

Bronze Clad Steel Doors and Frames**Section 08 1140****PART I GENERAL****1.01 SUMMARY**

- A. Description: Work includes Bronze Clad Interior and Exterior Steel Doors, Frames, and related Sidelites, and Transoms where applicable.
- B. Related work not included in this section:
 - 1. Finish hardware including lock cylinders and thresholds.
 - 2. Glass and glazing.
 - 3. Caulking between frames and masonry.
 - 4. Structural members.

QUALITY ASSURANCE

- A. Applicable standards of the following as referenced herein:
 - 1. AAMA, American Architectural Manufacturers Association
 - 2. ASTM, American Society for Testing and Materials
 - 3. ADA, Americans with Disabilities Act
 - 4. CDA, Copper Development Association
 - 5. NAAMM / HMMA, National Association of Architectural Metals Manufacturers
- B. Quality is based on Bronze Clad Steel Doors and Frames manufactured by Stiles Custom Metal, Inc. www.stilesdoor.com
- C. Manufacturer shall have been regularly engaged in manufacturing bronze doors and frames for a period of ten years. Doors and frames shall be fabricated by a single manufacturer. The manufacturer must have an effective quality control system in place.
- D. Allowable Tolerances as stated in NAAMM / HMMA Technical Manual.

1.03 SUBMITTALS

- A. Shop drawings: Indicate in elevation with sections and details to scale. Include glass and metal thicknesses, joining details, field connections, anchorage, concealed and exposed fastening methods, door and framing reinforcement, and metal finishes. Indicate compliance with specified design criteria.
- B. Finish samples: Submit two (minimum 5" x 7") samples indicating texture and color and to be expected in finished work.
- C. Maintenance data: Give instructions for general maintenance and repair of surfaces and finishes.

1.04 WARRANTY: Warrant Bronze Clad Steel Doors, Frames, and Window assemblies against defects in materials and workmanship for three (3) years, beginning thirty days after shipment when handled, stored, and installed in accordance with manufacturer's instructions and NAAMM / HMMA Technical Manual. Adjustments made necessary due to shifting or settling of building structure shall not be covered by warranty. Clear coat manufacturers warranty applies.

PART II PRODUCTS**2.01 DOORS**

- A. Acceptable products: Bronze Clad Steel Doors & Frames manufactured by Stiles Custom Metal, Inc.
- B. Bronze Cladding Material: CDA Alloy 464 Naval Brass, minimum 0.045" thick.
- C. Finish: (Make Selections) *See www.stilesdoors.com for details
 - 1. Abraded Finish: (choose one) [#4 Satin], [#8 Polished], [Non-Directional], [Angel Hair], [Random Swirl]
 - 2. Color: (choose one) [Natural], [Medium Bronze], [Oil-Rubbed Bronze], [Dark Statuary Bronze]
 - 3. Clear Protective Lacquer Coating: (choose one) [No clear coat] [Satin], [Semi-Gloss], [High-Gloss]
- D. Design of stile and rail profiles: As indicated on drawings. Door thickness: (choose one): [1-3/4"] or [2"]
- E. Code may stipulate bottom rail height.

BRONZE CLAD STEEL DOORS AND FRAMES (continued)**F. Door Construction:**

1. Base steel doors minimum 0.056" thickness and shall be unitized construction with continuous forms reinforcement stiffening channels welded into door body consistent with Stiles steel door construction. Assembly with bolts, screws, or tie rod connections shall not be acceptable.
2. Bronze Cladding: Minimum 0.045" thick. Cladding shall be blanked-out from one sheet of metal. No welding shall be permitted. Exposed seams on door faces are not acceptable. Prior to cladding, base door shall have a permanent coating applied which will prevent galvanic reaction. Cladding shall be applied to door with a tested, permanent, lifetime compression adhesive.
3. Door edge construction: (choose one) [Stiles replaceable Air-Tek™ integral weather-strip], [Hairline Seam] Adhesive or screw-applied weather strip shall not be accepted.
4. Bronze cladding over aluminum or wood construction shall not be accepted.

G. Glass Lite Kits: (choose one)

[Molding type lite kit with mitered corners welded, finished smooth and re-grained to match. Molding on exterior side of door to be permanently attached. Interior removable molding shall be attached with #8 oval head sheet metal screws of matching material].

[Internal channel type, flush glass moldings, securely welded to the inside face of the door skin. Removable glass channel stops shall be butted at corner joints, secured to the door with concealed, #8, sheet metal screws. Exposed fasteners shall not be accepted].

2.02 FRAMES**A. Construction:**

1. Material shall be minimum 0.08" thick with the same texture and finish as doors.
2. Fabricate components in accordance with approved shop drawings. Frames shall be fully welded construction with welds ground smooth and blended to be indistinguishable from finished work. Finish shall match doors.

B. Exposed fasteners shall be countersunk and shall have finish to match framing color.**C. Exterior Door frames shall have Stiles replaceable Seal-Tek™ integral weather-strip at vertical jambs and head. Adhesive applied weather-strip shall not be accepted.****D. Hardware: Manufacturer shall prepare and reinforce for mortised templated hardware per manufacturers templates and in accordance with NAAMM / HMMA.****PART III EXECUTION****3.01 CLEARANCES AND TOLERANCES** shall be in compliance with NAAMM / HMMA standards.**3.02 SITE STORAGE AND PROTECTION OF MATERIALS**

- A. Deliver and store materials to prevent damaging and marring of finishes.
- B. Protection: Protect metal surfaces from contact with lime, mortar, cement, acids, and other harmful substances / surfaces, and from careless handling, storage or machining.

3.03 INSTALLATION

- A. Framing systems shall be installed per Stiles instructions and NAAMM / HMMA 840. Install frames without use of exposed fasteners, except where indicated on shop drawings.
- B. Door Installation: Install doors and hardware in accordance with manufacturer's product data. Adjust hardware for proper operation.

3.04 CLEANING: Clean doors and frames in accordance with manufacturer's special instructions.**3.05 MAINTENANCE:** Instruct the Owner's Maintenance Personnel regarding the operation and maintenance of these doors.

End of Section