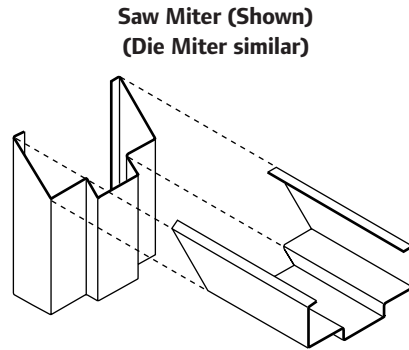
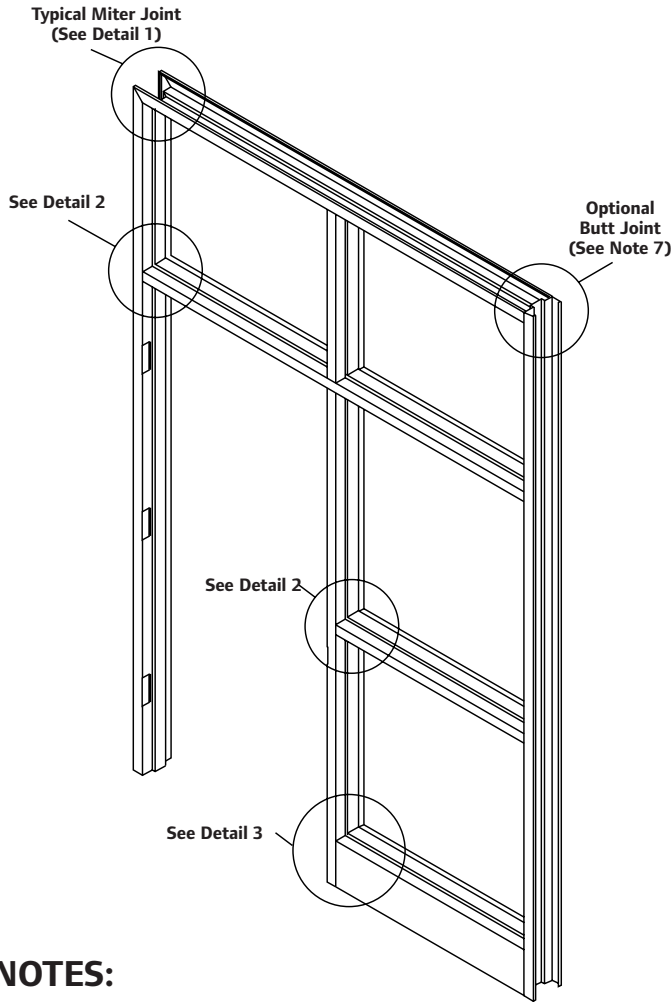
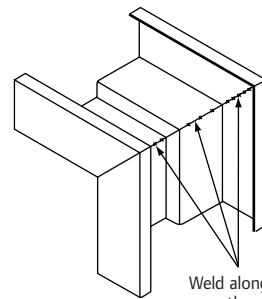


ELEVATION 1: TRANSOM AND SIDE PANEL OR LIGHT ASSEMBLIES



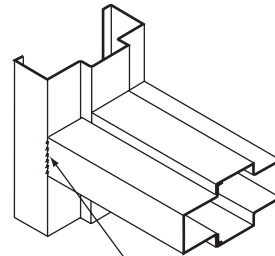
**Detail 1
Typical Corner Assembly**



Weld along inside of miter and grind smooth on outside face. Tack weld the rabbets and soffit on inside at jambs.

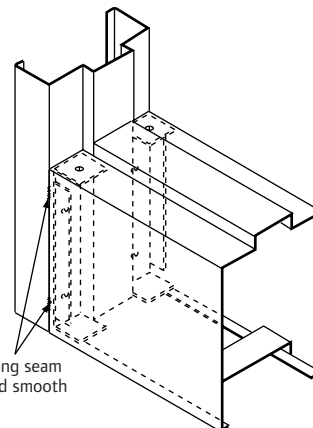
- For saw-mitered tack weld rabbets and soffit on inside of jamb
- For die-miter, bend interlocking miter tabs

