

TECHNICAL DATA-FRAMES

F and DW SERIES

ENGINEERING DETAILS for STANDARD SERIES F-16 and DW-16 UNI-FRAME[®] for 1³/₄" Doors

Specifications

1. Frames shall be manufactured of 16 gage prime commercial quality A60 galvanized sheets.
2. Frames shall be knocked down for field assembly. Miters shall have a precision hairline joint when assembled. OPTION: Corners shall be arc-welded and ground smooth, and frames shall be provided with steel bottom spreader.
Factory welded frames have spreader bar attached beneath the frame — it will be necessary to remove before setting the frame.
3. Heads shall be reinforced for surface applied closers, holders or brackets when required.
4. Dual purpose hinge reinforcements shall be 3/16" thick. It comes equipped with galvaneal back-up filler plate for standard weight hinges. Conversion from standard weight to heavy weight hinges is done by removing the filler plate. All reinforcements for hinges and strikes shall have steel-plaster guards.
5. All strike jambs shall be set out to suit pressure sensitive door silencers. Pressure sensitive silencers are purchased separately.
6. Frames shall be furnished with proper anchors as required to suit wall conditions. Frames shall have floor clips at bottom of all jambs for attachment to finished floor.
7. Heads of frames 4'-0" wide and over to be prepared with a universal "knock-out" to accept flush bolt on inactive door leaf.
8. Frames to be prime painted by Pioneer's exclusive "DURA-BOND" process, consisting of wash, phosphate treatment, "flo-coat" painting and oven-baking. in compliance with ANSI A250.10- 2004.
9. Frames to be furnished with UL or WHI listing mark (label) as required. Frame construction complies with ANSI A 250.8-2003 (SDI -100)
10. Frame construction complies with ANSI A 250.8-2003 (SDI -100)
11. Hardware preparations and reinforcements comply with ANSI A250.6-2003. Locations are in accordance with ANSI/BHMA A156.115-2006



The UNI-FRAME Assembly is designed to force selected frame components together with a hydraulic press creating specific door frame jambs or heads. This exclusive assembly method and patented design allows a nearly unlimited variety of frame jamb depths, sizes, hardware variations and applications. Interchangeable with integral frame members, the UNI-FRAME System provides a high degree of flexibility within your standard frame inventory.

UNI-FRAME[®] ASSEMBLY MACHINE for 1³/₄" Door Frames and Borrowed Lights

The UNI-FRAME Assembly Machine is a hydraulic press designed to force selected frame components together creating specific door frame jambs or heads.

Slightly over 26' long and 24" deep, the assembly machine stands about three feet tall and occupies a little over 50 square feet of floor space.

The machine is "one-sided" and may be placed against a wall.

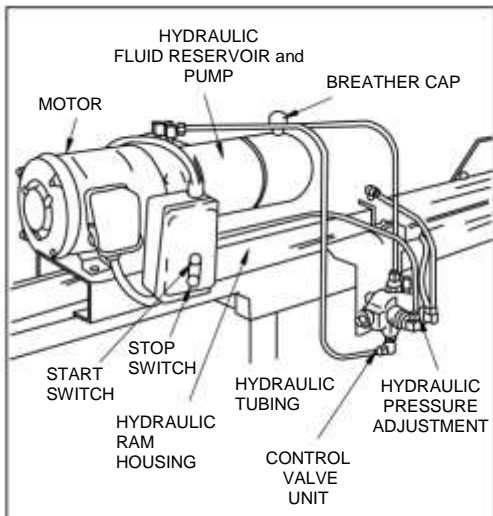
Single phase 220V electrical service of #12 wiring in 1/2" conduit is required. Provide adequate ground for motor. Check motor rotation before operating.



The machine is pre-assembled and tested at the factory before shipment. Little or no maintenance or adjustment is necessary. Consult the Uni-Frame Assembly Machine Manual concerning pressure adjustment and periodic maintenance. The pump reservoir has been filled with Texaco Regal Oil "PC" (R&O). In the event you have to add or change the oil you may substitute a good grade of automatic transmission fluid such as Ford type "F" or GM "Dextron".

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Setting up the job by staging all
The necessary components at the
Assembly machine area before
Starting to assemble the material
Can cut down the total time
Required to complete the job.

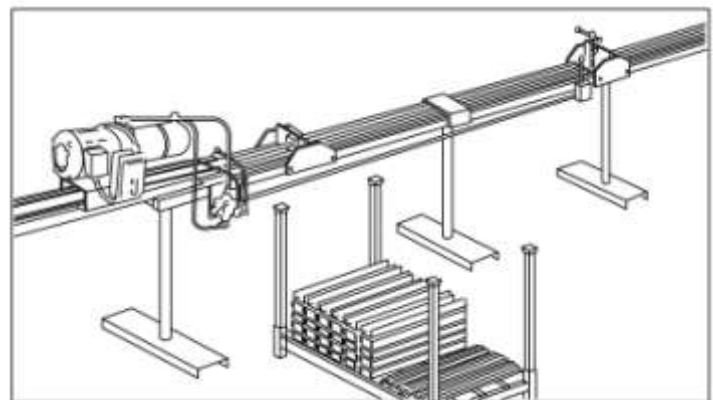
As the bolster must be moved
To accommodate the various
lengths of heads or jambs,
Stage and assemble material by
Size to reduce the Number of
Times the bolster position
has to be adjusted.

