

Our specifications typically reference ANSI/NAAMM HMMA 840 for the Receipt, Storage, and Installation of Hollow Metal Door Frames. This three-part Quality Bulletin Series will review three specific items in the referenced standard.

The first of the three topics is the **TEMPORARY SHIPPING SPREADER BAR** and the **INSTALLATION** of the hollow metal door frames concerning the proper wood setting spreader bar use. Proper use of spreader bars is critical for the next step of installing the door hinges and the door. Ensuring that we properly remove the temporary shipping spreader bars and use premeasured door frame setting spreader bars as specified in HMMA 840, will reduce the amount of time and effort placed into the door installation and provide us with a better, higher tolerance door installation.

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- Some manufacturers install a highlighted **Installer Notice**, which states that the temporary shipping spreader bar(s) is to be removed before installing the door frame. **Regardless of this notice**, the spot-welded shipping spreader bar(s) must never be left installed during the installation of the hollow metal door frame for several reasons:
 - The purpose of the spot-welded temporary shipping spreader bar(s) is to hold the frame square during shipping and handling at the job site.
 - The temporary shipping spreader bar(s) are **NOT** the correct dimension between the frames; they are typically off by $\frac{1}{16}$ " to $\frac{1}{4}$ ".
 - The temporary shipping spreader bar(s) will **NOT** prevent the frame from twisting or bowing of the frame when grouted.
 - The spot welds have a thickness that will raise the frame up from the floor at varying heights.
 - The HMMA-840 standard clearly states that "**At no time are the spreaders to be left in during installation**". So, leaving the spreaders in place is contrary to the Contract Documents.
 - The temporary shipping spreader bar(s) is a hazard on the job site. Someone could easily trip over them.
 - Rolling carts and equipment could move the set door frame, placing the frame out of square and tolerance.



- Hollow metal door frames will arrive at the job site with minor alignment deviations; this is to be expected and corrected by the installer. Leaving the temporary shipping spreader bar on the frame during installation will likely mask the alignment deviations until the door is being hung, wasting time to correct the frame in the door hinges.



- After the spot welds are removed from the temporary shipping spreader bars, the welds will need to be ground down flush with the frame. The grinding area will need to be restored and refinished using a direct to metal primer as soon as possible to prevent rust from developing. Make sure that the fabricator provides the same installed primer.

