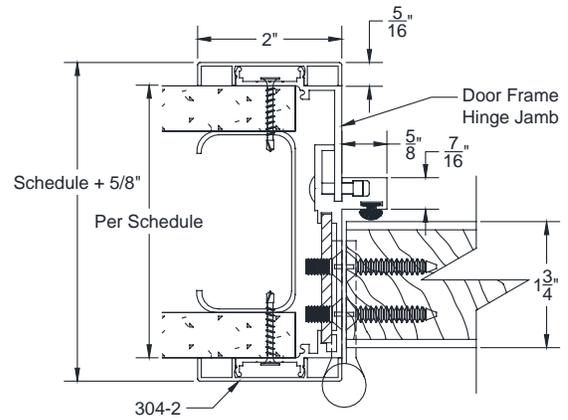


400 System w/ Applied Stop Glazing w/ 304-2 (5/16" x 2") Flush Trim

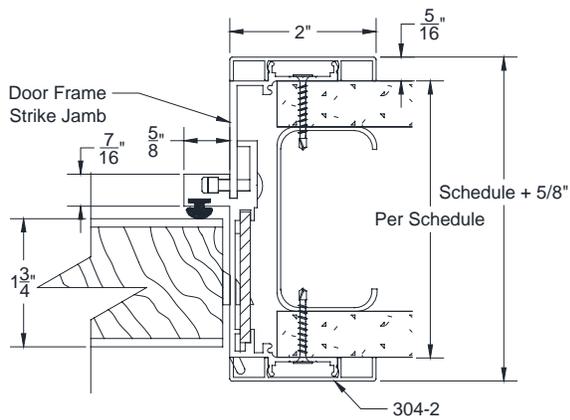
DETAIL 4-1B



DETAIL 4-2B

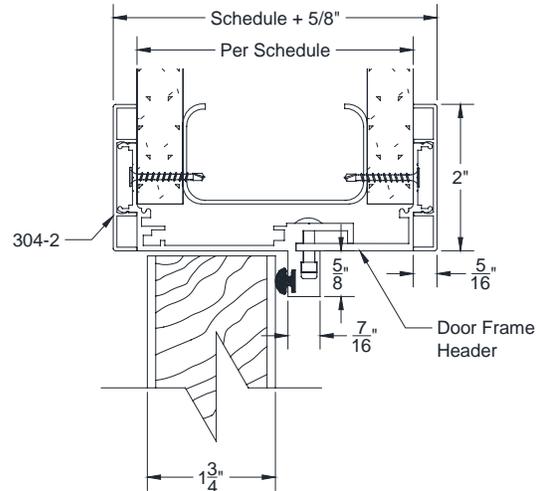


DETAIL 4-3B

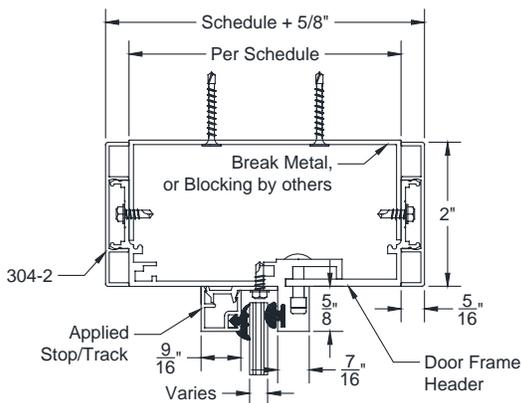


Note: Extended lip strike required.