**Detail 2
Mullion Connection**



Weld at joint along face and grind smooth

**Detail 3
Sill Connection**



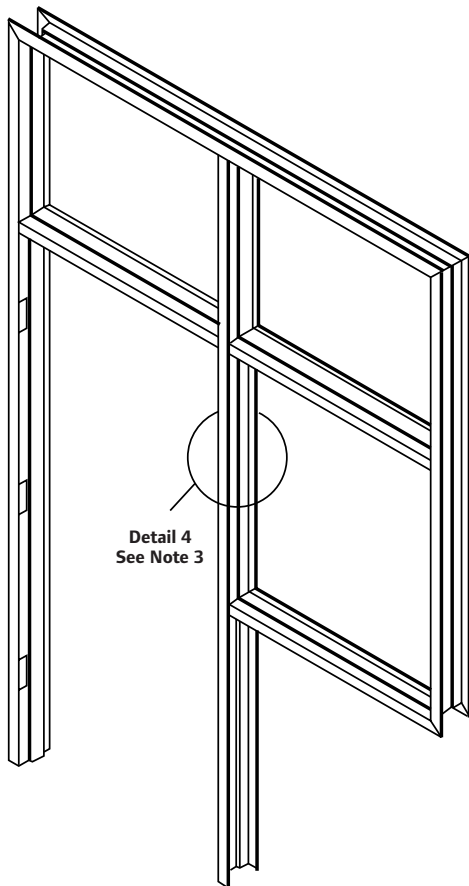
Weld along seam and grind smooth

NOTES:

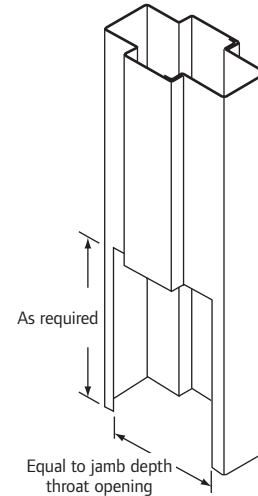
Transom and Side Panel/Light Assemblies are supplied in a multitude of elevation designs and sizes. The elevation and related details shown above are for reference.

1. The most common elevations used are with lights (windows). Glass can be of varying thickness which must be specified.
2. Perimeter jambs and head can be supplied either factory die mitered or saw mitered. Corner connections are usually supplied as welded (SUA).
3. **Removable transom bars** (above the door opening) can be supplied (when specified), to allow for passage of large equipment or objects through the door opening. If required, this feature must be specified, and the unit above the door would be a panel and not a light (glass).
4. **Transom panels** (above the door) are the same thickness as the door, and can be supplied (when specified) as:
 - With Transom Bar (fixed or removable) as shown above.
 - Without the Transom Bar (fixed or removable) for aesthetics or functionality.
5. **Removable mullions** (separating double doors) can be supplied (when specified), to allow for passage of large equipment or objects through the door opening.
6. All joints between meeting frame members are to be welded and finished in accordance with ANSI A250.8-1998.
7. If end jambs are specified as butt welded, frame must be installed in butted wall applications. Additional **field notching by others** will be required if the frame is installed in wrap wall applications.

ELEVATION 2 – PARTIAL SIDE PANEL OR LIGHT ASSEMBLIES

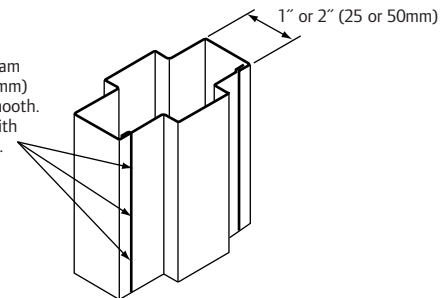


**Detail 4 – Closed Section
(with partial side light option)**
Available in F & FN-Series only.



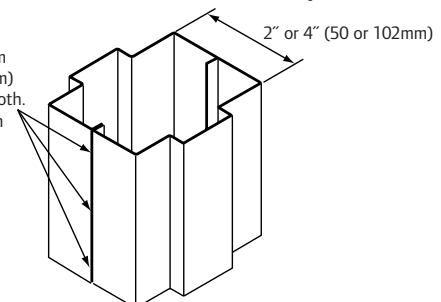
Detail 5 – Throat Filler Option

Tack weld along the seam approximately 8" (203mm) on center and grind smooth. Fill seam as required with filler and grind smooth.



Detail 6 – Double Frame Section Option

Tack weld along the seam approximately 8" (203mm) on center and grind smooth. Fill seam as required with filler and grind smooth.

