

SECTION 081613 - FIBERGLASS DOORS & FRAMES

PART 1 - GENERAL

1.1 SCOPE AND DEFINITIONS

- A. Furnish and install doors, frames of FRP composite construction in accordance with details and schedule shown on the project drawings and as specified herein.
- B. FRP is defined as "Fiberglass Reinforced Polyester"

1.2. RELATED SECTIONS

- A. Section 087100: Hardware

1.3 QUALITY ASSURANCE

- A. Experience: Manufacturer shall be ISO 9001 certified and been engaged in the manufacture of FRP door and frame systems for a minimum of five (5) years documented experience prior to the start of this work, and who has a history of successful production acceptable to the Architect.
- B. Process: Certify that FRP doors are manufactured via press-molding technology.
- C. Warranty: Provide written limited guarantee for FRP doors and frames as follows:
 - 1. Heavy Duty doors are guaranteed for the life of the product against delamination and failure due to products are inspected prior to shipment and guaranteed against defective workmanship for a period of ten (10) calendar years after the date of purchase.

1.04 SUBMITTALS

- A. Product Data: Provide catalog cut of FRP door detailing internal construction and reinforcements, materials used and description of molding process.
- B. Shop Drawings: To include the following specific information:
 - 1. Specifications relating to FRP door thickness, resin type, core material, method of construction, finish color, type of glass and glazing, anchor systems, joint construction and complete warranty information.
 - 2. Complete schedules or drawings of FRP doors and frames (and associated Builders Hardware) showing identifying mark numbers, door and frame types, typical elevations, nominal sizes, handing, actual dimensions and clearances, and required hardware preps and reinforcements.
 - 3. Supporting reference drawings pertaining to frame mounting details, door light or louver installation, hardware locations, and factory hardware cutouts and reinforcements.
- C. Color Samples: Provide a complete set of available finish colors from the manufacturer for color selection upon request.

- D. Installation instructions: Include manufacturer's specific information describing procedures, sequence and required fasteners for frame and door installation.
- E. Production of FRP doors and frames shall not proceed until final approval of submittals and all necessary manufacturing information is received from customer.

1.05 DELIVERY, STORAGE AND HANDLING

- A. FRP doors and frames are to be delivered to jobsite in adequate crating with foam sheet separations between all components.
- B. Handling and storage of the doors and frames after receipt is the responsibility/liability of the customer. Store indoors in a vertical position, clear of the floor, with blocking between the doors to permit air circulation between the doors and prevent damage to the door faces. Rain/water or condensation must not be allowed to collect or lay between stored doors. Do not wrap in plastic sheeting.
- C. Use care in handling FRP doors and frames to prevent damage to factory finishes. Wear protective gloves and do not slide or drag doors or frames against one another.

PART 2 - PRODUCTS

2.01 Manufacturer

- A. FRP Doors and Frames shall be as manufactured by Tiger Door, 5224 FM 802 Brownsville, TX 78521 ph 888.891.4416 Website: www.tigerdoor.com. FRP DOORS

2.02

A. Heavy Duty FRP Doors

1. Design: FRP doors shall be of seamless press-molded construction. Laminated FRP face sheets shall be applied while wet and uncured to an internal door stile and rail subframe/core assembly and then press- molded under heat and pressure. The composite door panel must be integrally fused over its entire surface area, not just adhesive-bonded at perimeter stiles and rails. Doors shall remain under pressure during curing for flat, warp-free surfaces.
2. Stiles & Rails: A high-modulus pultruded FRP square or rectangular tube subframe is to be provided within the door. Tubes are to be mitered and joined internally at the corners with solid polymer blocks to yield a one-piece unit that does not require any secondary external sealing. Provide a tubular midrail across width of door at lock height, and additional horizontal rails where specific design conditions dictate. Doors shall incorporate molded-in FRP edge strips, chemically bonded to the subframe stiles, for machining of hardware mortises so as not to cut or otherwise compromise the integrity of the pultruded stiles, nor allow moisture to penetrate into the core of the door. All connections shall be chemically welded. No mechanical fasteners will be allowed. The use or inclusion of aluminum, steel, gypsum or wood into stile and rail construction is not permitted.
3. Core: For maximum rigidity and compressive strength a triangular shaped 3/8" cell phenolic resin impregnated kraft paper honeycomb core shall be used. Molding pressure and resin gel time shall be sufficient to allow for penetration of resin into the cellular structure of the core to maximize shear and peel strengths at the skin/core interface and eliminate the possibility of delamination. The honeycomb is to be completely enclosed within the stile and rail subframe. Use of foam or balsa wood is not permitted.