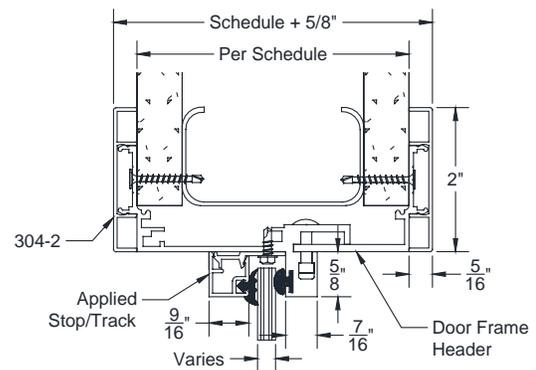
DETAIL 4-4B



DETAIL 4-5B

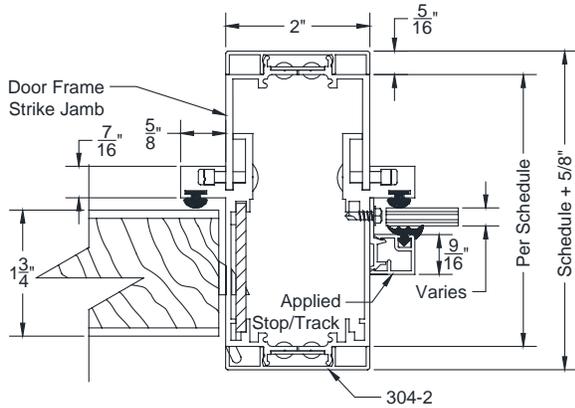


DETAIL 4-6B

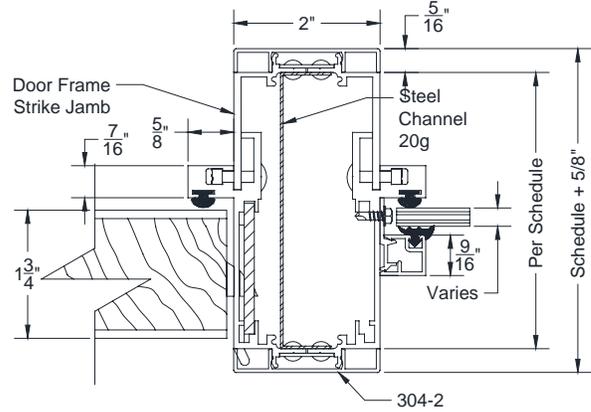


400 System w/ Applied Stop Glazing w/ 304-2 (5/16" x 2") Flush Trim

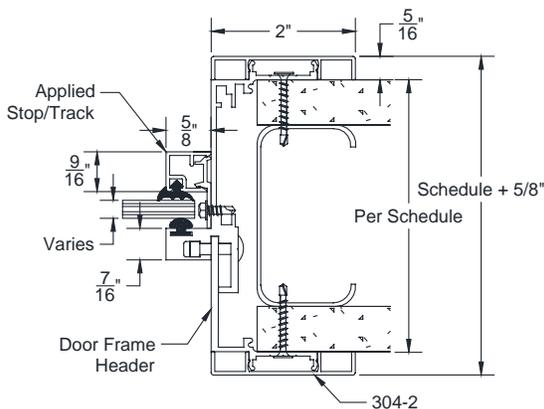
DETAIL 4-7B



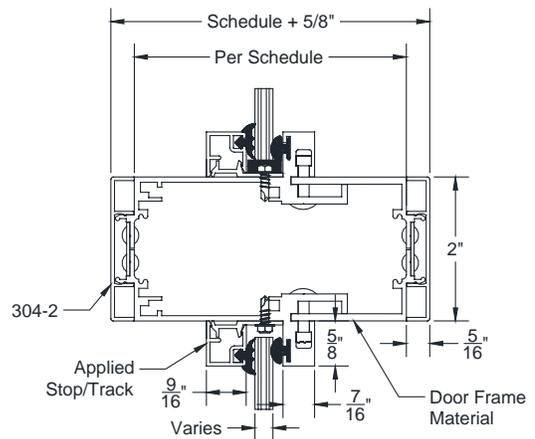
DETAIL 4-7Bst



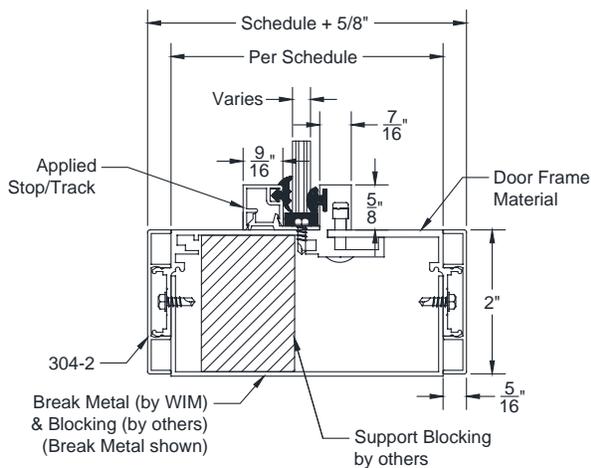
DETAIL 4-8B



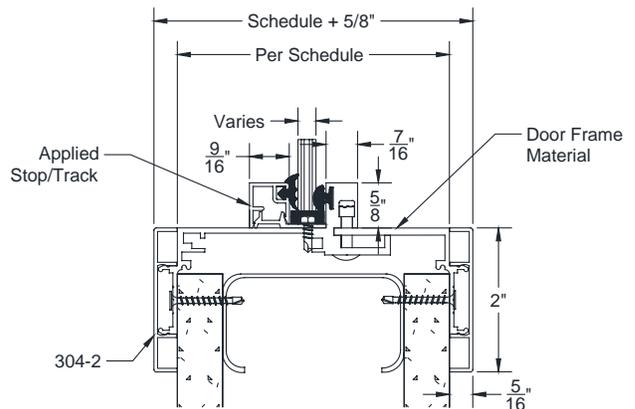
DETAIL 4-9B



DETAIL 4-10B

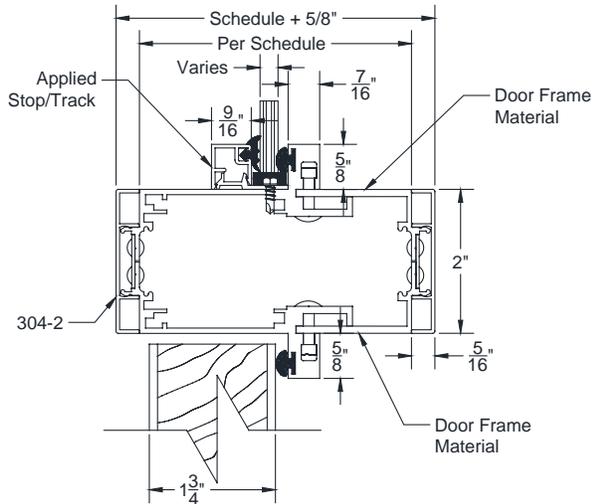


DETAIL 4-11B

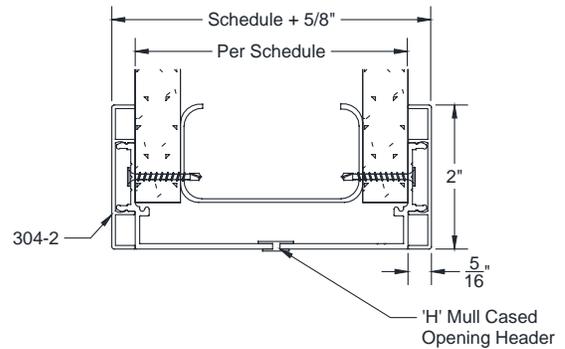


400 System w/ Applied Stop Glazing w/ 304-2 (5/16" x 2") Flush Trim

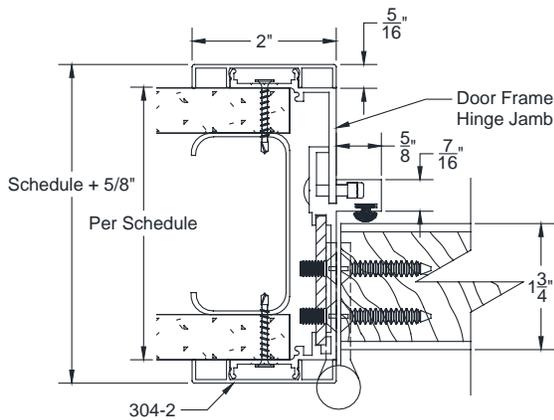
DETAIL 4-12B



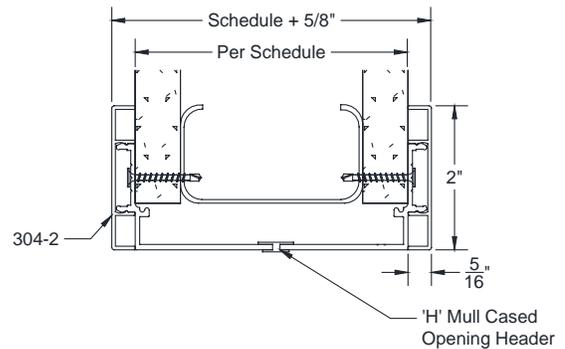
DETAIL 4-13B



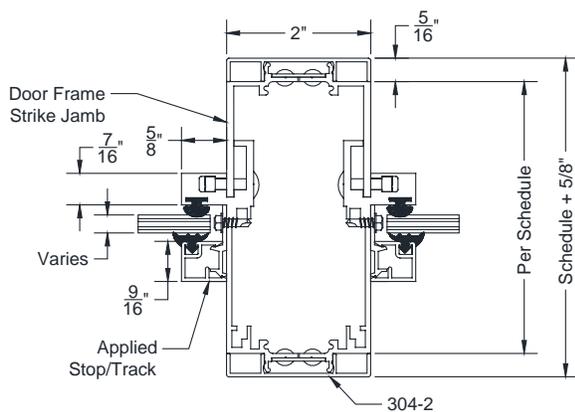
DETAIL 4-14B



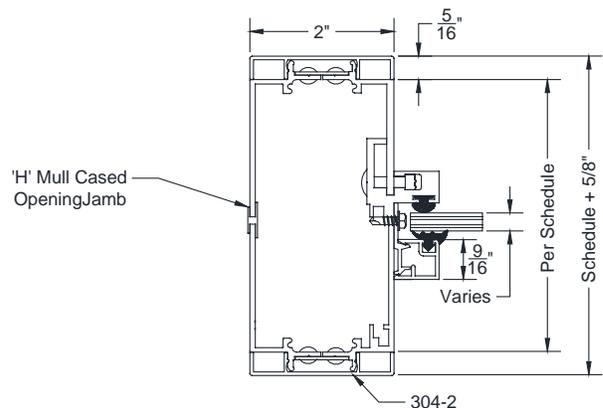
DETAIL 4-15B



DETAIL 4-16B

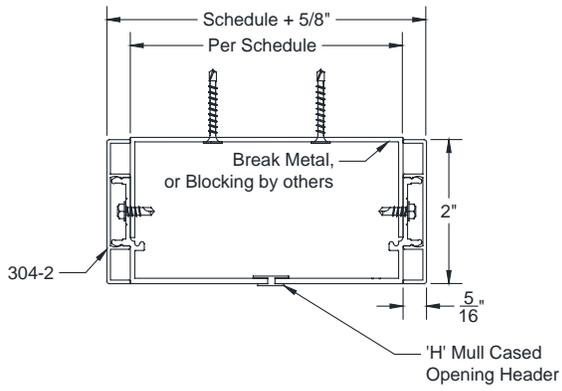


DETAIL 4-17B

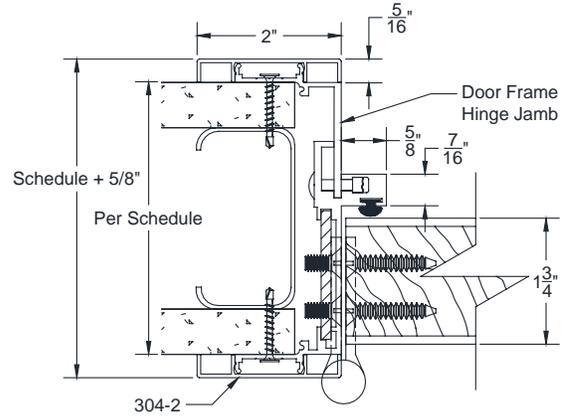


400 System w/ Applied Stop Glazing w/ 304-2 (5/16" x 2") Flush Trim

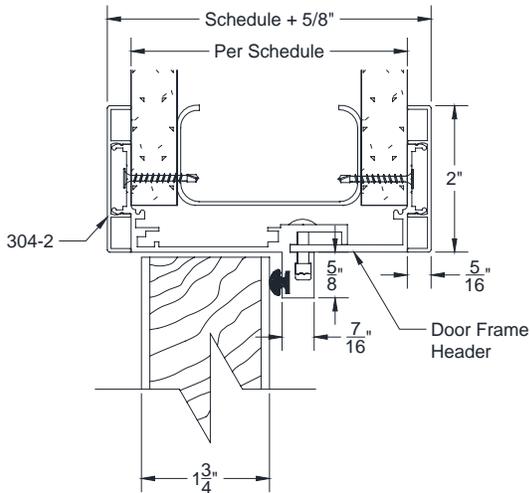
DETAIL 4-18B



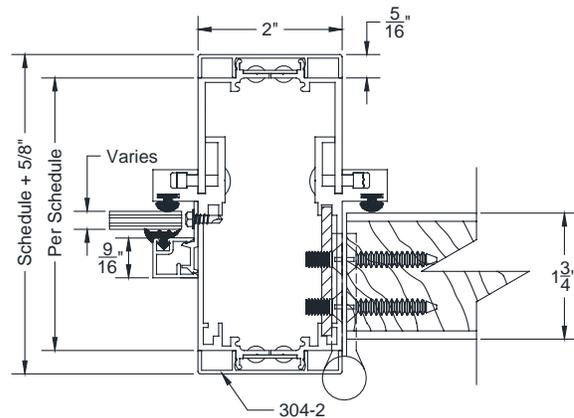
DETAIL 4-19B



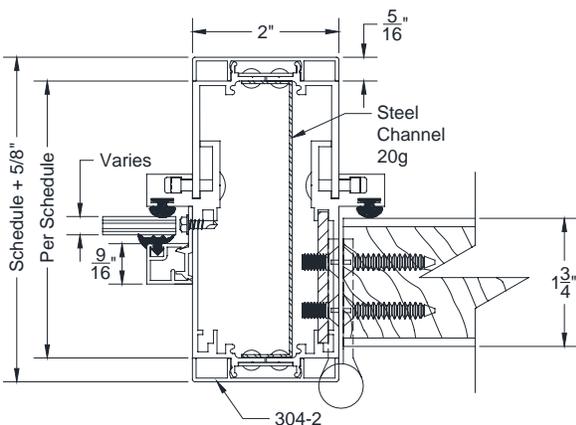
DETAIL 4-20B



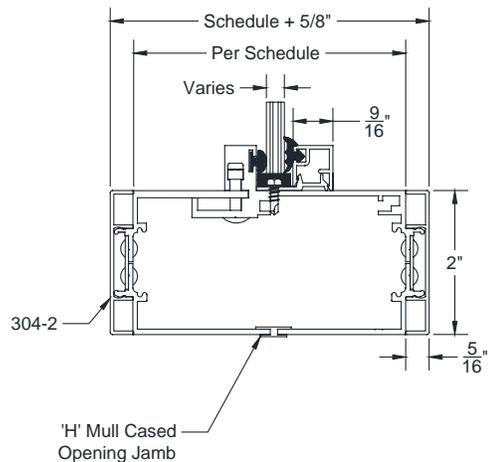
DETAIL 4-21B



DETAIL 4-21Bst

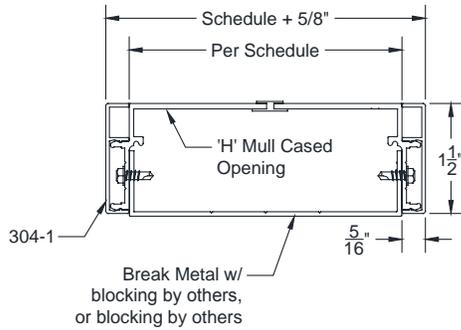


DETAIL 4-22B

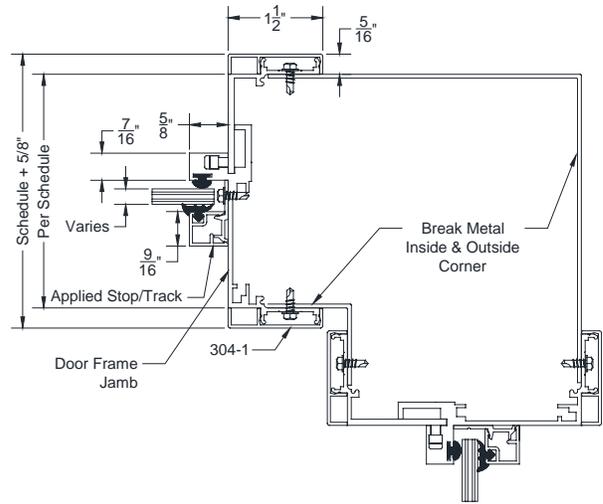


400 System w/ Applied Stop Glazing w/ 304 (5/16" x 1-1/2") Flush Trim

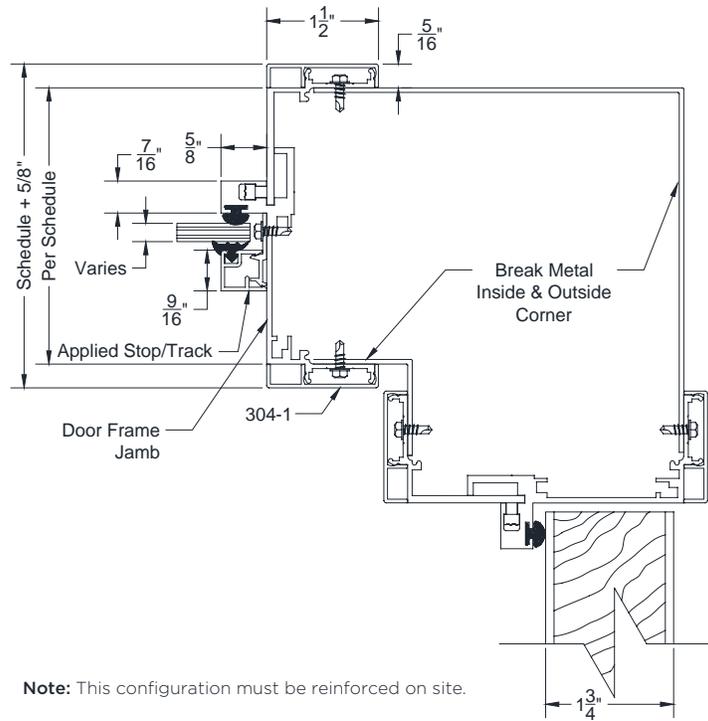
DETAIL 4-23A



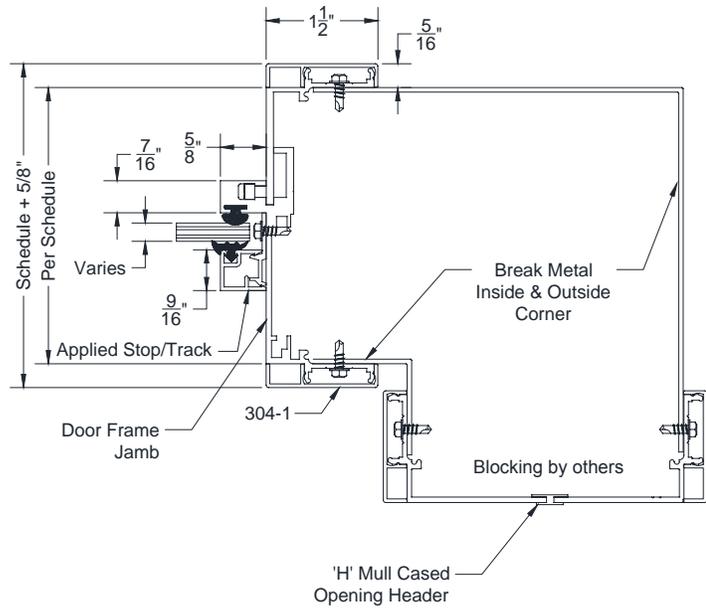
DETAIL 4-24A



DETAIL 4-25A



400 System w/ Applied Stop Glazing w/ 304 (5/16" x 1-1/2") Flush Trim
 DETAIL 4-26A



90 MINUTE FIRE RATED DOOR FRAME

90 Minute Aluminum Door Frame

MAXIMUM ASSEMBLY SIZE

- 4' 0" X 9' 0" Single swing with Pemko smoke seal #PK4 and HSS2000 intumescent on the perimeter of frame, supplied by Western Integrated Materials.
- 8' 0" X 9' 0" Standard pair with Pemko smoke seal #PK4, HSS2000 on the perimeter of the frame supplied by Western Integrated Materials.

THROAT SIZE

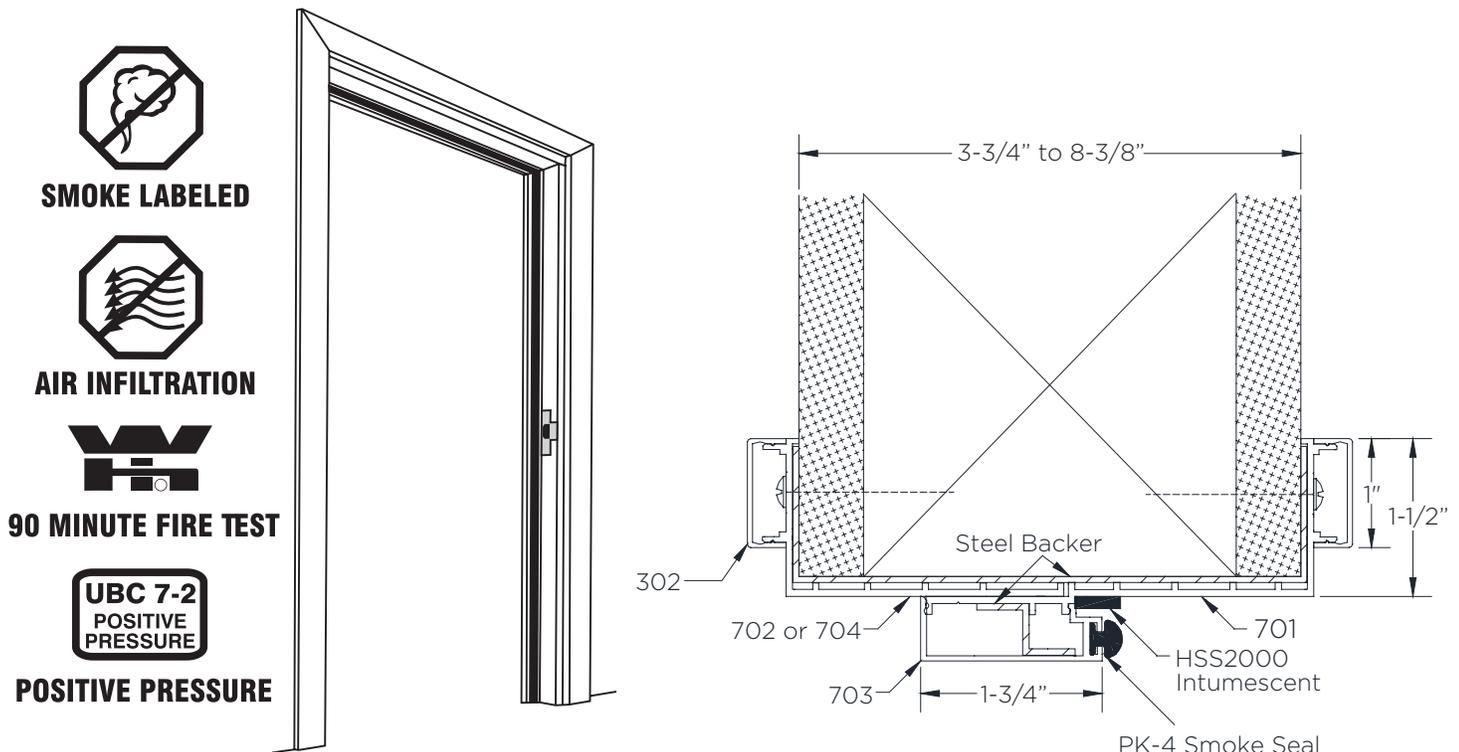
- **Series 700** for special wall thickness from 3-3/4" to 5-7/16" using the 702 Back Leg 1.
- **Series 701** for special wall thickness from 5-1/2" to 8-3/8" using the 704 Back Leg 2.

DOOR TYPE FOR POSITIVE PRESSURE

- Any listed steel 90 minute positive pressure rated doors.

DOOR TYPE FOR NEGATIVE PRESSURE

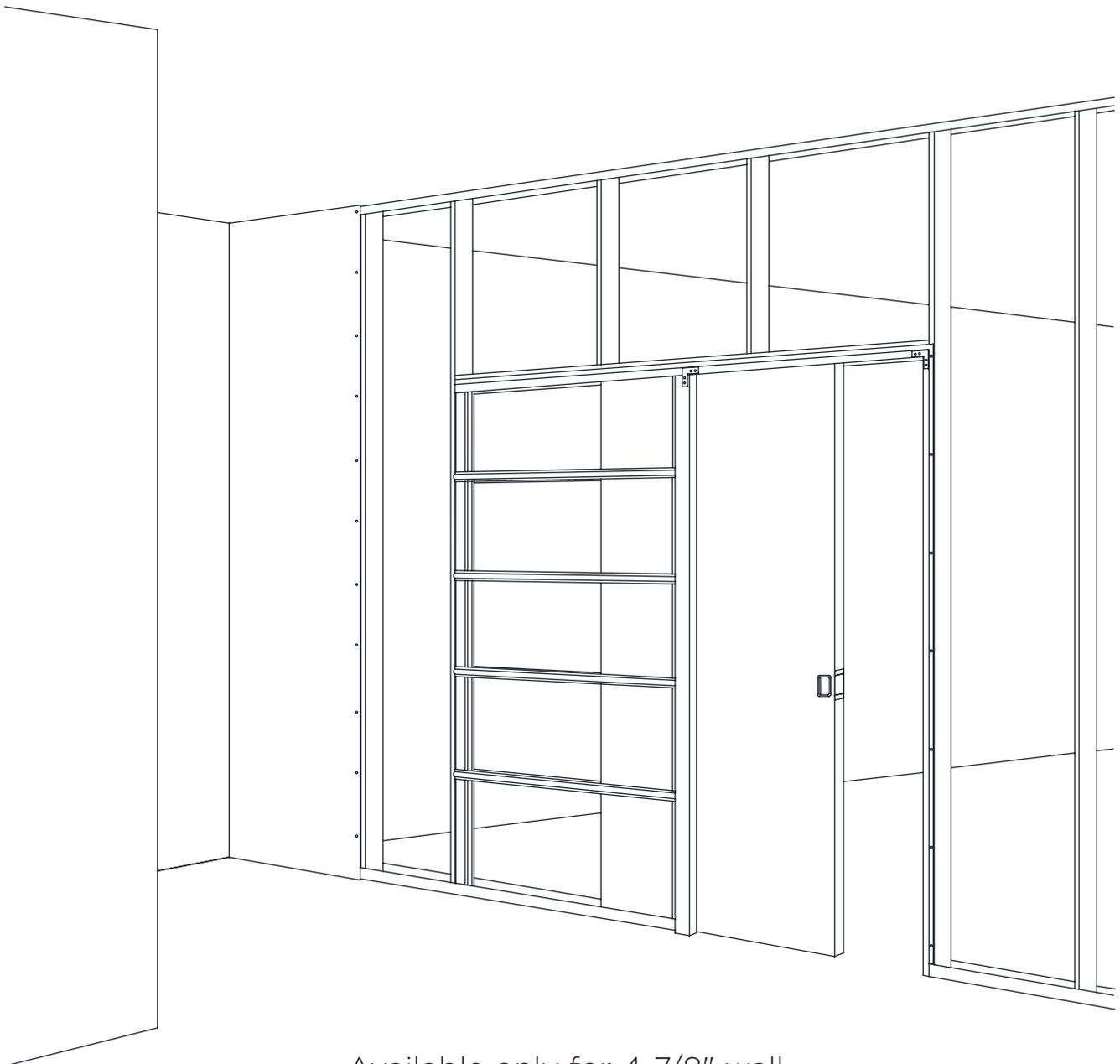
- Any listed Steel or Wood 90 minute negative pressure doors.



POCKET FRAMES

POCKET DOOR FRAME

Our pocket frame allows you to have a disappearing sliding door without building a special wall. The framework is formed from slim, smooth-faced aluminum sections (except the pocket, which is steel) giving an elegant, clean and graceful appearance. Every line and every detail of this advanced design expresses slimness, strength and serviceability.



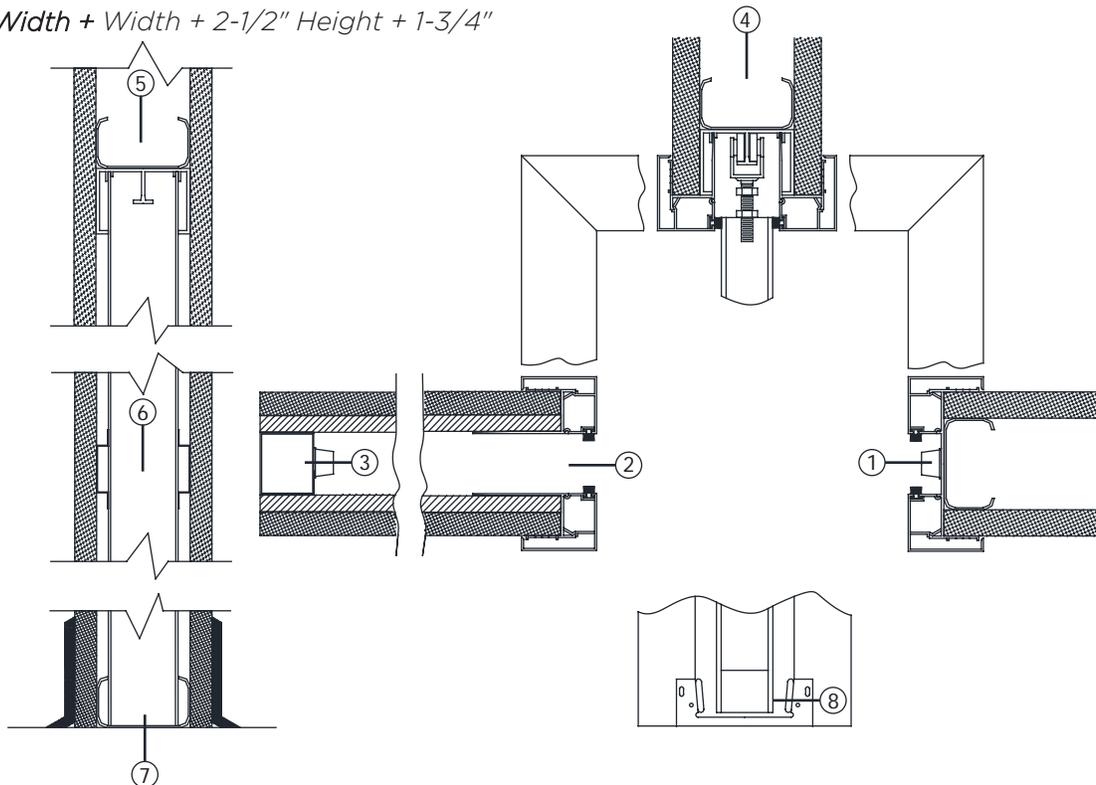
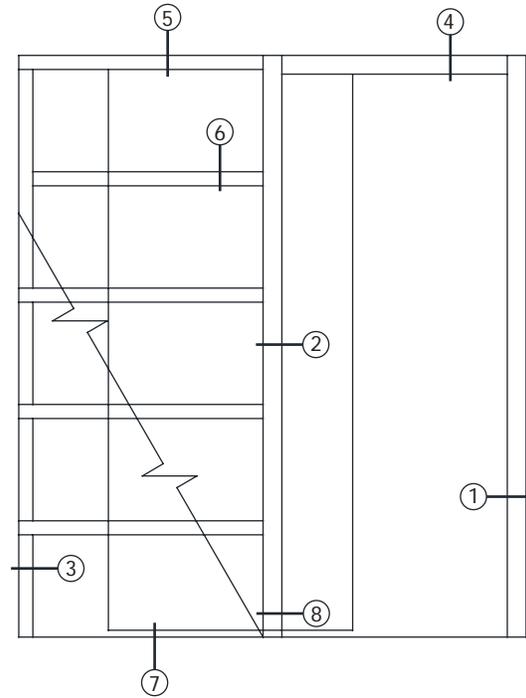
Available only for 4-7/8" wall

Pocket Frame Features:

- We supply you a complete, pre-fabricated frame track built in, the rolling hardware and the trim.
- Compatible with the Western Integrated aluminum swing door or a wood or aluminum door by others.
- The frame and pocket are shipped completely assembled, less door and pull.
- The pocket cavity is completely incombustible.
- The snap on trim can be removed to allow for the installation of a replacement door.
- The floor anchor at the pocket opening allows for precise spacing of the pocket opening.
- The 2" profile snap on trim completes an appealing look, designed to closely resemble our door frames.
- Wall boards are installed after the frame, allowing all the rough work to be completed prior to installation of the finish trim.

Available In: 4-7/8" throat for 1-3/4" door

Rough Opening: Width + Width + 2-1/2" Height + 1-3/4"



OTHER MISCELLANEOUS INFORMATION

STANDARD HINGE / STRIKE LOCATIONS 4-1/2" X 4-1/2" HINGE -- 1-1/2 PAIR

Hinge locations based upon the Door Opening Height to the Top of each hinge cutout.
 Strike location based upon the Door Opening Height to the Center Line of the Strike cutout.

Mortise door for 1/4" backset on hinges.

Loc ID*	Item	80"	81"	82"	83"	84"	85"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Middle Hinge	35-1/4"	35-3/4"	36-1/4"	36-3/4"	37-1/4"	37-3/4"
C	Bottom Hinge	65-1/2"	66-1/2"	67-1/2"	68-1/2"	69-1/2"	70-1/2"
F	Strike	42"	43"	44"	45"	46"	47"
Loc ID*	Item	86"	87"	88"	89"	90"	91"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Middle Hinge	38-1/4"	38-3/4"	39-1/4"	39-3/4"	40-1/4"	40-3/4"
C	Bottom Hinge	71-1/2"	72-1/2"	73-1/2"	74-1/2"	75-1/2"	76-1/2"
F	Strike	48"	49"	50"	51"	52"	53"
Loc ID*	Item	92"	93"	94"	95"	96"	97"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Middle Hinge	41-1/4"	41-3/4"	42-1/4"	42-3/4"	43-1/4"	43-3/4"
C	Bottom Hinge	77-1/2"	78-1/2"	79-1/2"	80-1/2"	81-1/2"	82-1/2"
F	Strike	54"	55"	56"	57"	58"	59"
Loc ID*	Item	98"	99"	100"	101"	102"	103"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Middle Hinge	44-1/4"	44-3/4"	45-1/4"	45-3/4"	46-1/4"	46-3/4"
C	Bottom Hinge	83-1/2"	84-1/2"	85-1/2"	86-1/2"	87-1/2"	88-1/2"
F	Strike	60"	61"	62"	63"	64"	65"
Loc ID*	Item	104"	105"	106"	107"	108"	109"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Middle Hinge	47-1/4"	47-3/4"	48-1/4"	48-3/4"	49-1/4"	49-3/4"
C	Bottom Hinge	89-1/2"	90-1/2"	91-1/2"	92-1/2"	93-1/2"	94-1/2"
F	Strike	66"	67"	68"	69"	70"	71"

STANDARD HINGE / STRIKE LOCATIONS 4-1/2" X 4-1/2" HINGE -- 1 PAIR

Loc ID*	Item	80"	81"	82"	83"	84"	85"
A	Top Hinge	5"	5"	5"	5"	5"	5"
C	Bottom Hinge	65-1/2"	66-1/2"	67-1/2"	68-1/2"	69-1/2"	70-1/2"
F	Strike	42"	43"	44"	45"	46"	47"

* See adjoining shop drawing.