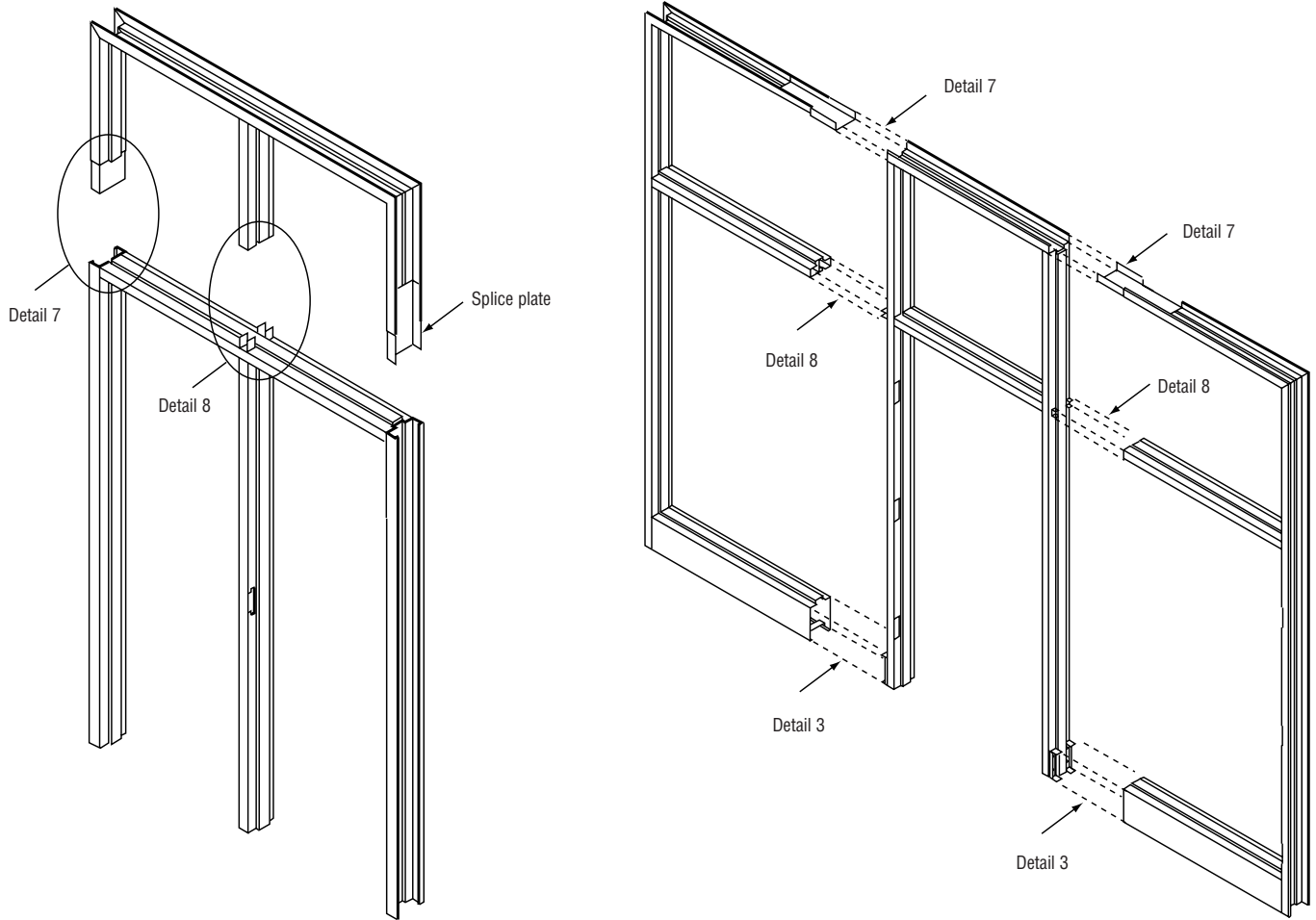


NOTES:

Partial Side Light Assemblies are supplied in a multitude of elevation designs and sizes. The elevation and related details shown above are for reference.

1. All notes shown on the previous page also apply to this type of elevation.
2. Since the side lights do not extend the full height of the mullion (which separate the door and transom area), care must be taken in fabricating the assembly.
3. Vertical mullions (separating the door and transom areas) must include provisions for glazing the sidelight unit, and can be accomplished in different ways:
 - **Closed section** – this section offers the best appearance, but must be supplied with an open frame throat to accommodate the wall construction below the side light. Available in F & FN-Series only. See detail 4.
 - **Throat opening filler plate** – can be installed, welded and finished to provide a closed section in the partial sidelight area of the elevation. See detail 5.
 - **Double frame sections** – can be utilized. For these elevations, the door frame and sidelight are one unit, but there is a visible seam separating the units. See detail 6.

