

**Lansing Housing Products • 800-331-8200 • Fax 563-538-4392 • lansinghp@mchsi.com**  
**Model 504HW Tubular Steel Storm Door**

**SCOPE**

To furnish Tubular Steel Frame Self-Storing Storm Doors with hardware, door closure, durable kick panel(s), an adjustable sill sweep, a unique pre-hung frame liner with integrally mounted weather seal, and an integral security screen that protects the entire glass portion of the door, as manufactured by Lansing Housing Products.

**GENERAL**

1. Materials - The masterframe shall be of 18 gauge (16 ga optional), zinc impregnated (G-90) tubular steel. All tubular profiles shall be engineered specifically and exclusively for use as component parts for door fabrication.
2. Frame liners and door sweeps shall be formed from 6063-T5 aluminum.
3. The kick panels shall be of 18 gauge galvanized sheet steel, embossed for added rigidity.
4. Frame liner shall be of extruded aluminum. The head and side frame liners shall be designed to receive a flexible weather seal for protection against inclement weather and dust infiltration. A magnetic weather seal shall be available when specified. The head frame liner shall be so designed and extruded to also function as a drip cap over the top of the door.
5. The door shall be manufactured with not less than five (5) hinges. Leaf hinges shall be 430 stainless steel alloy, .072 wall thickness with stainless steel pins pivoting on oil-lite bronze bushings. Each hinge is integrally assembled into the Z-bar frame liner with stainless steel rivets.
6. The bottom of the doors shall have an aluminum extrusion that will accept a durable vinyl plastic door sweep, adjustable to a minimum of one (1) inch.

**CONSTRUCTION**

1. The tubular frame of the door shall be of 18 gauge, 1 x 2 tubular steel. The miter corners are uniformly welded on both the inside and the outside edge.
2. Two horizontal mullions of 18 gauge, 1 x 2 steel are fully welded into the main frame. The embossed 18 gauge steel kick panels are formed to two 90 degree bends and inserted into the frame assembly with the flange resting on the back surface of the frame and secured with screws on 6" centers.

**SCREENING**

1. The security screen, .018", .023", or .028" diameter stainless steel mesh or galvanized 18 gauge perforated metal (5/32" diameter holes on 3/16" staggered centers, 33 holes psi with a 63% open area), shall cover the entire upper glass surface.
2. The security screen will be bent to 90 degrees on four sides and secured into the upper door frame with 18 gauge steel angles with screws on not more than six inch centers.
3. Self Storing Window – the 6063-T5 alloy aluminum single hung vertically operated window unit shall be placed into the doors main frame and secured to inside of door frame. 1/8" tempered safety glass, miter joint construction with corners securely staked. Zinc die cast swivel key and spring loaded slide bolts. All panels are easily removed from the inside for cleaning. Screen insert protects from insect entrance.

**FINISH**

1. All exposed surfaces of all metal parts shall be free of surface blemishes. All sections either assembled or fabricated in factory, shall have 4 wash coats and finish coat applied after such assembly or fabrication is completed.
2. All mainframe Miter welded corners shall be pre-treated with a rust inhibitor prior to powder coat painting.
3. All prefinish treatments and wash coats shall be bake oven processed at 400 degrees F. Air-dry finish shall be unacceptable as offering an inferior finish for high density usage.
4. All exposed areas of stainless wire cloth and frames shall have a chemical pre-treatment process applied, with a finish of polyester powder coat paint, electrostatically applied, and cured to a hard durable finish. Powder coat paint finish shall be a minimum of 1.5 mil thickness.

**INSTALLATION KIT**

An installation kit shall be furnished with each door. The kit shall include all necessary zinc plated steel Phillips head screws, adjustable door closer, chain with hold up spring, push button type latch and brochure describing detailed installation procedures.