Aluminum Door Frame Machine Details - 1-1/2 Pair Butts

Western Integrated Materials, Inc.		DRAWING NO:	P. O. NO:
Corp. Hq. Mfg., Tech. and Sales • 3310 E. 59th St. • Long Beach, CA 90805 (562) 634-2823 • Fax: (562) 634-8449 • www.aluminumdoorframes.com		Prepared by:	Customer:
Head Condition: <input type="checkbox"/> Wrap Drywall <input type="checkbox"/> <input type="checkbox"/>		Date Prepared:	Job Name:
View of Frame is NOT Corridor/Office Specific - Not to Scale			
<input type="checkbox"/> Mitered <input type="checkbox"/> Square <input type="checkbox"/> No <input type="checkbox"/> 1/2" X <input type="checkbox"/> 3/4" <input type="checkbox"/> 0"			
Rough Opening = 1 1/2" X 3/4"		SPECIAL INSTRUCTIONS / COMMENTS	
Finish	Series	Throat Size	Frame Mohair or Vinyl Bulb / Mohair / Bulb / Vinyl Color
N/A	N/A	1/4" Hinge Backset on Doors	Std Wt. 4-1/2" Hinge and ASA Strike Preps UON
TRIM:			
LH / RHR			
QTY:	NO.'s:		

STANDARD HINGE / STRIKE LOCATIONS 4-1/2" X 4-1/2" HINGE -- 2 PAIR

Hinge locations based upon the Door Opening Height to the Top of each hinge cutout.
 Strike location based upon the Door Opening Height to the Center Line of the Strike cutout.

Mortise door for 1/4" backset on hinges.

Loc ID*	Item	80"	81"	82"	83"	84"	85"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Top Middle Hinge	25-1/4"	25-1/2"	25-7/8"	26-1/4"	26-1/2"	26-7/8"
C	Bottom Middle Hinge	45-1/2"	46"	46-3/4"	47-1/2"	48"	48-3/4"
D	Bottom Hinge	65-3/4"	66-1/2"	67-5/8"	68-3/4"	69-1/2"	70-5/8"
F	Strike	42"	43"	44"	45"	46"	47"
Loc ID*	Item	86"	87"	88"	89"	90"	91"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Top Middle Hinge	27-1/4"	27-1/2"	27-7/8"	28-1/4"	28-1/2"	28-7/8"
C	Bottom Middle Hinge	49-1/2"	50"	50-3/4"	51-1/2"	52"	52-3/4"
D	Bottom Hinge	71-3/4"	72-1/2"	73-5/8"	74-3/4"	75-1/2"	76-5/8"
F	Strike	48"	49"	50"	51"	52"	53"
Loc ID*	Item	92"	93"	94"	95"	96"	97"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Top Middle Hinge	29-1/4"	29-1/2"	29-7/8"	30-1/4"	30-1/2"	30-7/8"
C	Bottom Middle Hinge	53-1/2"	54"	54-3/4"	55-1/2"	56"	56-3/4"
D	Bottom Hinge	77-3/4"	78-1/2"	79-5/8"	80-3/4"	81-1/2"	82-5/8"
F	Strike	54"	55"	56"	57"	58"	59"
Loc ID*	Item	98"	99"	100"	101"	102"	103"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Top Middle Hinge	31-1/4"	31-1/2"	31-7/8"	32-1/4"	32-1/2"	32-7/8"
C	Bottom Middle Hinge	57-1/2"	58"	58-3/4"	59-1/2"	60"	60-3/4"
D	Bottom Hinge	83-3/4"	84-1/2"	85-5/8"	86-3/4"	87-1/2"	88-5/8"
F	Strike	60"	61"	62"	63"	64"	65"
Loc ID*	Item	104"	105"	106"	107"	108"	109"
A	Top Hinge	5"	5"	5"	5"	5"	5"
B	Top Middle Hinge	33-1/4"	33-1/2"	33-7/8"	34-1/4"	34-1/2"	34-7/8"
C	Bottom Middle Hinge	61-1/2"	62"	62-3/4"	63-1/2"	64"	64-3/4"
D	Bottom Hinge	89-3/4"	90-1/2"	91-5/8"	92-3/4"	93-1/2"	94-5/8"
F	Strike	66"	67"	68"	69"	70"	71"

STANDARD HINGE / STRIKE LOCATIONS - DUTCH DOOR

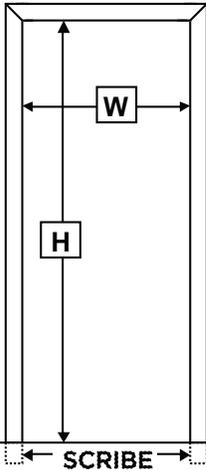
Loc ID*	Item	80"	84"
A	Top Hinge	5"	5"
B	Top Middle Hinge	30-1/2"	32-1/2"
C	Bottom Middle Hinge	45"	47"
D	Bottom Hinge	65-1/2"	69-1/2"
F	Strike	44"	46"

* See adjoining shop drawing.

Aluminum Door Frame Machine Details - 2 Pair Butts

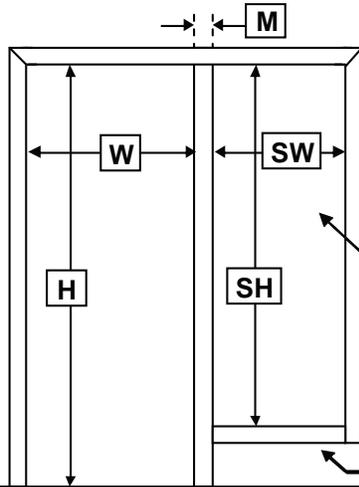
Western Integrated Materials, Inc.		DRAWING NO:	P. O. NO:
Corp. Hq. Mfg., Tech. and Sales • 3310 E. 59th St. • Long Beach, CA 90805 (562) 634-2823 • Fax: (562) 634-8449 • www.aluminumdoorframes.com		Prepared by:	Customer:
		Date Prepared:	Job Name:
Head Condition: <input type="checkbox"/> Wrap Drywall		View of Frame is NOT Corridor/Office Specific - Not to Scale	
<input type="checkbox"/> Mitered <input type="checkbox"/> Square		Scribe <input type="checkbox"/> No <input type="checkbox"/> 0'	
Rough Opening = 1 1/2" X 3/4"		SPECIAL INSTRUCTIONS / COMMENTS	
Finish	Series	Throat Size	Frame Mohair or Vinyl Bulb / Mohair / Bulb / Vinyl Color
		N/A	
TRIM:		1/4" Hinge Backset on Doors	
LH / RHR		Std Wt. 4-1/2" Hinge and ASA Strike Preps UON	
QTY:		NO. S:	

DOOR FRAME



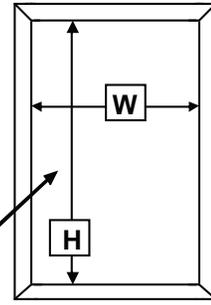
Rough Opening Width = $W + 1\frac{1}{2}''$
Rough Opening Height = $H + \frac{3}{4}''$

DOOR FRAME / SIDELIGHT



Rough Opening Width = $W + M + SW + 1\frac{1}{2}''$
Rough Opening Height @ Door = $H + \frac{3}{4}''$
Rough Opening Height @ Sidelight = $SH + 1\frac{1}{2}''$

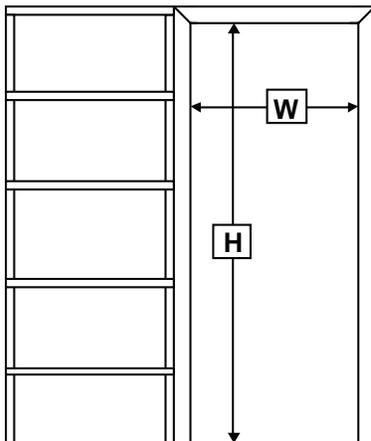
BORROWED LIGHT



Glass Size is $\frac{7}{16}''$ Over Visible Area

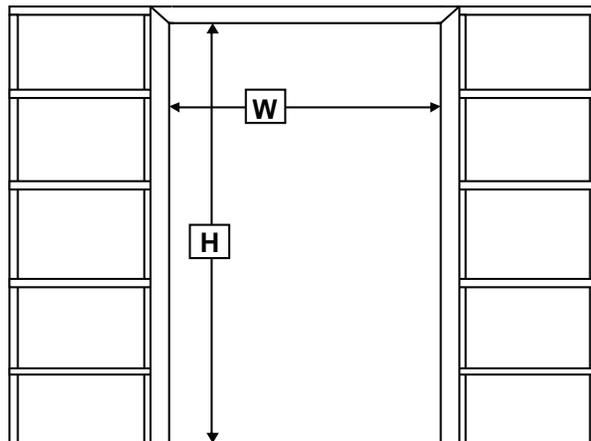
Rough Opening Width = $W + 1\frac{1}{2}''$
Rough Opening Height = $H + 1\frac{1}{2}''$

**SINGLE DOOR
POCKET FRAME**



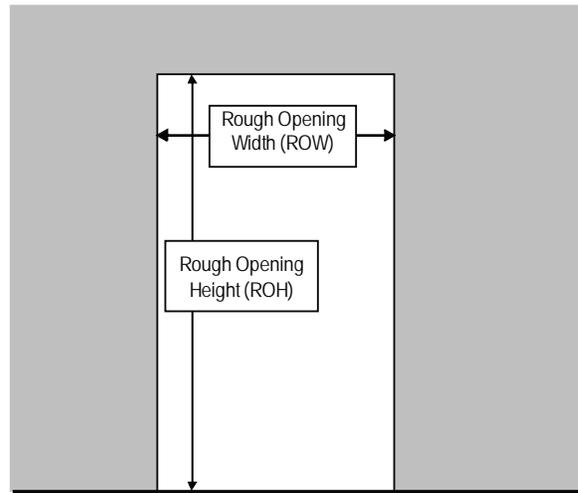
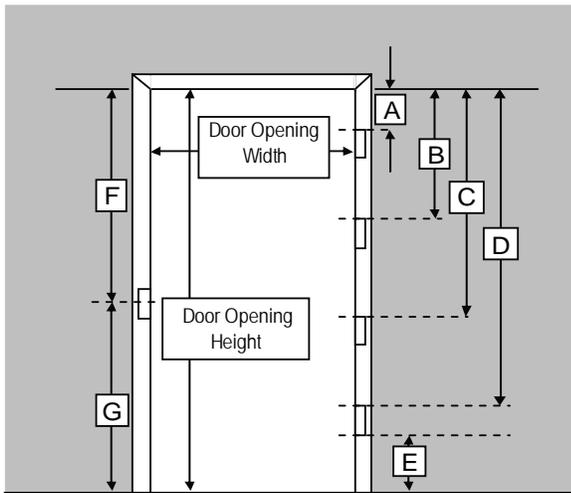
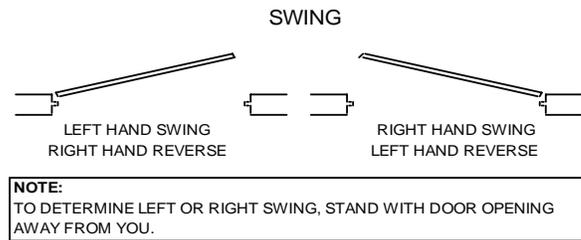
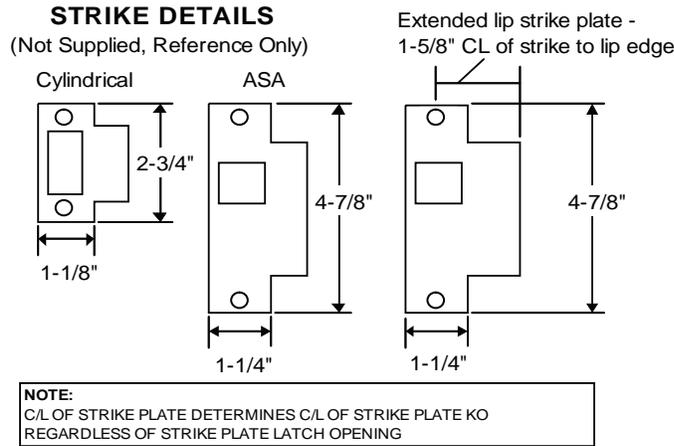
Rough Opening Width = $W + W + 2\frac{1}{2}''$
Rough Opening Height = $H + 1\frac{3}{4}''$

**DOUBLE DOOR
POCKET FRAME**

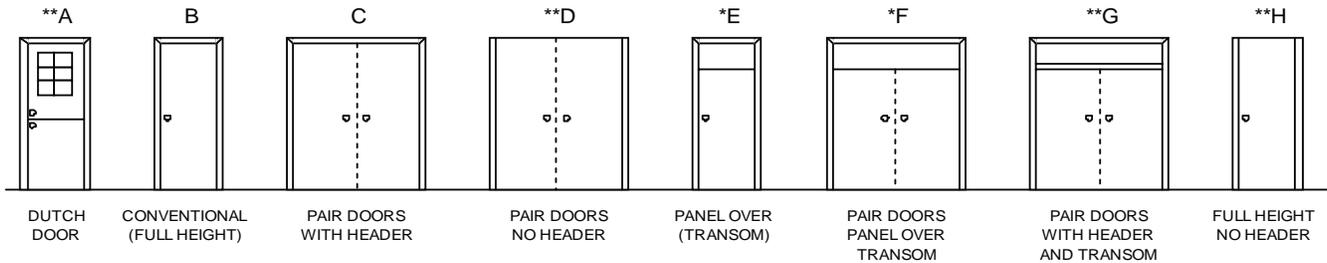


Rough Opening Width = $W + W + 2\frac{1}{2}''$
Rough Opening Height = $H + 1\frac{3}{4}''$

Misc. Information



DOOR TYPES ALL SERIES



NOTES: * Negative Pressure Rated w/wood above. ** Not rated.

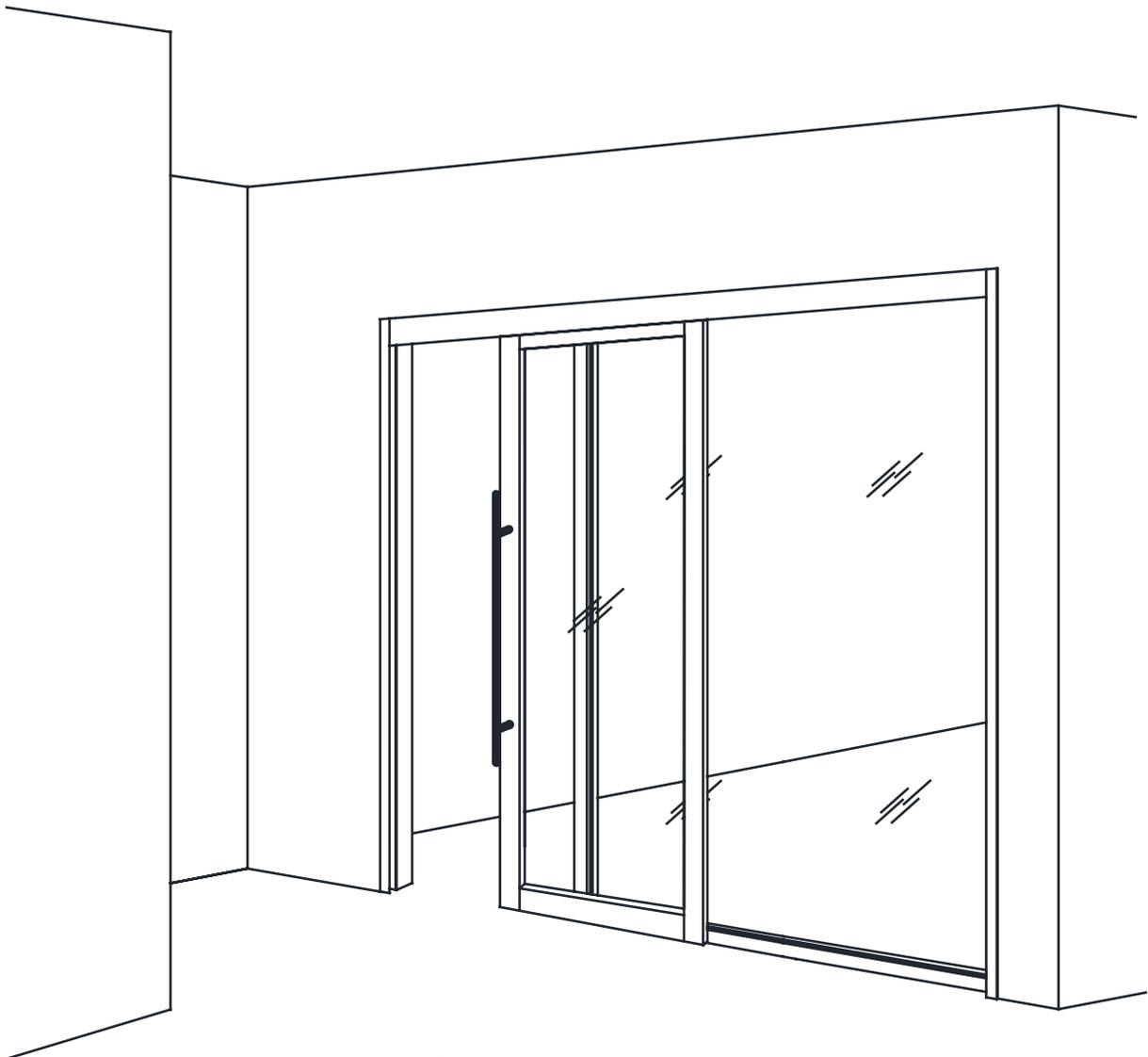
ALUMINUM SWING AND SLIDING DOORS

Alumaglide®

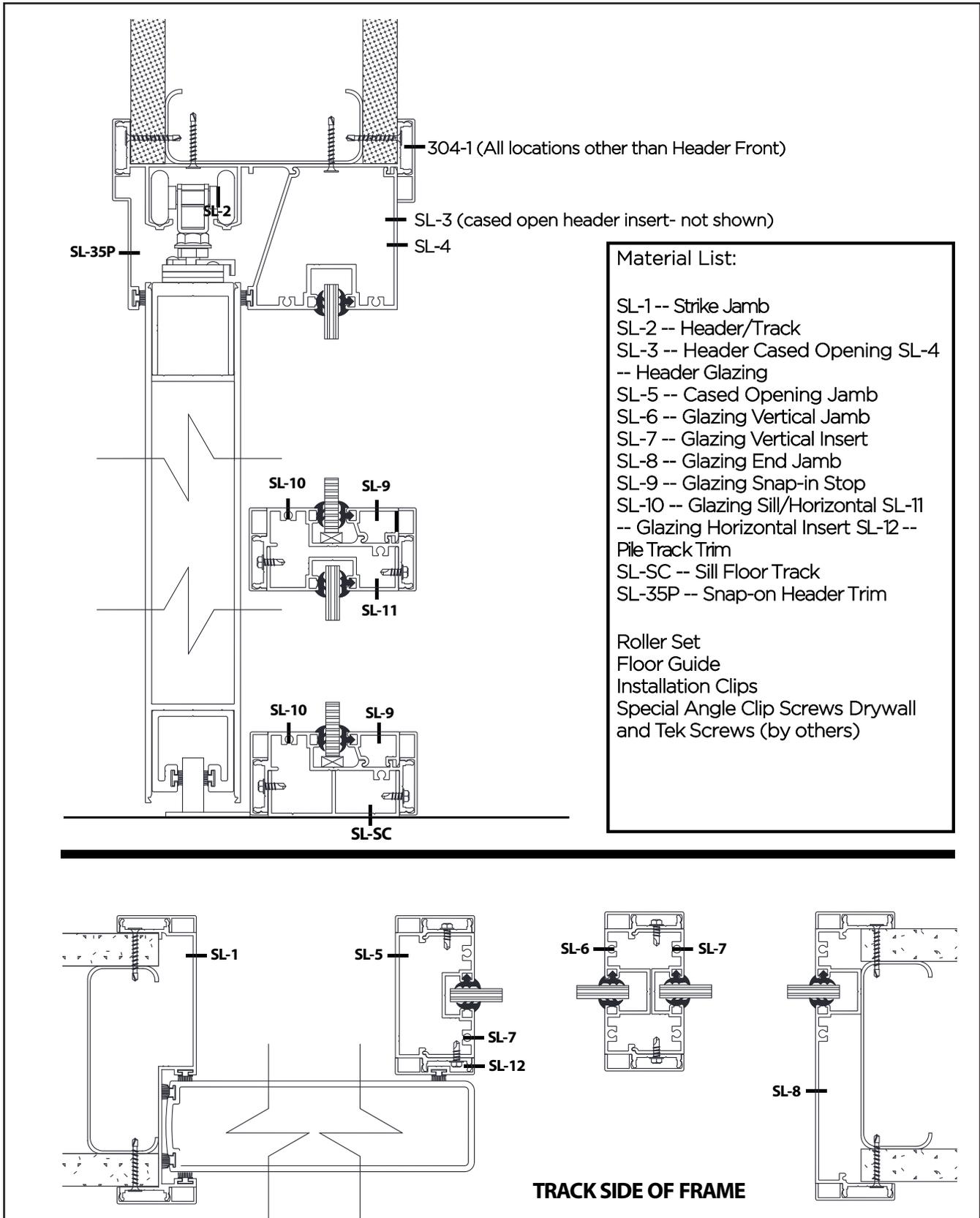
Interior Trackless Sliding Door System

Alumaglide®, Western Integrated Materials' aluminum interior trackless sliding door system can be matched to virtually any decor.