FIELD JOINT/ SPLICE DETAILS: TYPICAL DETAILS



NOTES:

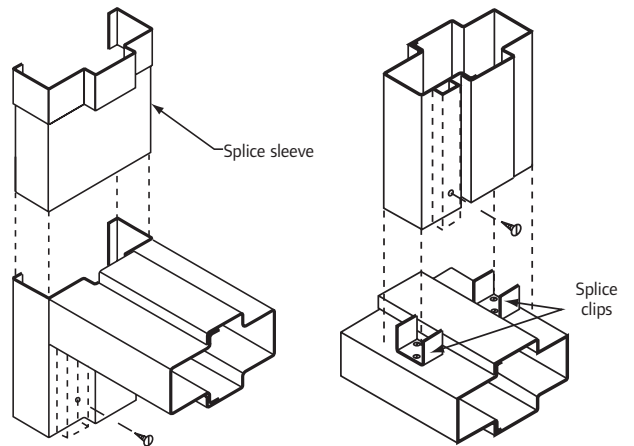
Field joint/splices of elevations are required when the assembly is too large to be fabricated in one piece. Some of the reasons for this practice are as follows:

1. Transportation limitations
2. Handling issues related to either the jobsite or during fabrication
3. Installation limitations

FIELD JOINT/SPLICE DETAILS

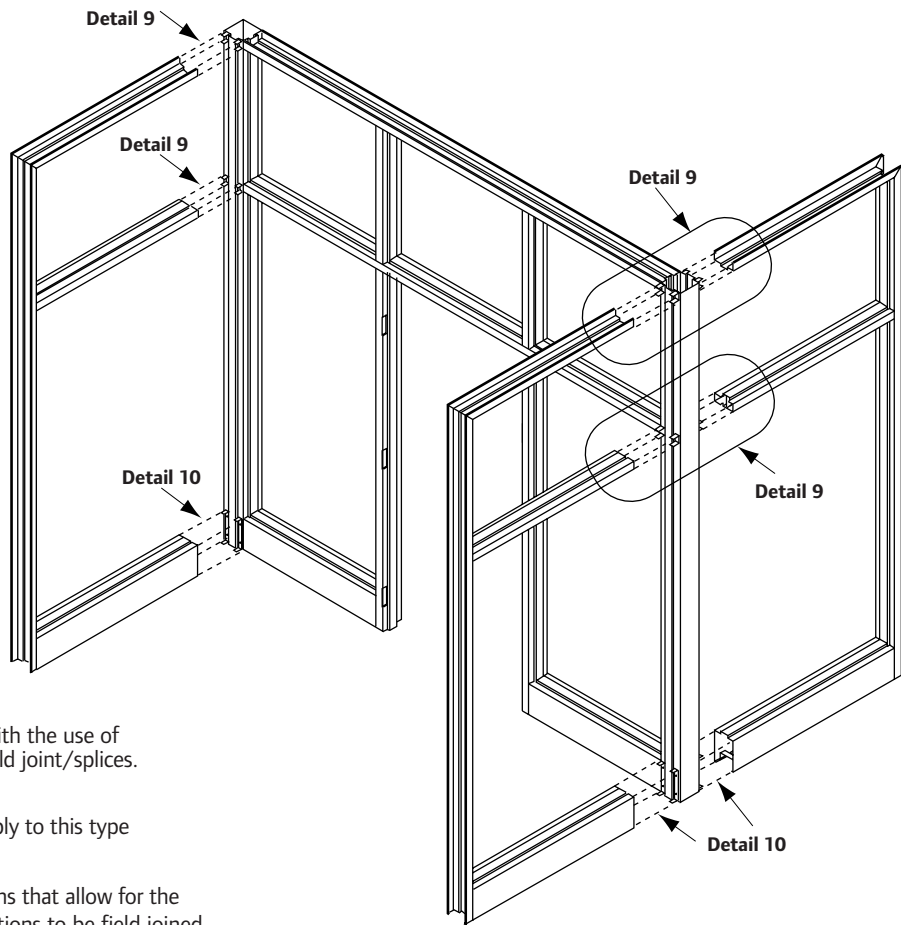
**Detail 7
End Jamb Connection**

**Detail 8
Mullion Connection**



FIELD JOINT/ SPLICE DETAILS: CORRIDOR AND ROOM ENCLOSURES

Corridor and Room Enclosures

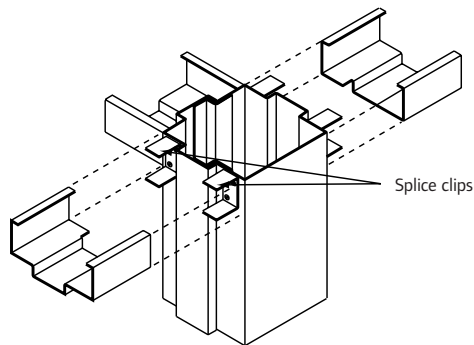


NOTES:

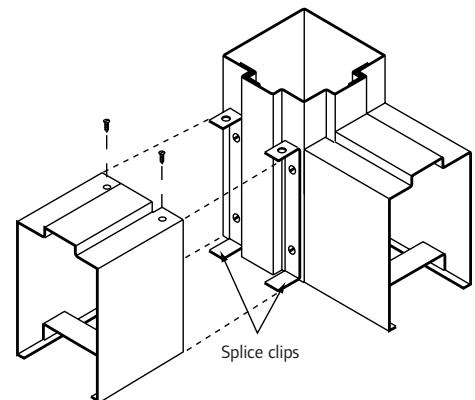