4. Internal Reinforcement: High-modulus pultruded tubular FRP, high-density polymer compression blocks, or plastic compression blocking at all hardware locations, and corner locations. No wood blocking, steel or aluminum reinforcing plates, ribs or fittings shall be used. A minimum of 900 lbs of pullout strength is required for each factory supplied hinge screw.
5. Faces: Door facings shall utilize a chemical resistant thermosetting polyester resin system with fiber reinforcing layers. Supplier shall furnish door faces as shown on the drawings and in the door elevations. Chopped strand mat layers shall be used to provide bond integrity between gelcoat, laminated facings and the internal door structure. Structural reinforcement shall be in the form of a knitted multi-layer material with layers of uni-directional glass fiber oriented in both the vertical and horizontal directions for high stiffness, impact resistance and resistance to warping. Gelcoat surface integrally molded to be 25/30 mils thick (wet) ultra-violet light stabilized marine grade NPG-isophthalic polyester gelcoat.
6. Finish: The exposed FRP door faces shall have a 3-4 mils (wet) factory applied two-part aliphatic polyurethane fully cured coating of industrial urethane. Coating shall have a minimum hardness of H to 2H. Finish shall be a slightly textured semi-gloss to minimize the visual effects of wear and tear.
7. Provisions for lights shall be performed during manufacture and shall not be attempted in the field. Cutouts are to be totally enclosed by pultruded FRP stiles and rails incorporated into the door structure. Light cutouts that expose core material are not acceptable.

2.03 FRP FRAMES

A. FRP Frames:

1. Design: FRP Door frames furnished under this specification shall utilize a high-modulus pultruded structural FRP shape. The frame section shall be standard double rabbeted 5-3/4" deep x 2" face, 3/16" thick, with integral 5/8" doorstop with 1 15/16" soffits, to match typical hollow metal configurations.
2. Corner Joints: Frame jambs and header shall be joined at corners via miter connections with hidden FRP angle clips and associated fasteners. Post and beam corners will not be acceptable. Exposed fasteners for miter connections will not be acceptable except for wrap wall applications.
3. Hardware Reinforcements: FRP reinforcing shall be chemically welded to door frame material at required locations. Minimum screw pullout strength of 1100 lb per #12 x 1" sheet metal screw is required. Mechanically fastened reinforcements are not permitted.
4. Anchors:
 - a. Provide manufacturer's required number of wire or strap type anchors for installation into wall.
5. Finish: Frames shall have a 3-4 mils (wet) factory applied two-part aliphatic polyurethane fully cured coating of industrial urethane. Industrial urethane chemical coating color topcoat, to match the color and sheen of the doors, for superior weatherability. Gelcoat may not be sprayed onto the frame as a secondary coating.

2.4 FASTENERS

- A. All fasteners for all hardware shall be type 304 CRSS (18-8 series corrosion resistant stainless steel) with no exception. No carbon steel or aluminum components shall be used.

2.5 HARDWARE

- A. Hardware shall be furnished as listed in section 087100 or as so designated in appropriate section and shall be coordinated by GC and installed by experienced mechanics.
- B. Supplier shall furnish manufacturer's standard templates, installation instructions, or full size approved door and frame preparation instructions as approved by the architect and as required by door and frame manufacturer prior to door and frame factory initiated manufacture. Standard factory lead-time for production of FRP doors and frames shall commence only and when all distributor required preparation information is received and acknowledged by the door and frame manufacturer.

PART 3 - EXECUTION

3.01 IDENTIFICATION

- A. Factory mark all doors and frames using a chemical resistant plastic tag or indelible marker with identifying number, keyed to shop drawings, prior to shipment.

3.02 INSTALLATION

- A. Frames: Install in strict accordance with manufacturer's printed instructions. Set plumb and square, using shims for bolt-in of existing openings, or wood bracing prior to grouting of jambs. Use at least two 2x6 wood spreaders inside frame to maintain critical opening dimensions during grouting.
- B. Doors: Hang per manufacturer's printed instructions using special screws provided for hinge attachment. Install doors to swing freely and to stand open at any angle. After installation make final adjustments to hardware to allow for proper door operation and latching. All surface applied hardware shall be thru bolted.

3.03 CLEANING

- A. Clean exposed surfaces of FRP doors and frames with a mild, non-abrasive cleaner and water.

END OF SECTION 081613