With its clean sight lines, functionality and many design options, it is the reason why architects, designers and spec writers choose the Alumaglide® sliding door system over all others.

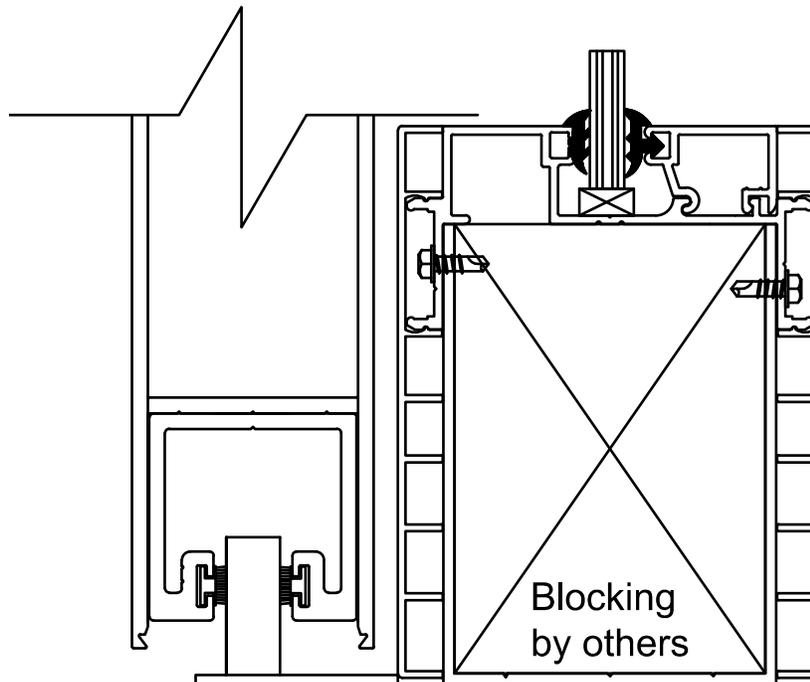


Available for 4-7/8" or 5" walls in Clear Anodized Only



Alumaglide® 4" Sill Trim Option

Optional 4" Sill Break Metal U-Channel w/ 4" Sill Trim
(Blocking Reinforcement by others)



ALUMINUM SWING DOORS

by Western Integrated Materials



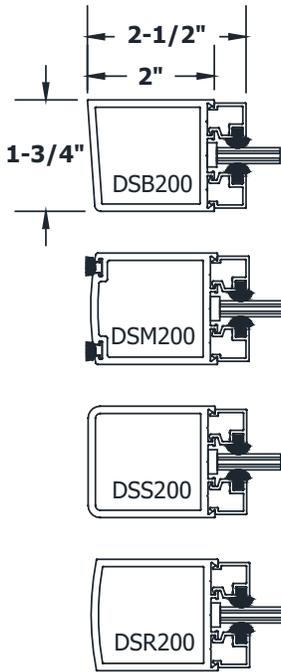
Features:

- Narrow, Medium and Wide Stile Doors
- Many Glass Options
- Special Preps Available
- Horizontal Muntins
- Heavy Duty Construction
- Welded Joint Corners
- LEED Certified
- 6063 T-6 Aluminum Alloy
- ADA Title 24 Compliant

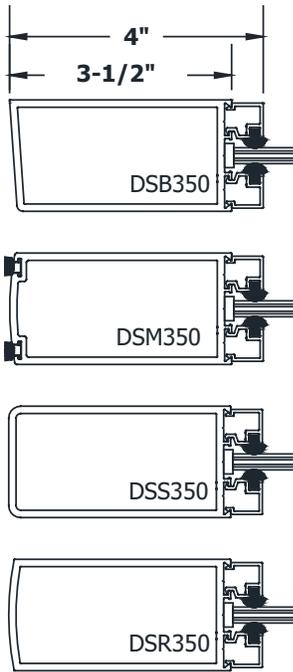
***Door and Frame Packages Available
from One Location!***

Door Extrusions

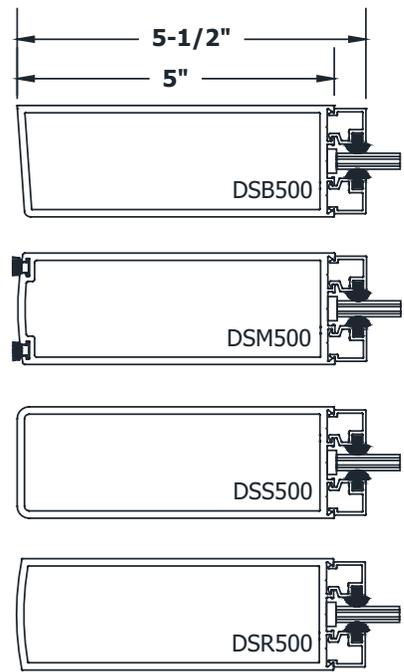
NARROW STILES



MEDIUM STILES



WIDE STILES

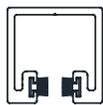


TOP & BOTTOM RAIL OPTIONS

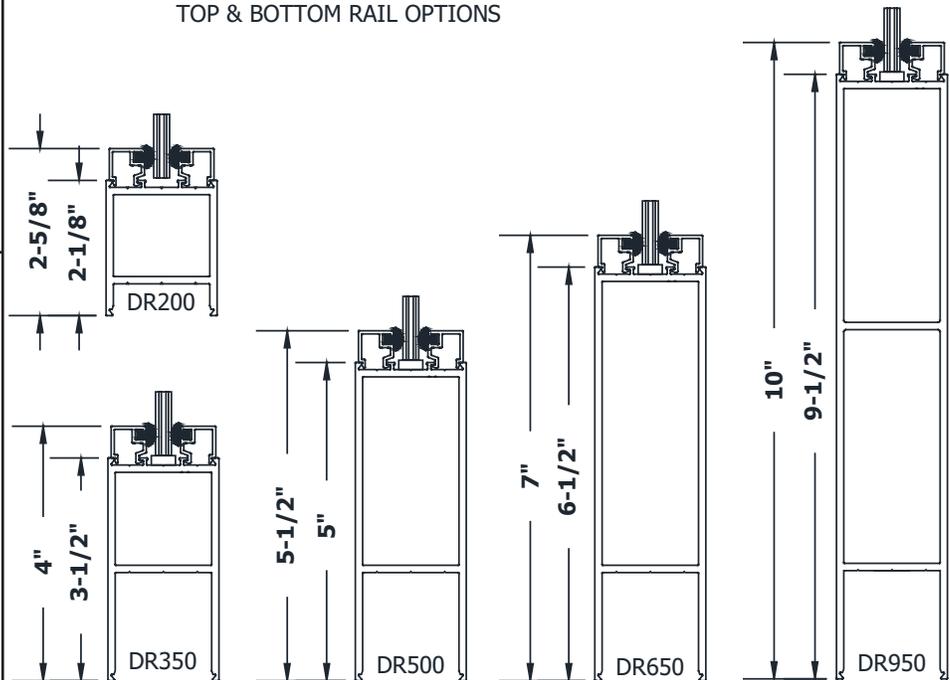
Standard $\frac{1}{4}$ " / $\frac{3}{8}$ " Glass Stop Optional 1" Glass Stop



Floor Guide U-Channel for WIM "Aluma-Glide" Sliding Door System (SBU1500)



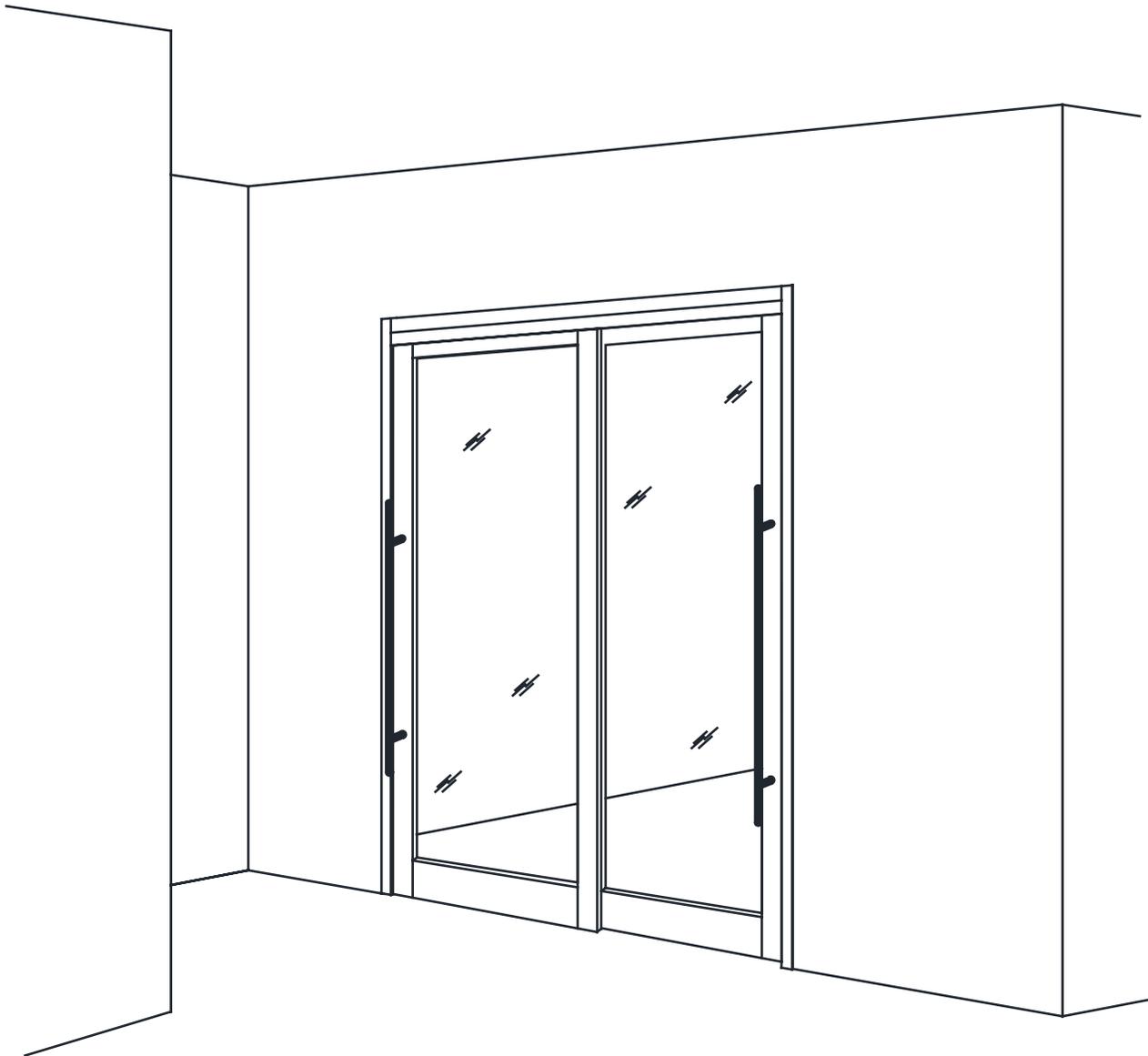
Sliding Top U-Channel for WIM "Aluma-Glide" Sliding Door System (STU1500)



BI-PASS DOOR FRAME

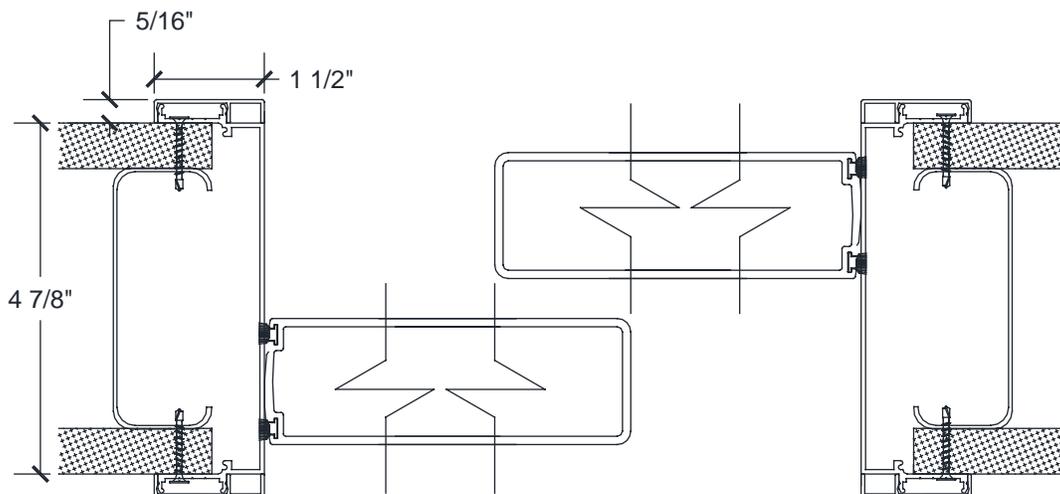
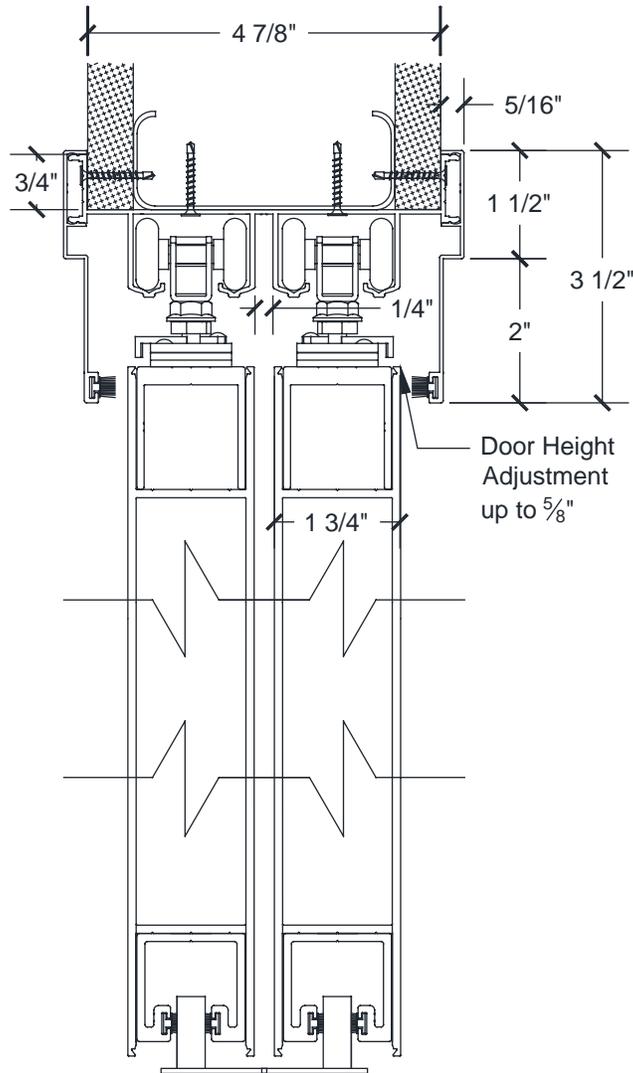
Similar to our Alumaglide® sliding door frame system, our Bi-Pass door frame offers unique serviceability to any office design. It can be used at a closet or as a main entrance, or any other opening that traditional swing doors may be prohibited.

Available in a 4-7/8" throat wall size. Standard finish is Clear Anodized. All other custom finishes are available upon request.



Available only for 4-7/8" wall

BI-PASS DOOR FRAME DETAILS



INSTALLATION INSTRUCTIONS

General Construction Information

Pre-finished Knock-Down Aluminum Door Frame Consisting of Separate Strike and/or Hinge Jamb and a Header Manufactured by Western Integrated Materials, Inc.

1. Extruded from 6063 T5 aluminum with a minimum wall thickness of .062
2. To be supplied with anodized surface of Clear satin, Bronze Anodize, Black Anodize or a specific baked enamel.
3. Manufactured to receive 4-1/2" x 4-1/2" .134 gauge square hinges.
4. Supplied with pre-finished mitered snap-on aluminum casing.
5. Supplied with 1/8" thick aluminum strike and hinge back up, pre-mounted on jambs.
6. Supplied with notch at top of jamb and corner brackets to provide a correct alignments with the header and add to the strength and dimensional stability of the joint.
7. Manufactured to receive a standard 2-3/4" Cylindrical , 3-1/4" Corbin or 4-7/8" A.S.A. strike.
8. Supplied also with vinyl or mohair mute.
9. Frame to be available for 1-3/4" door thickness.

Back Set = 1/4" on the door 7/16" on the frame.

Please Note:

Additional field labor and or cutting may be required during installation of Western Integrated aluminum door frames. i.e. cutting scribe, notching frames for clips, (mullions, muntins) notching trim for clips, etc. Please call our Production department for any additional information.