Corridor and room enclosures are accomplished with the use of "corner posts" (a frame stick component), and field joint/splices. The following notes apply.

1. All notes shown on the previous pages also apply to this type of elevation.
2. Corner posts are specially designed stick sections that allow for the connection of two Transom and Sidelight Elevations to be field jointed to make a corner.
3. At this time, corner connections are not Fire Rated applications.

Detail 9
Corner Post Connection



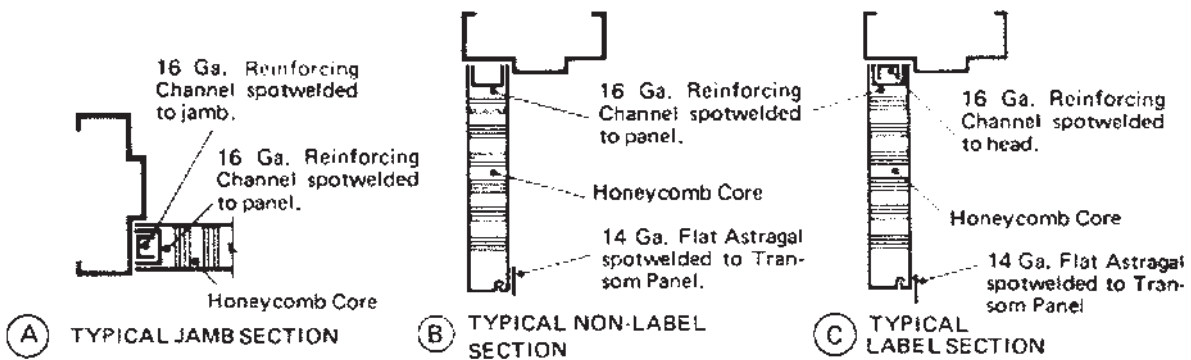
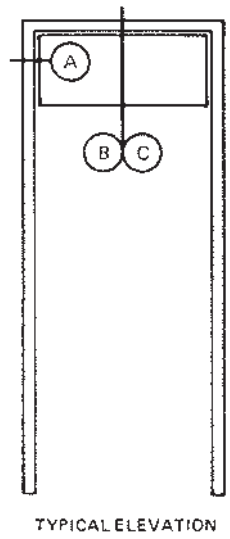
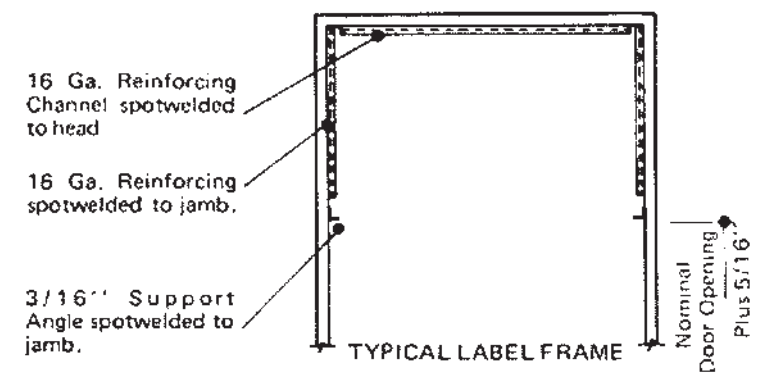
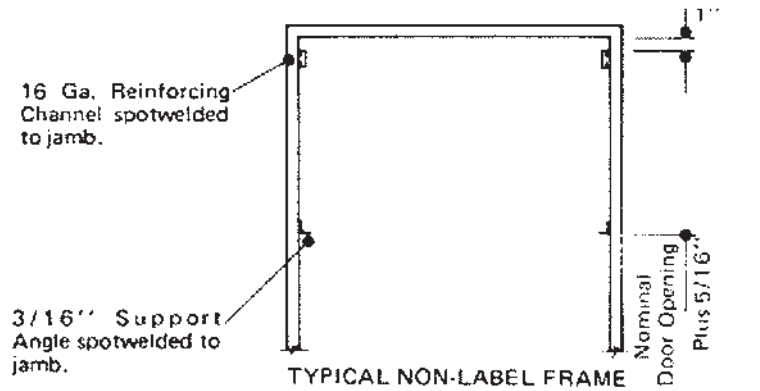
Detail 10
Sill Connection