Uni-Frame components are nested and
prebundled in units of Ten (10)
individual pieces.

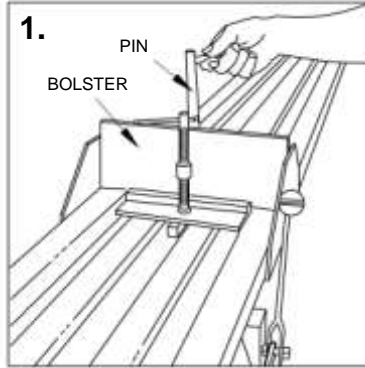
Each bundle and each individual
component is marked for identification.

Neatly racked material, stored close by
the work area, will facilitate assembly
with the least loss of efficiency.

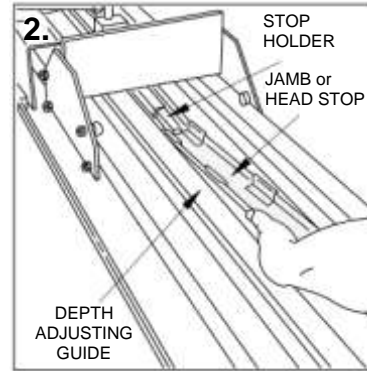
Uni-Frame components do not take up
a lot of valuable ware-house space.
Enough components to assemble 1000
frames can be stored in less than 100
sq. ft. of floor space.



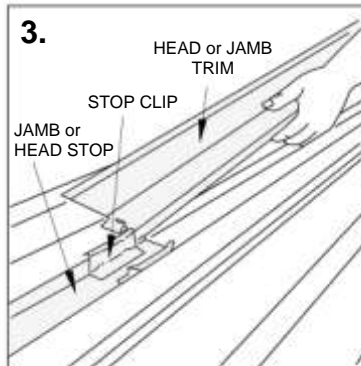
Assembly Details



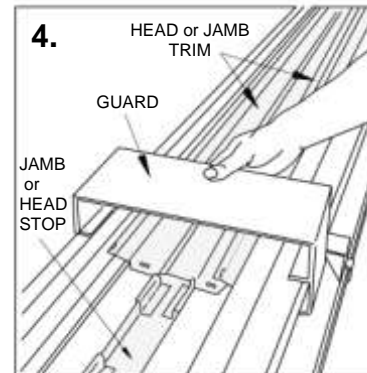
1. Move adjustable bolster to proper location for length of material to be assembled. Lock into position by dropping pin thru hole in bed of table



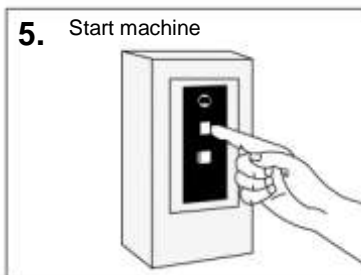
2. Place Jamb Stop or Head Stop member in slot in stop holder — clip side up. Squeeze yellow depth adjusting guides along both sides of stop, parallel with each other



3. Start Head Trim or Jamb Trim under first set of stop clips, with the rabbet resting on the yellow depth guides, parallel with each other. Do not use oil on stop clips to smooth out the friction. Excess oil on the prime paint will hinder finish painting

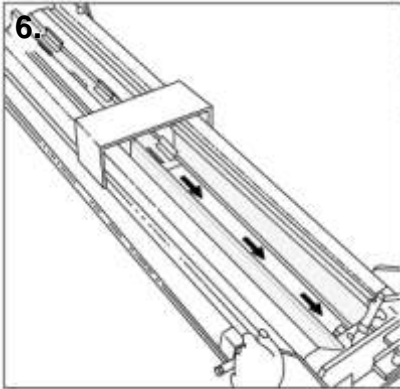


4. Keep Guard in place over material while assembling to prevent injury if material buckles and thrusts upward. Remove Guard for 4" head assembly

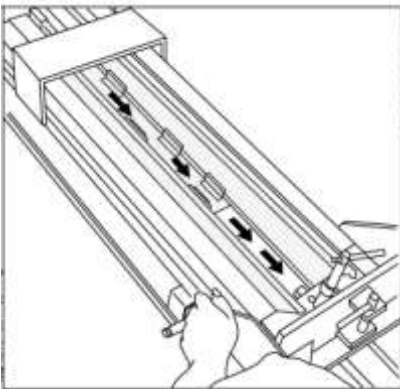


5. Start machine

The control valve has a spring return to the neutral position. Operator must hold control handle in forward position to assemble the components