Door Frame Installation Instructions

1. Frames are fabricated to exact width specified and no clearance is built in.
2. Rough opening should be 1-1/2" wider than the desired width, 3/4" over in height.
3. Determine high side of floor and cut jambs to the required height. Be sure mute is pushed to top of jamb before cutting.
4. Check opening for proper swing, then slip header over the wall. (Fig. 1)
5. Hold jambs at an angle and slip the upper portion over the wall. Push upward to engage notch with door stop on header, then push the rest of the jamb over the wall.(Fig. 2)

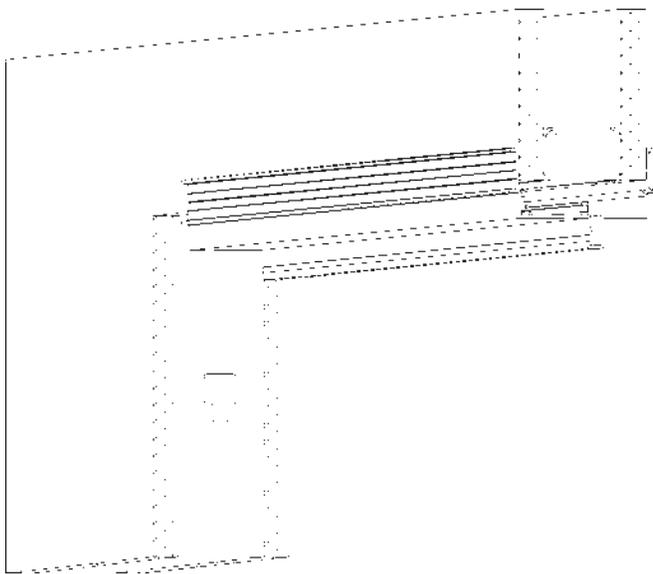


Fig. 1

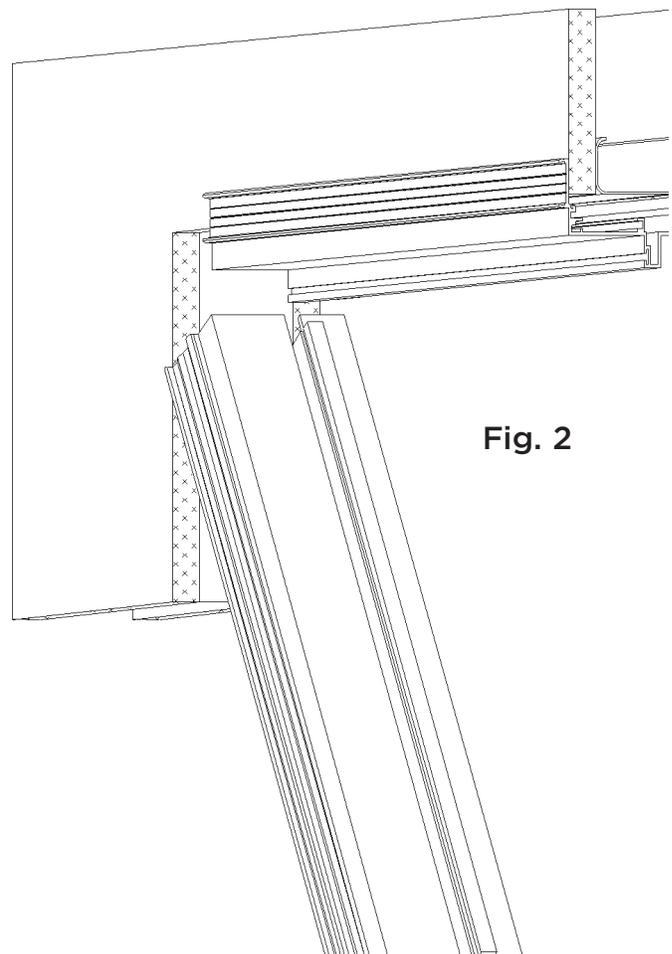


Fig. 2

6. Slide butt jamb down to finished floor. If carpet is to be laid, the base on which it is to be laid shall be considered the finished floor. For other floor coverings, (tile, etc.) the jamb should rest on removable spacers the same thickness as the flooring to be used.
7. Plumb butt side and secure to wall.

8. If door is premortised, hang prefit door and close into opening.
 - a.) If doors are not premortised, then use a square to attain a 90° corner between head & jambs. Head must butt up to vertical edge of clip (Fig. 3) and set flat in alignment groove (Fig. 4). You can then attach clips.
 - b.) Secure head to wall.
 - c.) Use same procedure for strike jamb.
9. Pull header down to door, allowing 1/8" spacing. Install corner clips (Fig. 3 & 4) and secure to wall.
10. Pull strike jamb into position and align with corner clips and door edge. Secure to wall.
11. If required, cut trim to length. Install trim. Trim should fit snugly. If there is any tendency to rattle, give full length a slight twist before installing.

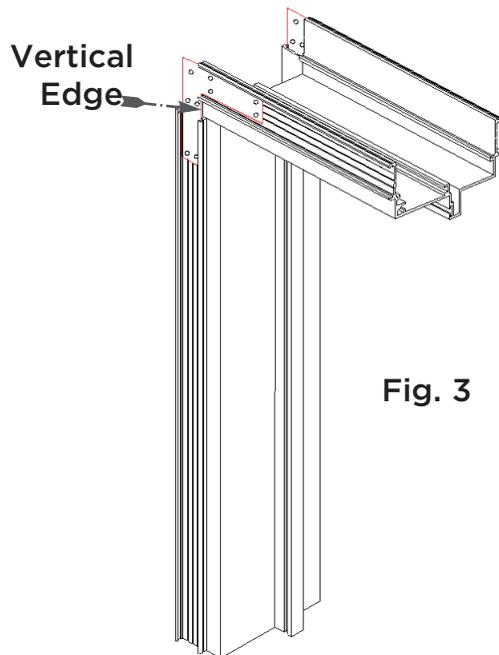


Fig. 3

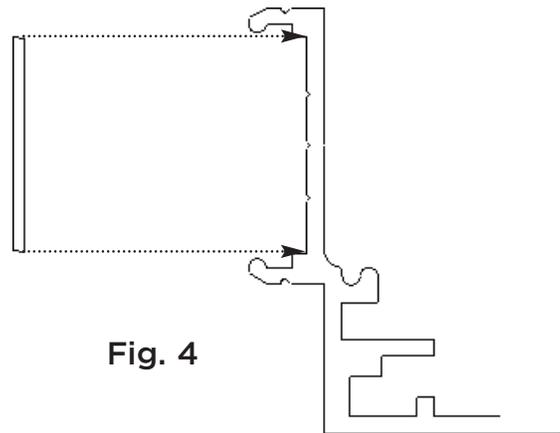
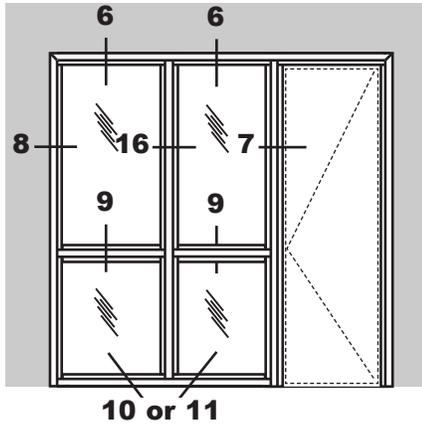


Fig. 4

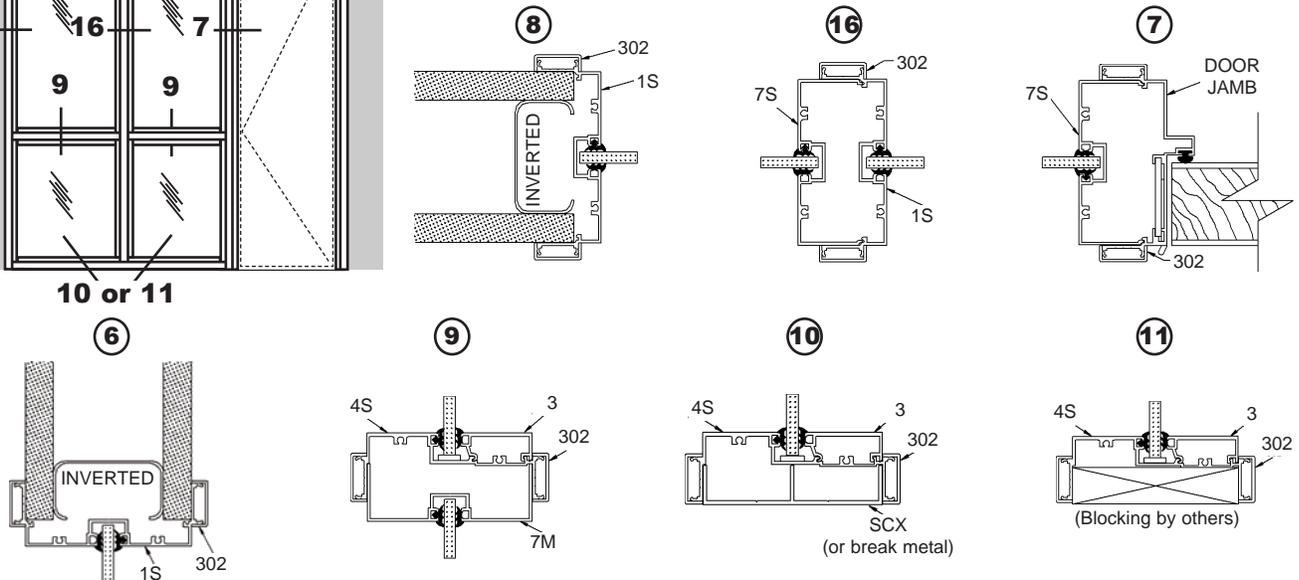
S-76 Clip Alignment Groove

- CLEANING:** If necessary to clean the aluminum, use water with a mild detergent. No abrasive agents should be used.
- FASTENING:** Corner Clips (S-76) - 4 per frame.
Use #6 7/16" Tek screws (supplied by others). (4 per clip - 16 per frame)
- FASTENING DOOR FRAME:** Use #6 1-5/8" drywall screws (supplied by others). Screws should penetrate studs 1/2". Screw 2" from each end - 12" o.c. minimum.

Full Height to Drywall Sidelight Installation Instructions



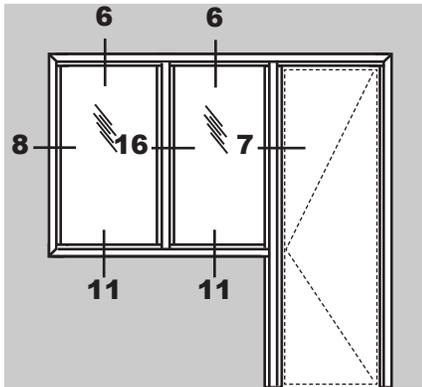
Note: The stud at details 6 and 8 must be inverted so that the glass pocket will clear.



1. Install door frame as per door frame installation instructions omitting the S-76 clips in the corner adjacent to the sidelight.
2. Align sidelight head with the door frame head and join together with a mullion clip each side. (see Fig.1) Bring the door frame/reglet jamb up under where the two heads meet. Align edge of clip with seam where the headers meet and check door opening for correct width. Fasten with mullion clips each side. (see Fig. 1)
3. Install the sidelight jamb, (see detail 8), by pushing it up under the head and align by installing the corner clip (S-76) in the trim bead of the head and jamb. (see Fig. 1) The vertical jambs all go to the floor. Install floor track (supplied by others unless otherwise specified), between the door frame/reglet jamb and the sidelight jamb. Place the sill over the floor track and secure with screw. Fasten the ends of the sill to the jambs with mullion clips. (see Fig. 1)
4. If there are mullions, put them in the desired location with the notch on the bottom and attach with mullion clips at top and bottom. (see Fig. 1)
5. If there are horizontal muntins, put them at the desired height between the vertical mullions and fasten to vertical mullions with mullion clips at both ends. (see Fig. 1)
6. Make sure all sections are level and that the door frame and all components are level and square. Secure all around with drywall screws 12" o.c.
7. Install glass. (If the sidelight is fire rated it will be reinforced with a steel channel at the door frame/sidelight reglet.) Snap on the trim.

NOTE: Installing Mullion (Horizontal or Vertical) -- Mullion clips (S-79) are supplied (4 per mullion). Hold end of clip 1/8" back from edge of trim retainer so trim can be installed continuously without notching. (See Fig. 1)

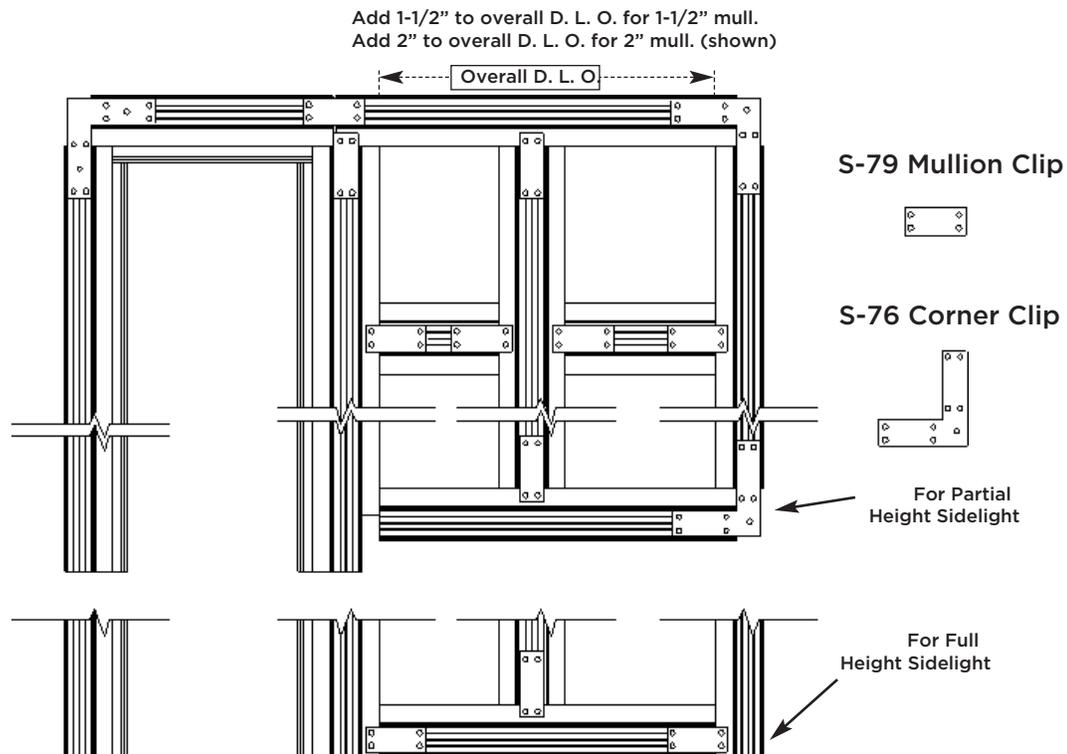
Partial Height to Drywall Sidelight Installation Instructions



See details on next page.

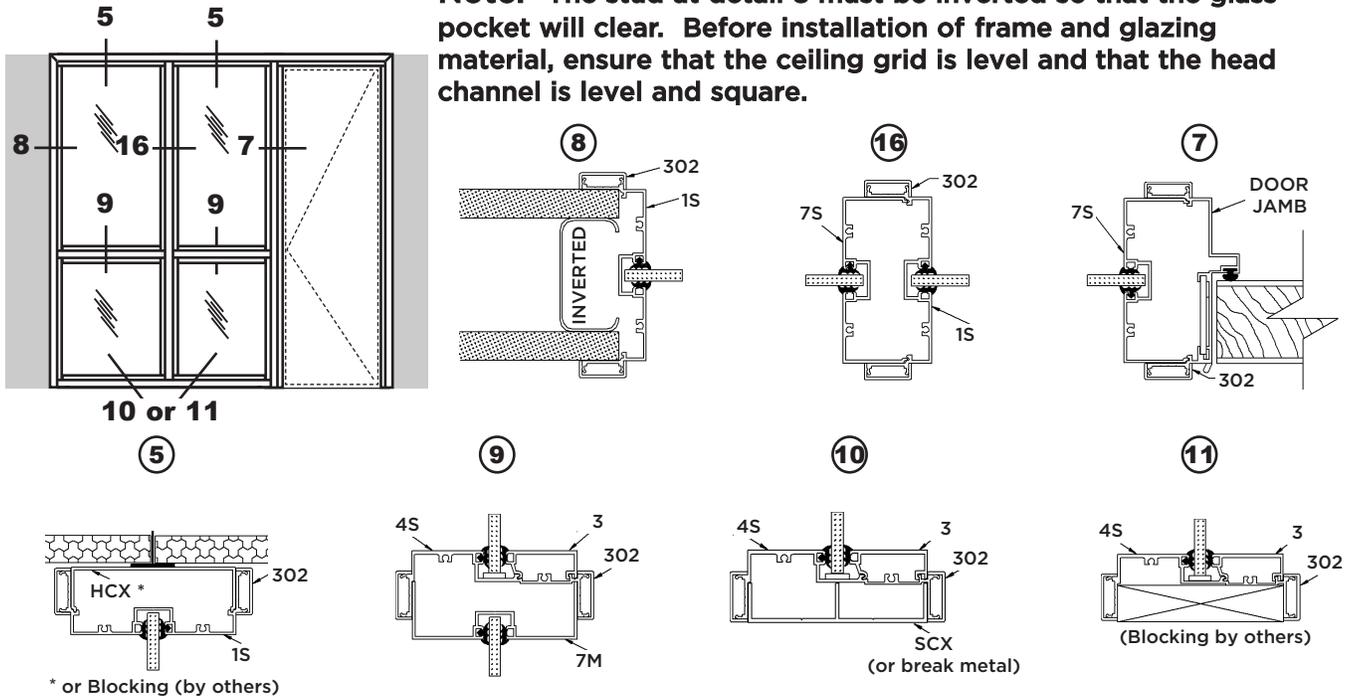
1. Install door frame as per door frame installation instructions omitting the S-76 clips in the corner adjacent to the sidelight.
2. Align sidelight head with the door frame head and join together with a mullion clip each side. (see Fig. 1)
3. Install Sidelight jamb with notch at the bottom and push up under the head. Align top and bottom with S-76 corner clips placed in the trim bead of the vertical and horizontal sections. (see Fig. 1) Fasten the jamb with a few screws to hold in place.
4. Install the sill section over the stub wall and fasten with clips and screws every 12" o.c. (see Fig. 1)
5. Install reglet into door frame jamb on the sidelight side and screw the two together every 12" o.c.
6. Make sure all sections are level and square then secure all around the unit with screws placed every 12" o.c.
7. If there are mullions, put them in place with the notch on the bottom and attach with mullion clips top and bottom. (see Fig. 1)
8. If there are horizontal muntins, put them at the desired height and fasten with mullion clips at both sides. (see Fig. 1)
9. Install glass, put the snap-on section in place, roll in vinyl then snap on the trim all around the unit.

Fig. 1



Full Height to Ceiling Grid Sidelight Installation Instructions

Note: The stud at detail 8 must be inverted so that the glass pocket will clear. Before installation of frame and glazing material, ensure that the ceiling grid is level and that the head channel is level and square.