TRANSOM PANELS WITHOUT TRANSOM BARS

NOTES:

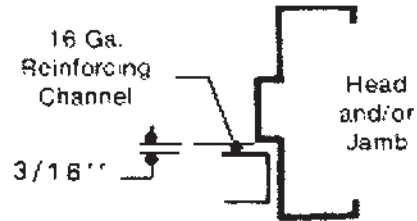
1. Transom panels are shipped loose for installation by others. Screws for attachment are supplied by Steelcraft.
2. Transom panels are phosphatized and finished with one coat of baked-on primer.
3. Transom panels are individually wrapped in corrugated cardboard with wood stripping on vertical edges of package together with metal banding.
4. Labeled panels are available in L18 door type only. For fire ratings and size limitations, see the **FIRE RATED** section of this manual.



TRANSOM PANELS WITHOUT TRANSOM BARS

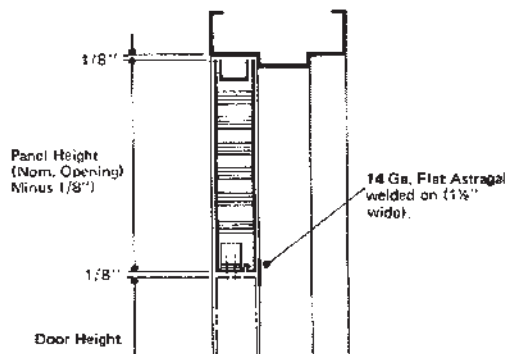
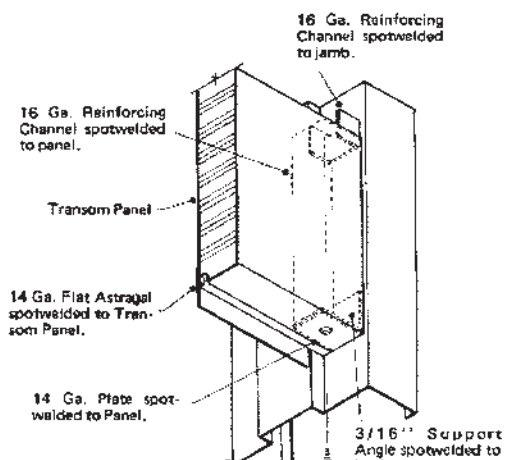
INSTALLATION:

1. Place panel in frame below channels and support angle.
2. Slide panel toward top of frame over channels until panel bottoms are on support angle.
3. Center punch thru holes on bottom edge of panel of each corner.
4. Drill .199" diameter hole (No. 8 drill) at center punches in support angle.
5. Install No. 12-24 flat head thread cutting machine screws to secure panel in place.