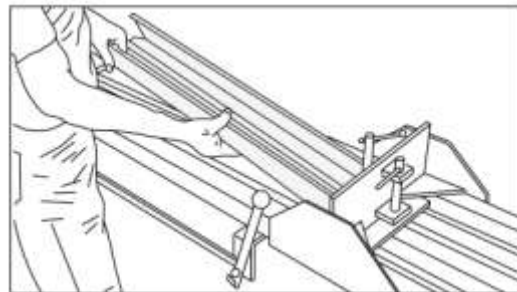
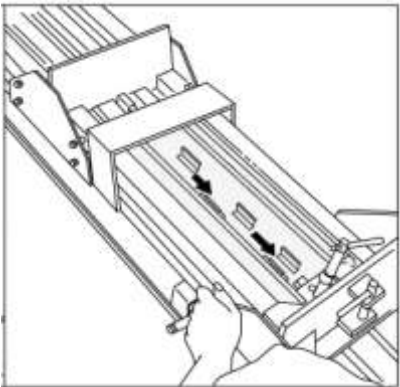
Push and hold control valve extension handle toward adjustable bolster. This will force stop member between the trim members.



The control valve will allow a measure of ram speed control. Slow down as you approach the end of a stroke. Retract ram immediately. The end of the stop may deform if allowed to stay under extreme pressure.

The control valve has a spring return to the neutral position for safety purposes. Operator must hold control handle in reverse to retract ram.

Do not be alarmed by the high pitched squealing sound at the end of the forward stroke or when ram is retracted. The pressure relief valve causes the oil to bypass at maximum pressure.

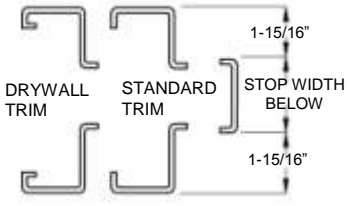
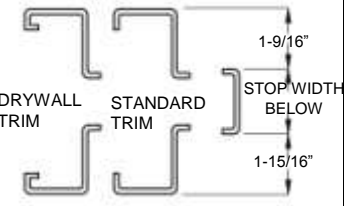
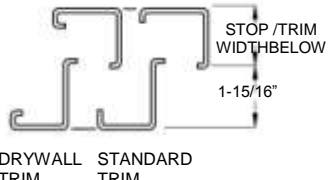


Remove frame member and repeat procedure

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UNI-FRAME[®] COMPONENT ASSEMBLY TABLE

JAMB WIDTH	EQUAL DOUBLE RABBET PROFILE		UNEQUAL DOUBLE RABBET PROFILE	SINGLE RABBET PROFILE
				
3"				1-1/16"
3-1/8"				1-3/16"
3-3/16"				1-1/4"
3-1/4"				1-5/16"
3-3/8"				1-7/16"
3-1/2"				1-9/16"
3-5/8"				1-11/16"
3-3/4"				1-13/16"
3-7/8"				1-15/16"
4"				2-1/16"
4-1/8"				2-3/16"
4-1/4"				2-5/16"
4-3/8"				2-7/16"
4-1/2"			1"	
4-5/8"			1-1/8"	
4-3/4"			1-1/4"	
4-7/8"		1"	1-3/8"	
5"		1-1/8"	1-1/2"	
5-1/8"		1-1/4"	1-5/8"	
5-1/4"		1-3/8"	1-3/4"	
5-3/8"		1-1/2"	1-7/8"	
5-1/2"		1-5/8"	2"	
5-5/8"		1-3/4"	2-1/8"	
5-3/4"		1-7/8"	2-1/4"	
5-7/8"		2"	2-3/8"	
6"		2-1/8"	2-1/2"	
6-1/8"		2-1/4"	2-5/8"	
6-1/4"		2-3/8"	2-3/4"	
6-3/8"		2-1/2"	2-7/8"	

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UNIFRAME ASSEMBLY COMPONENTS Cont'd:

6-1/2"	2-5/8"	3"	
6-5/8"	2-3/4"	3-1/8"	
6-3/4"	2-7/8"	3-1/4"	
6-7/8"	3"	3-3/8"	
7"	3-1/8"	3-1/2"	
7-1/8"	3-1/4"	3-5/8"	
7-1/4"	3-3/8"	3-3/4"	
7-3/8"	3-1/2"	3-7/8"	
7-1/2"	3-5/8"	4"	
7-5/8"	3-3/4"	4-1/8"	
7-3/4"	3-7/8"	4-1/4"	
7-7/8"	4"	4-3/8"	
8"	4-1/8"	4-1/2"	
8-1/8"	4-1/4"	4-5/8"	
8-1/4"	4-3/8"	4-3/4"	
8-3/8"	4-1/2"	4-7/8"	
8-1/2"	4-5/8"		
8-5/8"	4-3/4"		
8-3/4"	4-7/8"		