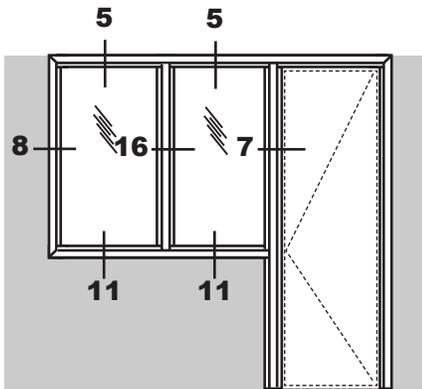


1. Install door frame as per door frame installation instructions omitting the S-76 clips in the corner adjacent to the sidelight.
2. Align sidelight head with the door frame head and join together with a mullion clip each side. (see Fig.1) Bring the door frame/reglet jamb up under where the two heads meet. Align edge of clip with seam where the headers meet and check door opening for correct width. Fasten with mullion clips each side. (see Fig. 1)
3. Install the sidelight jamb, (see Detail 8), by pushing it up under the head and align by installing the corner clip (S-76) in the trim bead of the head and jamb. (see Fig. 1) The vertical jambs all go to the floor. Install floor track, (supplied by others unless otherwise specified), between the door frame/reglet jamb and the sidelight jamb. Place the sill over the floor track and secure with screw. Fasten the ends of the sill to the jambs with mullion clips. (see Fig. 1)
4. If there are mullions, put them in the desired location with the notch on the bottom and attach with mullion clips at top and bottom. (see Fig. 1)
5. If there are horizontal muntins, put them at the desired height between the vertical mullions and fasten to vertical mullions with mullion clips at both ends. (see Fig. 1)
6. Make sure all sections are level and that the door frame and all components are level and square. Secure all around with drywall screws 12" o.c.
7. Install glass. (If the sidelight is fire rated it will be reinforced with a steel channel at the door frame/sidelight reglet.) Snap on the trim.

NOTE: Installing Mullion (Horizontal or Vertical) -- Mullion clips (S-79) are supplied (4 per mullion). Hold end of clip 1/8" back from edge of trim retainer so trim can be installed continuously without notching. (See Fig. 1)

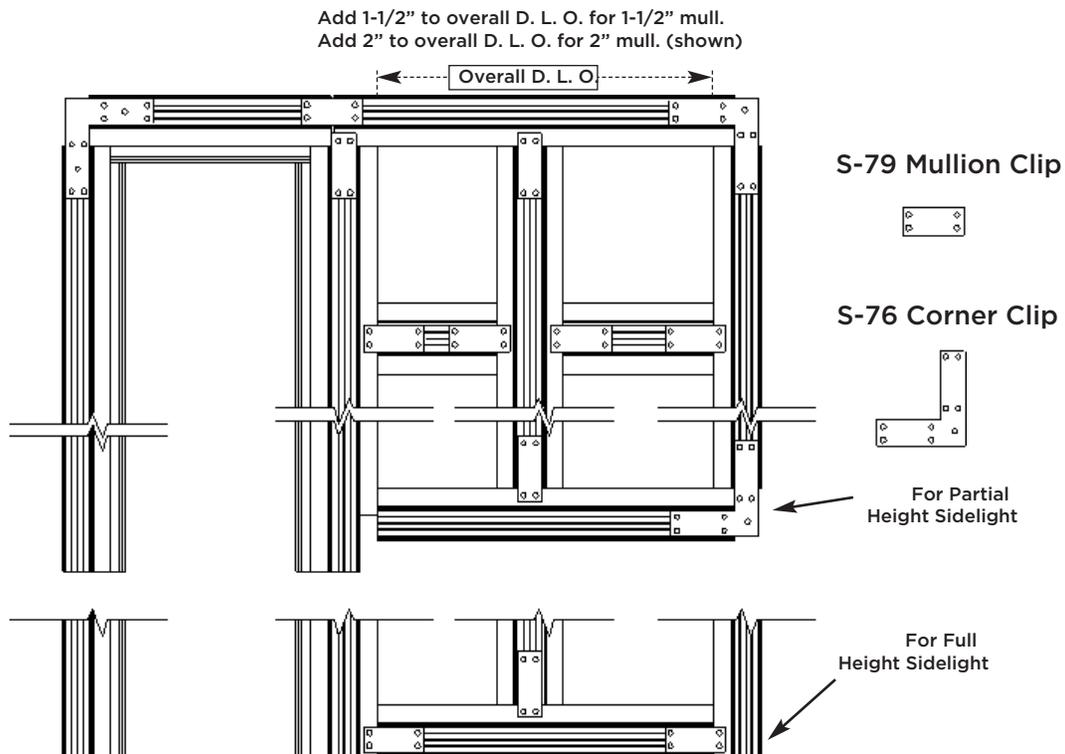
Partial Height to Ceiling Grid Sidelight Installation Instructions

See details on previous page.

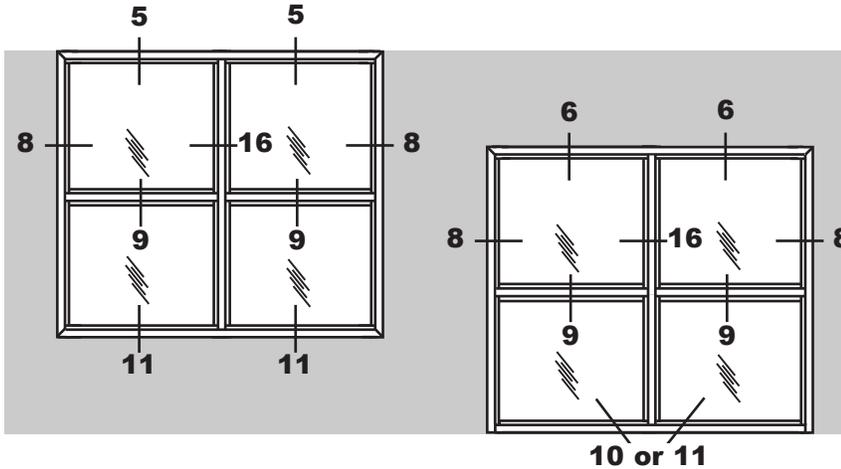


1. Install door frame as per door frame installation instructions omitting the S-76 clips in the corner adjacent to the sidelight.
2. Align sidelight head with the door frame head and join together with a mullion clip each side. (see Fig. 1)
3. Install sidelight jamb with notch at the bottom and push up under the head. Align top and bottom with S-76 corner clips placed in the trim bead of the vertical and horizontal sections. (see Fig. 1) Fasten the jamb with a few screws to hold in place
4. Install the sill section over the stub wall and fasten with clips and screws every 12" o.c. (see Fig. 1)
5. Install reglet into door frame jamb on the sidelight side and screw the two together every 12" o.c.
6. Make sure all sections are level and square then secure all around the unit with screws placed every 12" o.c.
7. If there are mullions, put them in place with the notch on the bottom and attach with mullion clips top and bottom. (see Fig. 1)
8. If there are horizontal muntins, put them at the desired height and fasten with mullion clips at both sides. (see Fig. 1)
9. Install glass, put the snap-on section in place, roll in vinyl, then snap on the trim all around the unit.

Fig. 1

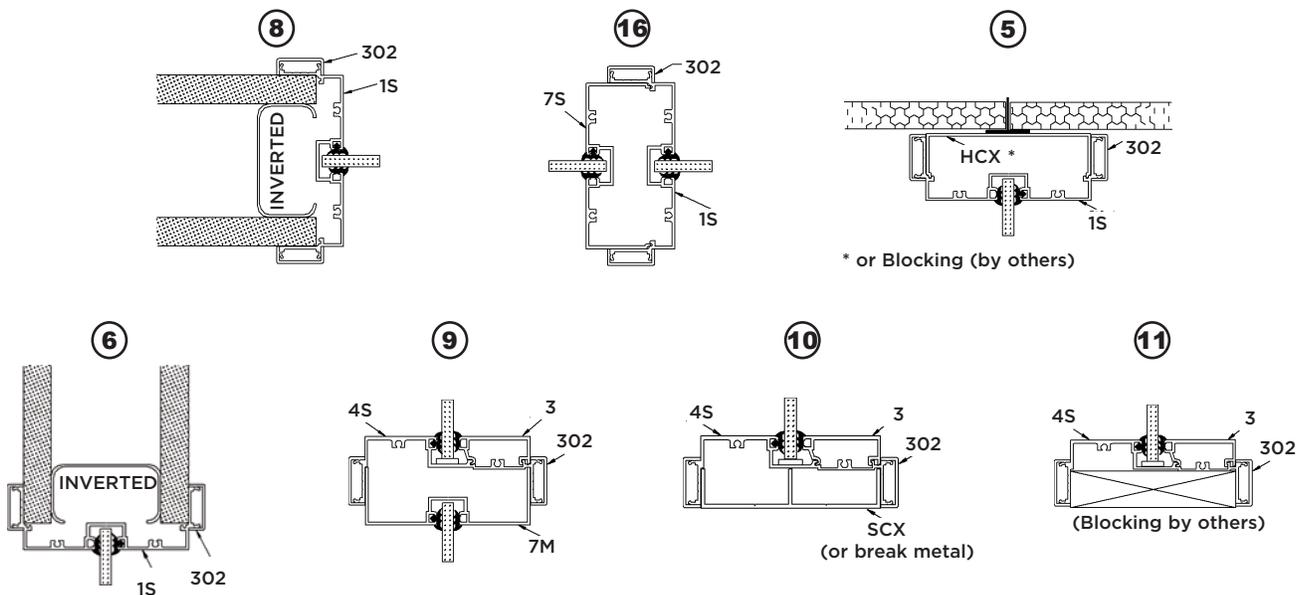


Borrowed Light Installation Instructions



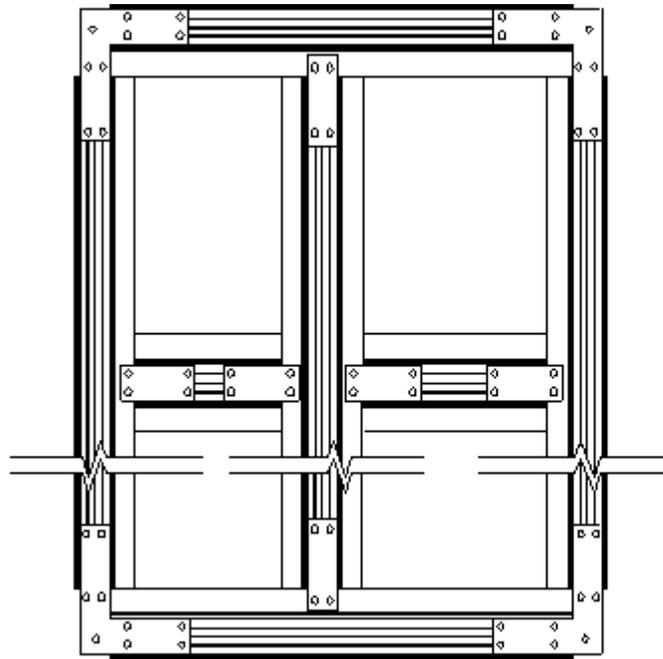
Note: The stud at detail 6 and 8 must be inverted so that the glass pocket will clear. If installing to ceiling grid, (Detail 5), ensure that the ceiling grid is level and that the head channel is level and square before installation of frame and glazing material.

DO NOT SECURE FRAME UNTIL ALL PARTS ARE SET IN PLACE.



1. Push head up over wall, level and secure in place.
2. Start jamb over wall at head with notch at the bottom and swing bottom into place.
3. Repeat with second jamb.
4. Set sill over wall or sill channel, (supplied by others, unless otherwise specified).
5. Slide one jamb over to head and use a square for a 90° at corner. Install clip as needed. (see Fig. 1) Clip must set flat in groove. (Fig. 3)
6. Repeat at sill.

Fig. 1



S-79 Mullion Clip



S-76 Corner Clip



Note: Installing Mullion (Horizontal or Vertical) Mullion clips (S-79) are supplied. Hold end of clip 1/8" back from edge of trim retainer so trim can be installed continuously without notching. (Fig. 3)

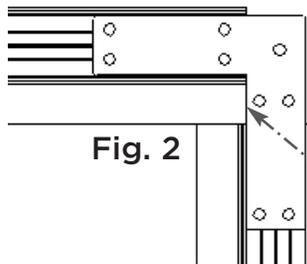


Fig. 2

Vertical Edge

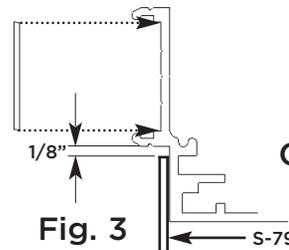


Fig. 3

**S-76 & S-79
Clip Alignment
Groove**

7. If there are mullions, put them in the desired location with the notch on the bottom and attach with mullion clips at top and bottom. (see Fig. 1)
8. If there are horizontal muntins, put them at the desired height between the vertical mullions and fasten to vertical mullions with mullion clips at both ends. (see Fig. 1)
9. Set glass.
10. Install snap on stop.
11. Roll in vinyl.
12. Snap on trim.

CLEANING: If necessary to clean the aluminum, use water with a mild detergent. No abrasive agents should be used.

FASTENING: Corner Clips (S-76) - 4 per frame - 3 sided, 8 per frame - 4 sided. Use #6 7/16" tek screws (supplied by others). (4 per clip.)

FASTENING DOOR FRAME: Use #6 1-5/8" drywall screws (supplied by others). Screw 2" from each end.

90 Minute Door Frame Installation Instructions

1. Frames are fabricated to exact width specified and no clearance is built in.
2. Rough opening should be 1-1/2" wider than the desired width, 3/4" over in height.
3. Determine high side of floor and cut jambs to the required height. Be sure mute is pushed to top of jamb before cutting.
4. Check opening for proper swing, then slip header over the wall. (Fig. 1)
5. Hold jambs at an angle and slip the upper portion over the wall. Push upward to engage header, then push the rest of the jamb over the wall. (Fig. 2)

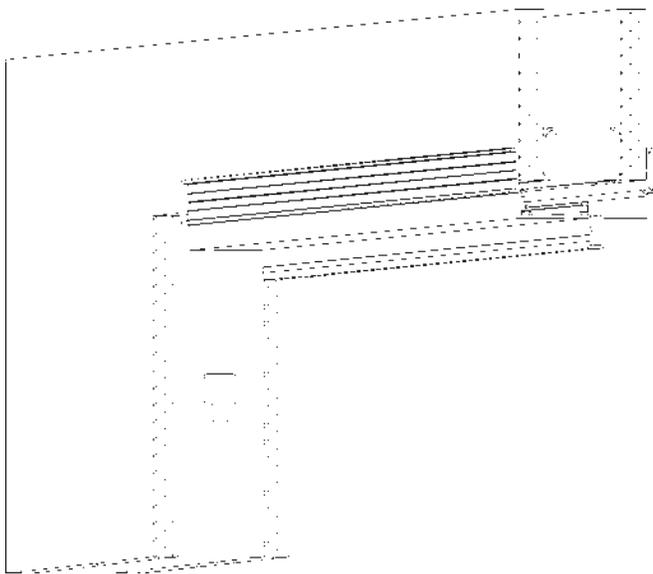


Fig. 1

PLEASE NOTE:

The illustrations shown in these instructions do not show the steel backer channel that comes pre-attached to the frame members.

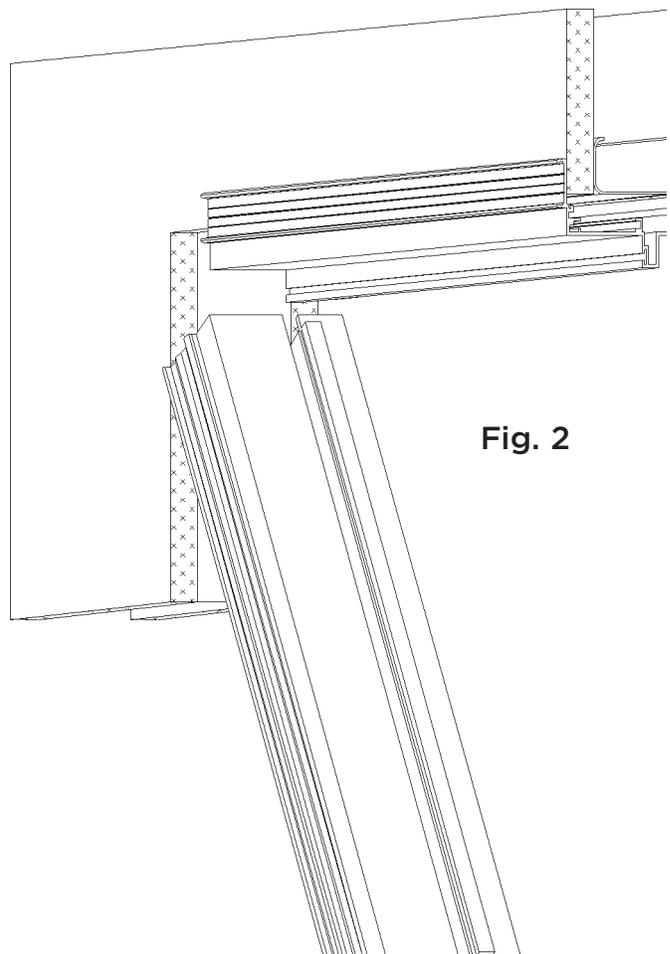


Fig. 2

6. Slide butt jamb down to finished floor. If carpet is to be laid, the base on which it is to be laid shall be considered the finished floor. For other floor coverings, (tile, etc.) the jamb should rest on removable spacers the same thickness as the flooring to be used.
7. Plumb butt side and secure to wall.

8. If door is premortised, hang prefit door and close into opening.
 - a.) If doors are not premortised, then use a square to attain a 90° corner between head & jambs. Head must butt up to vertical edge of clip (Fig. 3) and set flat in alignment and groove (Fig. 4). You can then attach clips with #8 x 3/4" Tek screws.
 - b.) Secure head to wall.
 - c.) Use same procedure for strike jamb.
9. Pull header down to door, allowing 1/8" spacing. Install corner clips (Fig. 3 & 4) and secure to wall.
10. Pull strike jamb into position and align with corner clips and door edge. Secure to wall.
11. If required, cut trim to length and install trim. Trim should fit snugly. If there is any tendency to rattle, give full length a slight twist before installing.

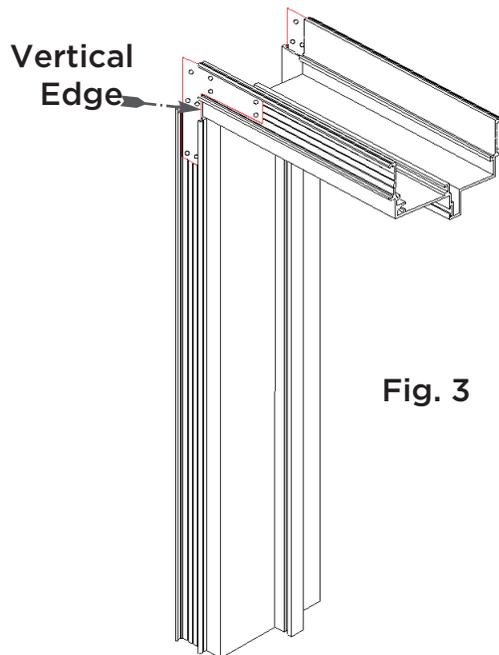


Fig. 3

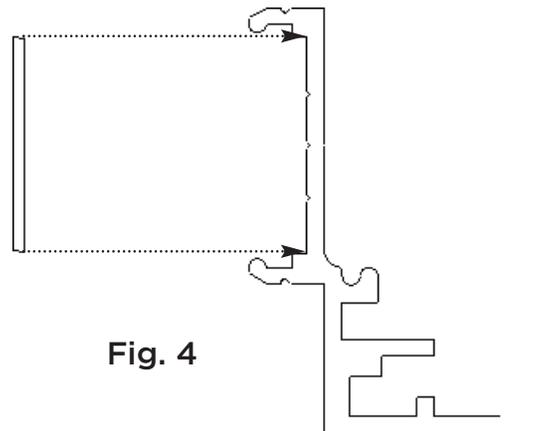
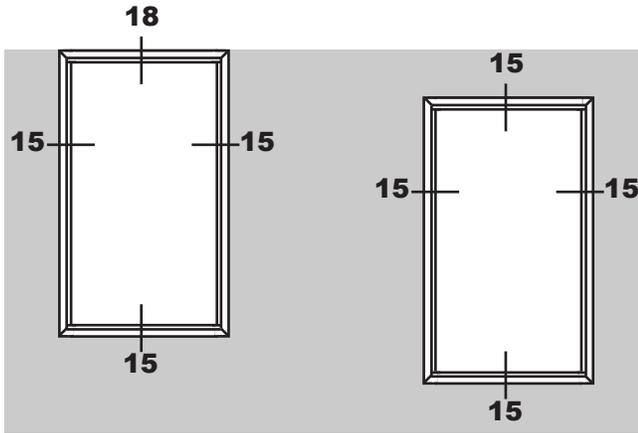


Fig. 4

S-76 Clip Alignment Groove

- CLEANING:** If necessary to clean the aluminum, use water with a mild detergent. No abrasive agents should be used.
- FASTENING:** Corner Clips (S-76) - 4 per frame.
Use #8 3/4" Tek screws (supplied by others). (4 per clip - 16 per frame)
- FASTENING DOOR FRAME:** Use #6 1-5/8" drywall screws (supplied by others) in each pre-drilled hole. Screws should penetrate studs 1/2".