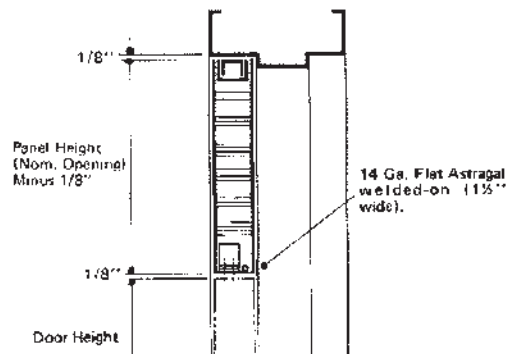
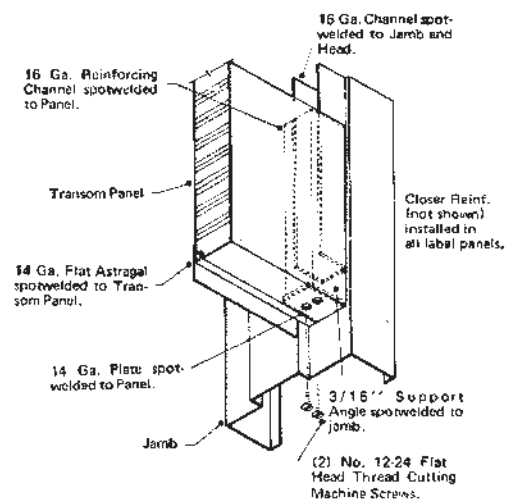


TYPICAL CHANNEL LOCATION

NON-LABELED TRANSOM PANEL



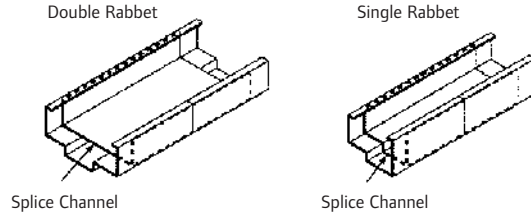
LABELED TRANSOM PANEL



Removable mullion: Cutting, notching and installation — **SPLICING HEAD AND JAMB SECTIONS**

Sometimes it is necessary to splice jambs and/or heads to make a long section. Steelcraft recommends the following method of splicing. It is recommended that the splice always be located over the center of a vertical member.

1. Install splice channel into end of one section. Allow half of the splice channel to extend out of the section.
2. Weld the ends of the splice channel to the frame section.
3. Slide other frame section over the splice channel and weld to the channel.
4. Weld the face joint and grind smooth.

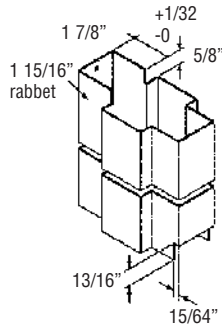


REMOVABLE MULLIONS:

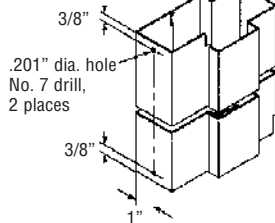
Double rabbet removable mullions can be made from TSF-16 or any intermediate strike mullion. The details shown illustrate the cutting and notching required to make the removable mullion.

REMOVABLE MULLION INSTALLATION

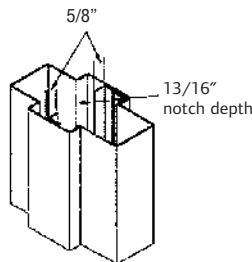
Notch mullion as shown
The mullion stiffener channel must be notched 13/16" deep at the bottom. See detail below.



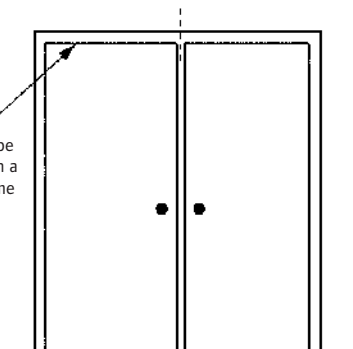
Drill holes as shown. All other mounting holes will be match drilled at installation.



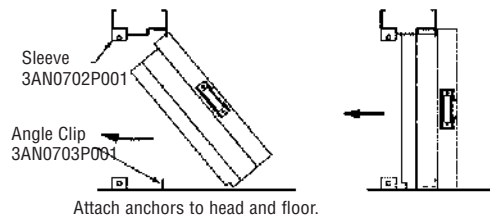
Bottom Notch Detail
Detail is shown reversed for clarity.



Note:
Frame must be 2" wider than a standard frame for a pair of doors.



Double Rabbet



Attach mullions to anchors (6 places)

Single Rabbet