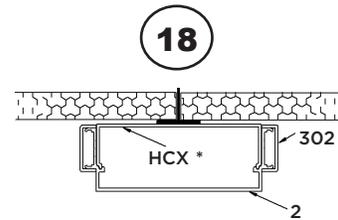
4 Sided Cased Opening Installation Instructions



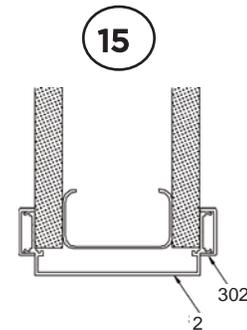
**Cased Opening
to Ceiling Grid**

**Cased Opening
to Drywall**

Note: If installing to ceiling grid (detail 18) ensure that the ceiling grid is level and that the head channel is level and square before installing cased opening.



* or Blocking (by others)



Note: DO NOT SECURE FRAME UNTIL ALL PARTS ARE SET IN PLACE.

1. Push head up over wall.
2. Set Sill over wall
3. Start jamb over wall at head and swing bottom into place. (Fig. 1)
4. Repeat with second jamb.
5. Level sill & secure in place.
6. Push one jamb down to sill and use a square for a 90° corner. Vertical edge of head must line up with vertical edge of clip. (Fig. 2)
Clip must set flat in groove. (Fig. 3)
7. Repeat for second jamb.
8. Pull head down to set on top of jambs, check for 90° at corners and secure in place. (Fig. 3)
9. Snap on trim.

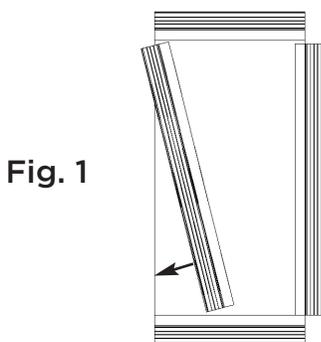


Fig. 1

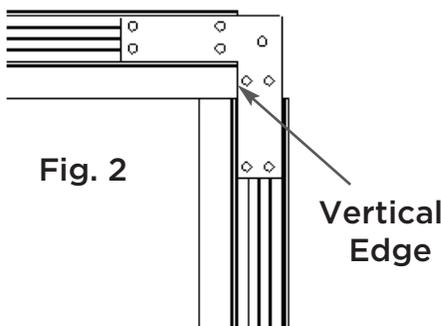


Fig. 2

**Vertical
Edge**

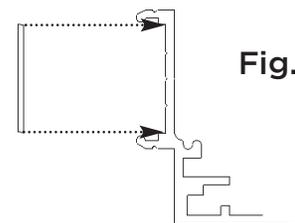
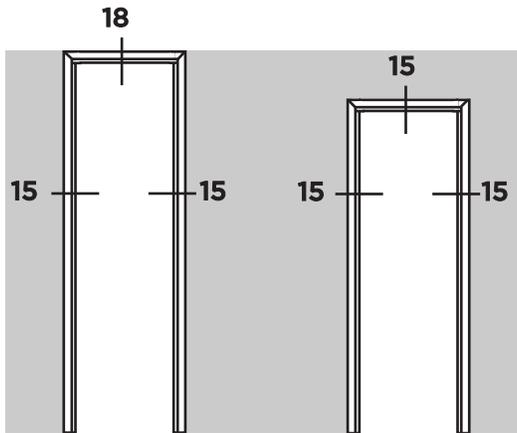


Fig. 3

S-76 Clip Alignment Groove

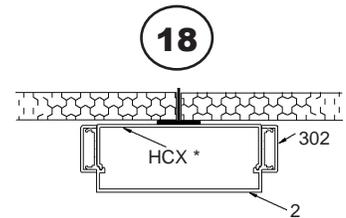
3 Sided Cased Opening Installation Instructions



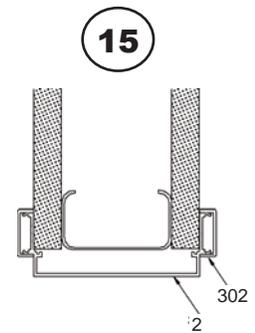
**Cased Opening
to Ceiling Grid**

**Cased Opening
to Drywall**

Note: If installing to ceiling grid (detail 18) ensure that the ceiling grid is level and that the head channel is level and square before installing cased opening.



* or Blocking (by others)



Note: DO NOT SECURE FRAME UNTIL ALL PARTS ARE SET IN PLACE.

1. Push head up over wall.
2. Start jamb over wall at head and swing bottom into place. (Fig. 4)
3. Repeat with second jamb.
4. Plumb one jamb and secure in place.
5. Pull head to jamb. Check corner for 90°. Vertical edge of head must line up with vertical edge of clip. (Fig. 2) Clip must set flat in groove. (Fig. 3)
6. Slide other jamb over into position and line up as above. Plumb and secure in place.
7. Snap on trim.

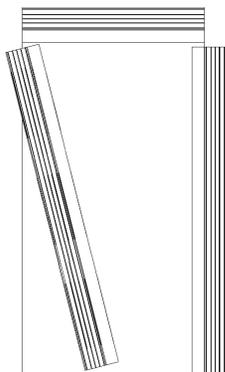


Fig. 4

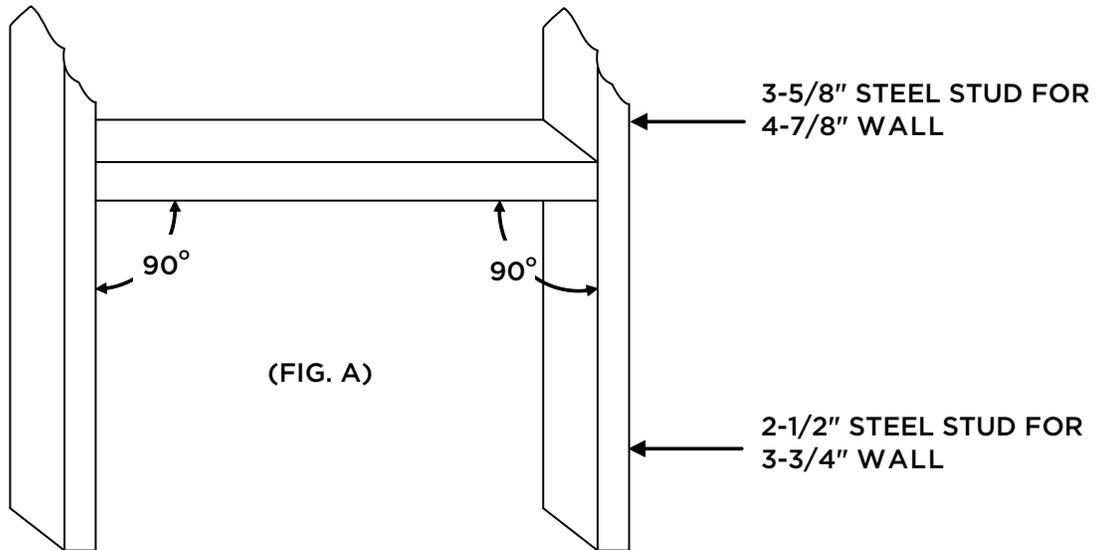
CLEANING: If necessary to clean the aluminum, use water with a mild detergent. No abrasive agents should be used.

FASTENING: Corner Clips (S-76) - 4 per frame - 3 sided, 8 per frame - 4 sided. Use #6 1-5/8" drywall screws. (4 per clip.)

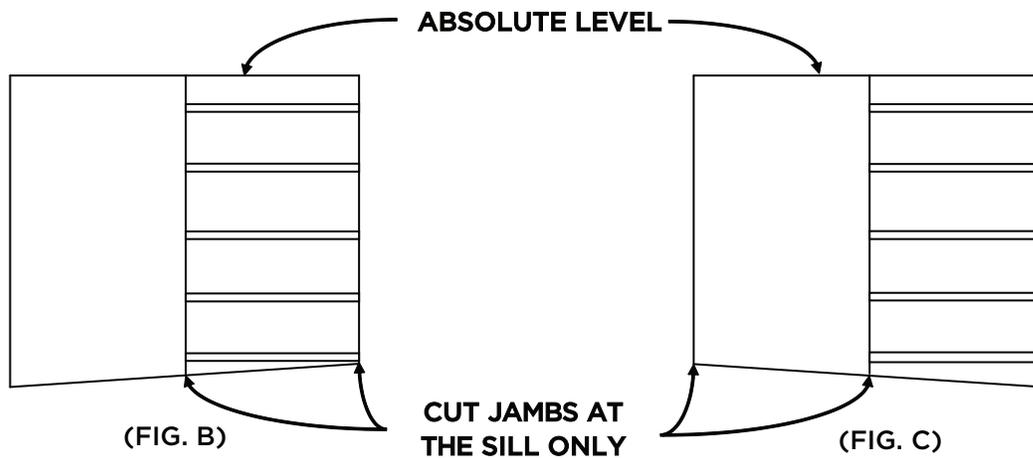
FASTENING DOOR FRAME: Use #6 1-5/8" drywall screws Screw 2" from each end - 12" o.c. minimum.

Pocket Frame Installation Instructions

1. All framing must be square (Fig. A) and be the proper dimensions.

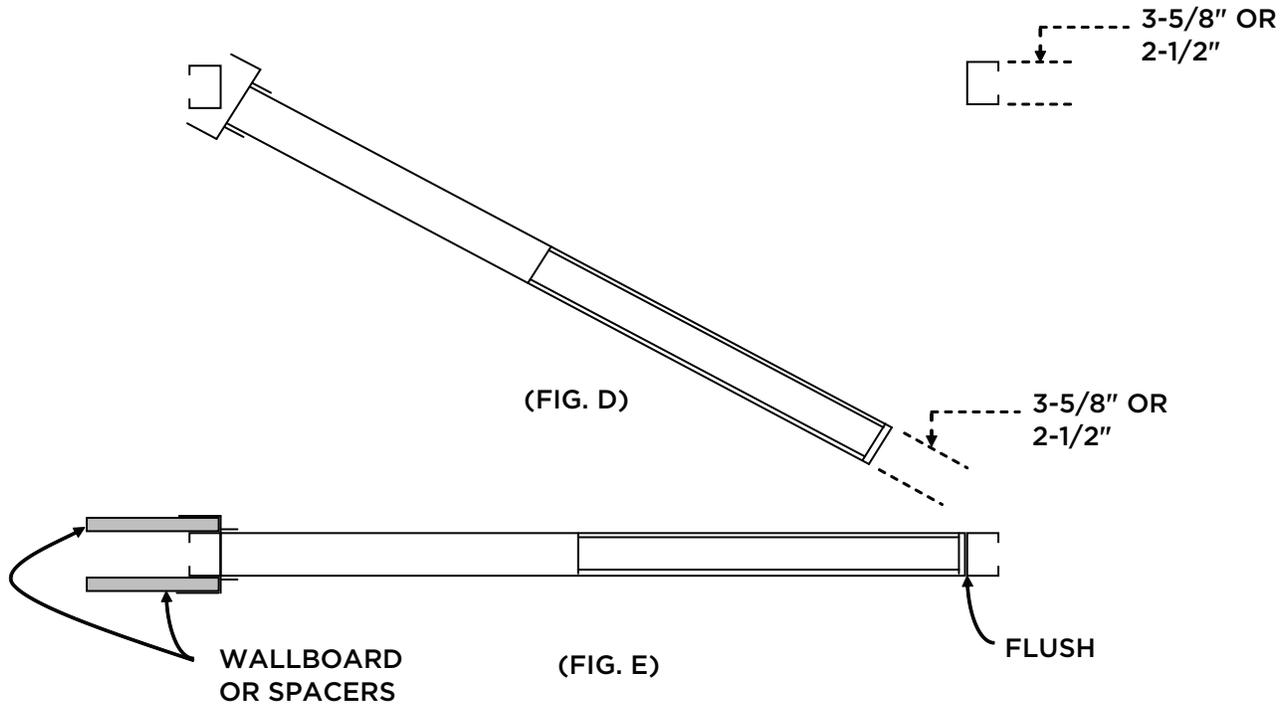


If for any reason your floor is not level, the jamb must be trimmed at the base. (Fig. B & C)
The header must always remain level. This is because the door hangs and rolls on the track.

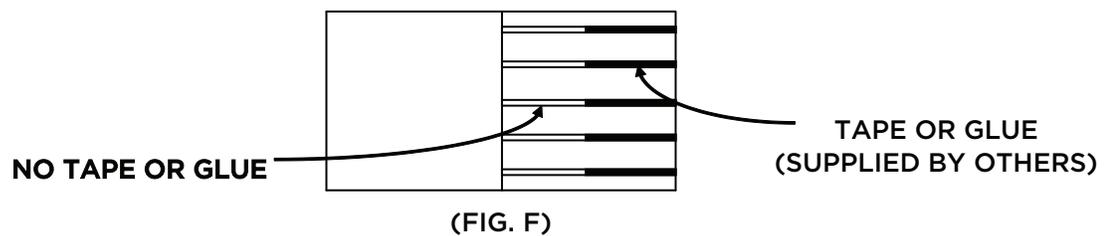


2. All framing must be with steel studs. **NOT FLOOR TRACK !**
3. **IMPORTANT:** INSTALL ROLLERS ONTO TRACK. THIS MUST BE COMPLETED BEFORE FRAME IS INSTALLED IN OPENING

4. Slip exposed jamb over steel stud (FIG. D) & swing pocket end into place. (FIG. E)



5. To center exposed jamb, you must either now install drywall or use dummy spacers. (Fig. E) Wall Frame work and pocket frame work will flush out.
6. You can now secure frame by screwing through jambs and header.
7. Install hanger plate to top of door. (See Hardware Instructions.)
8. Hang door on rollers. (See Hardware Instructions.)
9. To attach wall board to aluminum horizontal ribs, use double stick tape or glue on one half of each rib only. (Fig. F) If tape is applied to entire length of horizontal ribs the gypsum board cannot be slipped under jambs.



10. Now install door frame trim by snapping it on.

ALUMAGLIDE® INSTALLATION INSTRUCTIONS

Ensure that the wall is straight and plumb before installation. It is imperative that the wall MUST be a true 4-7/8". If not, the snap on trim that touches the door will be out of alignment.

Rough Opening Height is Door Opening Height + 2-3/4"

Rough Opening Width is Door Opening Width + Sidelight DLO + 3"

- Step 1: Modify stud wall for Lock Strike (if required); Slip SL-1 Strike Jamb over wall (do not fasten).
- Step 2: Slip SL-8 Glazing End Jamb over wall (do not fasten).
- Step 3: Insert Rollers into SL-2 Header/Track and Install SL-2 Header/Track between SL-1 Strike Jamb and SL-8 Glazing End Jamb; Secure to drywall through trim track sides and through underside of SL-2 Header/Track (as shown on previous page) 2" from each end and 12" O.C. (minimum) w/ 1-1/2" #6 drywall screws.
- Step 4: Pull SL-1 Strike Jamb and SL-8 End Jamb into position and align to SL-2 Header/Track using the "L" shaped corner clips; Ensure SL-1 Strike Jamb and SL-8 Glazing End Jamb are plumb and square and screw through trim track (as shown on previous page) 2" from top and bottom and 12" O.C. (minimum) w/ 1-1/2" #6 drywall screws.
- Step 5: Snap SL-4 Header Glazing and SL-3 Header Cased Opening into place.
- Step 6: Chalk line floor from edges of frame from SL-1 Strike Jamb to SL-8 Glazing End Jamb for Mullion and Sill Alignment.
- Step 7: Measure Door Opening Width from edge of SL-1 Strike Jamb and mark; install SL-5 Cased Opening Jamb/SL-7 Glazing Vertical Insert (pre-mullioned at plant) at this mark and secure with pre-attached angle clip on track side and (1) Straight Clip on other side (2 special screws provided from plant). Ensure plumb and square and in exact alignment with SL-1 Strike Jamb and SL-8 Glazing End Jamb.
- Step 8: Lay SL-10 Glazing Sill with SL-SC Sill Floor Track (do not fasten) onto floor between SL-5/7 Mullion and SL-8 Glazing End Jamb ensuring exact alignment; remove SL-10 Glazing Sill and shoot SL-SC Sill Floor Track to Floor; return SL-10 Glazing Sill and attach to SL-SC Sill Floor Track using 3/4" #8 Tek Screws.
- Step 9: Locate position of any (if any) Intermediate SL-6 Glazing Vertical Jamb/SL-7 Glazing Vertical Insert Mullions with (3) Straight Clips using 3/4" #8 Tek Screws and (1) modified Straight Clip w/ small angle (at top door side with special screws provided from plant).
- Step 10: Locate position of any (if any) SL-10 Glazing Horizontal/SL-11 Horizontal Insert Muntins and secure using straight clips with 3/4" #8 Tek Screws.
- Step 11: Install glass and snap-on SL-9 Glazing Snap-in Stop(s).
- Step 12: Install Roll-In Vinyl.
- Step 13: Install 304-1 (5/16" x 1-1/2") Snap-on Trim and SL-12 -- Pile Track Trim (**Notch trim legs at clip intersections so that the clip does not interfere with the snapping of the trim**).
- Step 14: Install Floor Guide.
- Step 15: Install Door and adjust for undercut.
- Step 16: Install SL-35P Snap-on Trim on door side of SL-2 Header/Track.
- Step 17: Install Lock Strike

SPECIFICATIONS & FIRE RATING INFORMATION

SPECIFICATIONS

SECTION 08 11 16 INTERIOR ALUMINUM DOORS AND FRAMES

PART 1 GENERAL

1.1 SUMMARY

A. Section Includes:

1. Pre-finished aluminum door frames for interior use.
2. Pre-finished aluminum window frames for interior use.
3. Pre-finished aluminum framing system for interior use.
4. Pre-finished aluminum doors for interior use.

B. Related Sections:

1. Division 01 Section "Sustainable Design Requirements" for additional LEED documentation and requirements.
2. Division 08 Section "Glazing" for glass view panels in interior aluminum doors.
3. Division 08 Sections "Flush Wood Doors", "Clad Wood Doors", and "Stile and Rail Wood Doors" for wood doors used in interior aluminum frames.
4. Division 08 Sections "Door Hardware" and "Access Control Hardware" for door hardware used on interior aluminum doors and frames.
5. Division 26 "Electrical" Sections for electrical connections including conduit and wiring for door controls and operators installed on interior aluminum frames.
6. Division 28 Section "Access Control" for access control devices installed at interior aluminum frame openings and provided as part of a security access system.

C. Codes and References: Comply with the version year adopted by the Authority Having Jurisdiction.

1. AAMA 603.8 - Performance Requirements and Test Procedures for Pigmented Organic on Extruded Aluminum.
2. AAMA 611 - Guide Specification for Anodized Architectural Aluminum.
3. AAMA 609 & 610-02 - Cleaning and Maintenance Guide for Architecturally Finished Aluminum.
4. ASTM B221 - Standard Specification for Aluminum and Aluminum-alloy Extruded Bars, Rods, Wire, Profiles, and Tubes.
5. NAAMM - "Metal Finishes Manual for Architectural and Metal Products".
6. ANSI/NFPA 80 - Standard for Fire Doors and Fire Windows; National Fire Protection Association.
7. NFPA 252 - Standard Method of Fire Tests of Door Assemblies.
8. ANSI A117.1 - Accessible and Usable Buildings and Facilities
9. ICC/IBC - International Building Code.

1.2 SUBMITTALS

- ###### A. Submit under provisions of Section 01 30 00.
- ###### B. Product Data: For each type of product indicated. Include construction details, material descriptions, hardware reinforcements, profiles, anchors, fire-resistance rating, and finishes.
- ###### C. Templates: Door hardware supplier is to furnish templates, template reference number and/or physical hardware to the interior aluminum door and frame supplier in order to prepare the doors and frames to receive the finish hardware items.
- ###### D. Shop Drawings: Include the following:
1. Frame details for each frame type, including dimensioned profiles.
 2. Locations of reinforcement and preparations for hardware.
 3. Details of each different wall opening condition. Include requirements for steel

framing at partitions for fit and securing of frames, partition widths and tolerances, direction of framing members, clips and attachments.

4. Details of anchorages, joints, field splices, and connections.
5. Details of accessories.
6. Details of moldings, removable stops, and glazing.
7. Elevations of each door design.
8. Details of doors, including vertical and horizontal edge details.
9. Details of preparations for power, signal, and control systems.

E. Samples for verification: Provide, at the request of architect, prepared Samples as indicated below:

1. Framing Member: 12 inches long.
2. Corner Fabrication: 12-by-12-inch-long, full size window corner, including full-size sections of extrusions with factory-applied finish.
3. Aluminum chips in full range of manufacturer's standard finishes for architect's color selection.

F. Interior Aluminum Door and Frame Schedule: Use same designations indicated on Drawings. Coordinate with Door Hardware schedule and glazing.

G. Informational Submittals:

1. LEED Documentation: Submit manufacturer's environmental documentation and applicable sustainability program credits for MR-4 and that are specified herein.
2. Certificates of Compliance: Submit any product test report or information necessary to indicate compliance with this specification section.

1.3 QUALITY ASSURANCE

- A. Source Limitations: Obtain aluminum frames and doors through one source from a single qualified manufacturer.

B. Manufacturer Qualifications: A firm experienced in the manufacturing of interior aluminum framing systems and doors with a minimum five (5) years successful in-service performance providing product similar to those indicated, including pre-engineering and pre-fabricating all components of aluminum framing systems and doors.

C. Installer Qualifications: An experienced installer with a minimum five (5) years experience who has completed aluminum framing systems and door installations similar in material, design, and extent to those indicated and whose work has resulted in construction with a record of successful in-service performance.

D. Aesthetic Effects: Do not modify intended aesthetic effects, as judged solely by Architect, except with Architect's approval. If modifications are proposed, submit comprehensive explanatory data to Architect for review.

E. Fire Rated Assemblies: In locations where fire-rated openings are scheduled or required by regulatory agencies, provide fire-rated aluminum frames that have been tested and certified for specified exposure by an agency acceptable to governing authorities.

1. Provide labels permanently fastened on each frame that is within size limits established by NFPA and the testing authority.
 - a. Provide 20-minute labels.
 - b. Provide 90-minute labels.
 - c. Provide labels for openings as scheduled on the drawings.

F. Pre-Installation Conference: Conduct conference in compliance with requirements in Division 01 Section "Project Meetings" with attendance by representatives of Supplier, Installer, and Contractor to review proper methods and procedures for installing interior aluminum frames and doors and to verify installation of electrical knockout boxes and conduit at frames with electrified or access control hardware.

1.4 DELIVERY, STORAGE AND HANDLING

- A. Deliver interior aluminum frames and doors individually protective wrapped within cartons and marked for the corresponding

scheduled opening. Do not bulk pack frames.

B. Inspect frames upon delivery for damage.

1. Repair minor damage to pre-finished products as recommended by Manufacturer.
2. Replace frames that cannot be satisfactorily repaired.

C. Store Interior aluminum frames and doors at Project site under cover and as near as possible to final installation location. Do not use covering material that will cause discoloration of aluminum finish.

1.5 PROJECT CONDITIONS

A. Field Measurements: Verify actual dimensions of interior aluminum frame openings by field measurements before fabrication and indicate measurements on Shop Drawings submittals.

B. Do not begin installation of aluminum frames and doors until area of work has been completely enclosed and interior is protected from the elements.

C. Maintain temperature and humidity in areas of installation within reasonable limits, as close as possible to final occupancy standards. If necessary, provide artificial heating, cooling, and ventilation to maintain required environmental conditions.

1.6 WARRANTY

A. Provide manufacturer's written warranty against defects in materials and workmanship upon final completion and acceptance of Work in this section.

PART 2 PRODUCTS

2.1 MANUFACTURERS

A. Manufacturers: Subject to compliance with requirements, provide products by the following:

Western Integrated Materials, Inc.
3310 E. 59th St. Long Beach, CA 90805
Telephone: (562) 634-2823
Fax: (562) 634-8449
Website: www.aluminumdoorframes.com

1. Acceptable Products:

- a. Western Integrated Materials, Inc. - Interior Aluminum Frames
- b. Western Integrated Materials, Inc. - Interior Aluminum Swinging Doors
- c. Western Integrated Materials, Inc. - Interior Aluminum Sliding Doors and Sliding Door Frame -Alumaglide®

B. Substitutions: Material from alternate interior aluminum framing system and door fabricators will not be accepted without prior written and sample approval in accordance with requirements specified in Division 01 and at the discretion of Architect and their designated openings consultant.

2.2 MATERIALS

A. Extruded Aluminum: Controlled ASTM B221 alloy billets of 6063-T5 for framing / 6063-T6 for doors, to assure compliance with tight dimensional tolerances and maintain color uniformity.

B. EXTRUDED INTERIOR ALUMINUM FRAMES

1. Provide interior aluminum framing components complying with dimensions, profiles, and relationships to adjoining work of components as indicated on Drawings. Provide frames that are fitted for partition types and throat openings meeting the throat opening and required clearances per frame manufacturer's recommendations. Reinforce for specified hinges, strikes, closers, and other hardware as required.

a. Western Integrated Materials Series 300, 400, and 700 Frames: Provide frames with the following characteristics:

1. Rectilinear design.
2. 1-1/2", 2", 3", 4" face profiles.
3. Trim:

a. (302) 1" with 3/8" return (reveal trim)

- b. (303) 1-1/4" with 5/8" return (reveal trim)
 - c. (302-375) 1-1/4" with 3/8" return (reveal trim)
 - d. (307) 1-1/4" x 5/16" return (reveal trim)
 - e. (304) 1-1/2" with 5/16" return (flush trim)
 - f. (305) 1-1/2" with 5/16" return (reveal trim)
 - g. (306) 1-7/16" with 3/8" return (reveal trim)
 - h. (304-2) 2" with 5/16" return (flush trim)
 - i. (304-3) 3" with 5/16" return (flush trim)
 - j. (304-4S) 4" with 5/16" return (flush sill trim)
 - k. (304-4C) 4" with 5/16" return (flush column trim)
4. Series 300 Throat (drywall partition) sizes :
- a. 3-3/8", 3-3/4", 3-7/8", 4-5/8", 4-3/4", 4-7/8", 5", 5-1/4", 5-1/2", 6", 7-1/4"
5. Series 400 Throat (drywall partition) sizes:
- a. From 3" to 9-1/2"
6. Series 700 (90 Minute Positive Pressure Fire Rated) Throat (drywall partition) sizes:
- a. From 3-3/4" to 8-3/8"
- b. Fire Rated Frames: Fabricate frames in accordance with NFPA80, listed and labeled by a qualified testing agency.
- 1. 300 and 400 Series Door Frames only may be rated up to 20 Minute Positive Pressure.
 - 2. 700 Series Door Frames only are rated at 90 Minute Neutral or Positive Pressure.
- C. INTERIOR ALUMINUM DOORS
- 1. General: Provide 1-3/4 inch doors of type and design indicated, not less than 0.100 inch thick material.
 - 2. Aluminum Stile & Rail Type Swinging Doors: Door Stiles and rails to have tubular design with the following characteristics:
 - a. Stiles:
 - 1. Narrow Stile (2")
 - 2. Medium Stile (3-1/2")
 - 3. Wide Stile (5")
 - b. Rails:
 - 1. 2-1/8" Rail
 - 2. 3-1/2" Rail
 - 3. 5" Rail
 - 4. 6-1/2" Rail
 - 5. 9-1/2" Rail
 - c. Snap-in stops with factory applied glazing gaskets for 1/4", 3/8", or 1/2" thick glass
 - d. Hardware as specified in Division 08 Section, "Door Hardware". Aluminum Stile & Rail Sliding Type Doors: Subject to the same tubular design standards as Stile & Rail Type Swinging Doors with the following characteristics:
 - e. Sliding door track to be installed in properly blocked ceiling or wall above frame. Sliding track to be provided with snap on covers.
 - f. Horizontal member at head shall have two contact points incorporating woven pile. All shall be held in integral extruded slots and secured to prevent movement or loss while operating
 - g. Sliding Door Hardware:
 - 1. Quad sealed Bearing Rollers -2 per door. Maximum rollers rated for 250 lbs.
 - 2. Provide bumper stops in track assemblies.

3. Provide concealed door guide at floor (track assemblies are not allowed).
4. Locking device Adams-Rite maximum security lock AR 2331 with stainless steel bolt
5. Accurate 2001 steel, mortise lock with steel bolt.
6. Pull handles:
 - a. Western Integrated Materials, Inc.
 - b. Rockwood
 - c. Don-Jo
 - d. Hager
- h. Snap-in stops with factory applied glazing gaskets for 1/4", or 3/8" thick glass.

3. Interior Aluminum Door Glazing:

- a. Glass and Glazing System: Refer to Division 08 Section "Glazing" for glass units and glazing requirements applicable to glazed aluminum-framed glass doors unit.
- b. Glass: Comply with Division 08 Section "Glazing" for requirements applicable to safety glazing, insulating-glass units, and laminated glass units.
- c. Fixed panels shall be constructed to allow for field glazing. Panel glazing shall be accomplished using a "marine" style reusable, wraparound black flexible PVC or EPDM material per commercial standard CS23060 without the need for separated glazing beads or putty style bedding compounds. The glazing channel shall be provided with the unit for 1/4" and 3/8" glass.

D. INTERIOR POCKET DOOR FRAME

1. To define the standard of quality desired, frames shall be manufactured by Western Integrated Materials, Inc.
2. Steel member to be galvanized.

3. Door(s) to be 1-3/4"
4. Framing to fit 4-7/8" throat.

2.3 ACCESSORIES

- A. Fasteners: Aluminum, nonmagnetic, stainless steel or other noncorrosive metal fasteners compatible with frames, stops, panels, reinforcement plates, hardware, anchors, and other items being fastened.
- B. Door Silencers: Manufacturer's standard continuous mohair, wool pile, or vinyl seals.
- C. Glazing Gaskets: Manufacturer's standard extruded or molded plastic, to accommodate glazing thickness indicated.
- D. Glazing: Comply with requirements in Division 08 Section, "Glazing."
- E. Hardware: As specified in Division 08 Section, "Door Hardware".

2.4 FABRICATION

A. FRAME CONSTRUCTION

1. Factory pre-engineer and pre-cut interior aluminum frame components to the greatest extent practical. Linear glazing components fabricated in the field are not allowed. If necessary, allow for 2 inches excess vertical length for scribing to suit floor conditions. Face trim to be pre-cut to match jamb lengths. Machine jambs and prepare for hardware, with concealed plates, drilled and tapped as required, fastened in frame with concealed screws.
2. Provide concealed corner reinforcements and alignment clips for precise joints at butt or mitered connections.
3. Hardware Preparation: Factory interior aluminum frames to receive template mortised hardware; include cutouts, reinforcement, mortising, drilling, and tapping according to the Door Hardware Schedule and templates as specified in Division 08 section, "Door Hardware".

- a. Reinforce frames to receive surface mounted door hardware. Machine jambs and prepare for hardware, with concealed reinforcement plates, drilled and tapped as required and fastened within frame with concealed screws.
- b. Locate hardware as indicated.
- c. Coordinate locations of conduit, wiring boxes, and power transfers for electrical connections with Division 26 Sections.

4. Fabricate frames for glazing with removable stops to allow glazing replacement without dismantling frame.
5. Fabricate all components to allow secure installation without exposed fasteners.

B. INTERIOR ALUMINUM DOOR CONSTRUCTION

1. Factory pre-engineer aluminum doors and components to the greatest extent practical.
2. Hardware Preparations: Factory interior aluminum doors to receive template mortised hardware; include cutouts, reinforcement, mortising, drilling, and tapping according to the Door Hardware Schedule and templates as specified in Division 08 Section, "Door Hardware".
 - a. Reinforce doors to receive surface mounted door hardware. Machine and prepare for hardware, with concealed reinforcement plates, drilled and tapped as required and fastened within door with concealed screws.
 - b. Locate hardware as indicated.
 - c. Coordinate locations of conduit and power transfers for electrical connections with Division 26 Sections.
3. Clearances for Non-Fire Rated Door Frames: Not more than 1/8" at jambs

and heads, not more than 1/4" between pairs of doors. Not more than 3/4" at bottom.

4. Fabricate kits for glazing with removable stops to allow glazing replacement without dismantling.

2.5 ALUMINUM FINISHES

- A. General: Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for apply and designated finishes. Exposed surfaces to be free of scratches and other serious blemishes.
- B. Factory finish extruded frame components so that any part exposed to view upon completion of installation will be uniform in finish and color.
- C. Acrylic Finish: Comply with AAMA 603.5; baked to assure hardness.
 1. Color: As selected from manufacturer's standard colors.
 2. Color: As indicated in schedules on the drawings.
 3. Custom color to match Architect's sample.
- D. Clear anodic coating: Comply with AAMA 611
 1. Commercial, AAM12C22A21 clear anodized coating, 0.1 mill minimum thickness.
- E. Color anodic coating: Comply with AAMA 611
 1. Class II, AAM12C22A34 color coating electrolytically deposited, 0.4 to 0.7 mill minimum thickness.
 - a. Color: Bronze anodized
 - b. Color: Black anodized

PART 3 EXECUTION

3.1 EXAMINATION

- A. Examine substrates, areas, and conditions, with Installer present, for compliance with requirements for installation tolerances and other conditions affecting performance of the Work.

B. Verify wall thickness does not exceed standard tolerance of +/- 1/16".

C. General Contractor to verify the accuracy of dimensions given to frame and door manufacturer for pre-cut openings.

D. Proceed with installation only after unsatisfactory conditions have been corrected.

Remove and replace frames that cannot be satisfactorily adjusted.

3.4 PROTECTION

A. Provide protection required to assure that frames and doors will be without damage or deterioration upon substantial completion of the project.

3.2 INSTALLATION

A. General: Install and set interior aluminum frames plumb, rigid, properly aligned, and securely fastened in place; comply with Drawings and manufacturer's written instructions.

1. At fire-protection-rated openings, install frames according to NFPA 80,

B. Install frame components in the longest possible lengths with no component less than 48 inches.

1. Fasten to suspended ceiling grid at 48 inches on center maximum, using #6 sheet metal screws or other fasteners approved by frame manufacturer.

2. Use concealed installation clips to produce tightly fitted and aligned splices and connections.

3. Secure clips to extruded main-frame components and not to snap-in or trim members.

4. Do not use screws or other fasteners exposed to view when installation is complete.

3.3 ADJUSTING AND CLEANING

A. Final adjustments: Check and readjust operating hardware items immediately before final inspection. Leave work in complete and proper operating condition.

B. Clean exposed frames promptly after installation, using cleaning methods recommended by frame manufacturer and according to AAMA 609 & 610.

C. Touch up marred areas so that touch-up is not visible from a distance of 48 inches.

REPORT ON FIRE RESISTANCE OF WESTERN INTEGRATED MATERIALS EXTRUDED ALUMINUM DOOR FRAME

May 5, 1977 **WHI #495-0065**

Western Integrated Materials, Inc. successfully passed a 20 minute Fire Test on our Extruded Aluminum Door Frame for a 3' x 9' opening with a minimum wall thickness of 3-1/4".

October 2, 1981 **WHI #495-0368**

Western Integrated Materials, Inc. successfully passed a 20 minute Fire Test on our Extruded Aluminum Door Frame for a 8' x 10' frame with a minimum wall thickness of 3-3/8".

January 19, 1983 **WHI #495-0472**

Western Integrated Materials, Inc. successfully passed a 20 minute Fire Test on our Extruded Aluminum Door Frame for 6' x 9' with a minimum wall thickness of 3".

September 22, 1988 **WHI #495-0924**

Western Integrated Materials, Inc. successfully passed a 20 minute Fire Test on our Extruded Aluminum Frame Assembly for a 3' x 10' door frame and a 2' x 10' full height side light with a minimum wall thickness of 3-3/8".

October 11, 1989 **WHI #495-1002**

Western Integrated Materials, Inc. successfully passed a 20 minute Fire Test on our Series 400 (2 piece) Extruded Aluminum Door Frame for 8' x 10' with a minimum wall thickness of 3-1/2".

September 2, 1999 **WHI #495-1470**

Western Integrated Materials, Inc. successfully passed a 20 minute Positive Pressure Fire Test with Smoke and Draft Control on our Extruded Aluminum Door Frame for 6' x 9' with a minimum wall thickness of 3-3/4".

June 19, 2001 **WHI #495-1610**

Western Integrated Materials, Inc. successfully passed a 90 minute Positive Pressure Fire Test with Smoke and Draft Control on our Series 700 (2 piece) Extruded Aluminum Door Frame for 8' x 9' with a minimum wall thickness of 3-3/4".

Architectural Specifications for Positive Pressure Fire Test

- ❖ Meeting the UBC 97 Building Code 7.2 Part 1 and Part 2.
 - Part 1 - Fire Tested for 20 Minute Positive Pressure.
 - Part 2 - Smoke and Draft Control.
- ❖ Maximum Opening Size 6' x 9'.
- ❖ Series 300
Throat Size with Approval are 3-3/4", 3-7/8", 4-1/2", 4-5/8", 4-3/4", 4-7/8", 5", 5-1/4", 5-1/2", 6", 7-1/4".
- ❖ Series 400
Throat Size with Approval are 3-3/4" to 9-1/2"
- ❖ Our 20 Minute Fire Rated Door Frame is qualified for installation with a Category A and Category B door.
- ❖ Acceptable Labeled Hardware Mortised or Cylindrical Latch, Auto or Manual Mortised Flush Bolts, Surface Mounted Bolts, Concealed and Surface Mounted Fire Exit Hardware.