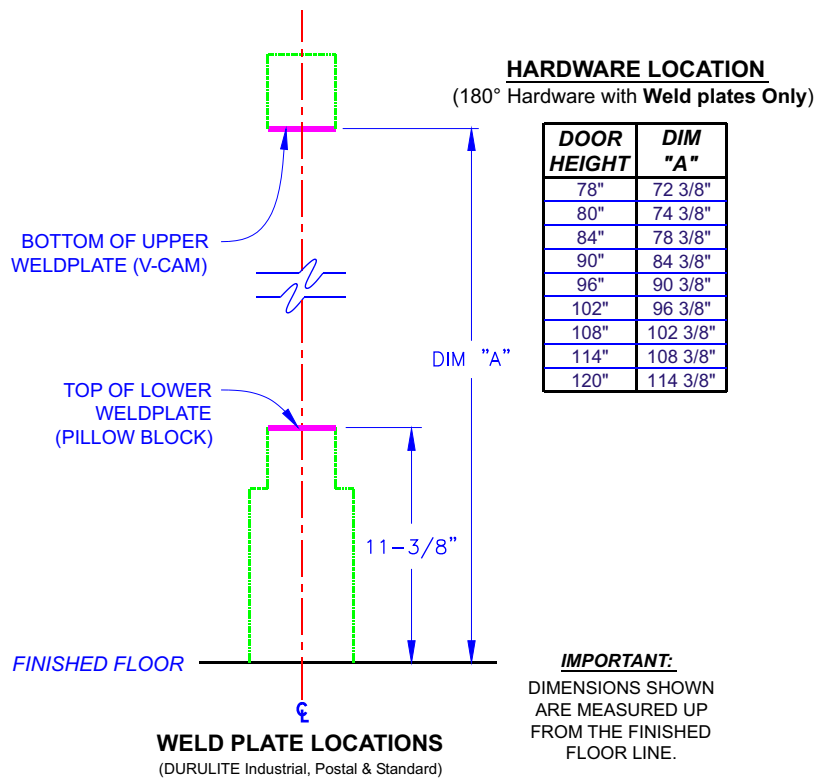


90° WELD PLATE INSTRUCTIONS

1. Mark jamb centerline at top of jamb and plumb to the bottom. Mark bottom plumb line.
 2. Match center lines of template to center lines on jamb and fasten with tape.
 3. Mark lines from template onto jamb with a straight edge. Remove template.
 4. Locate weld plates on jamb as shown in Figure 3 (Studs and threaded holes must be oriented as Shown, See Figures 1-A, 1-B & 2).
- IMPORTANT:** Weld plates MUST be aligned in the center of jamb and square with jamb for proper operation of doors. **Check before proceeding.**
5. Weld the plates to the jamb. Do Not extend the bead of the weld onto the face of the plates.
 6. Complete door installation as per Step 2 of your Durulite installation instructions.



FASTENERS

Industrial & Postal Pillow Block Weld Plate (Fig. 1-A):

1/4"-20X3/4" Hex Bolts - 3 ea. with Lock Washers
1/4" Castle Nuts - 5 ea. with Lock and Flat Washers

Standard Pillow Block Weld Plate (Fig. 1-B):

1/4"-20X3/4" Hex Bolts - 3 ea. with Lock Washers
1/4" Castle Nuts - 1 ea. with Lock and Flat Washers

V-Cam Weld Plate (Fig. 2):

1/4"-20X5/8" Hex Bolts - 2 ea. with Lock Washers
1/4" Castle Nuts - 2 ea. with Lock and Flat Washers

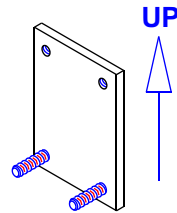
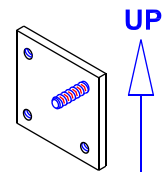
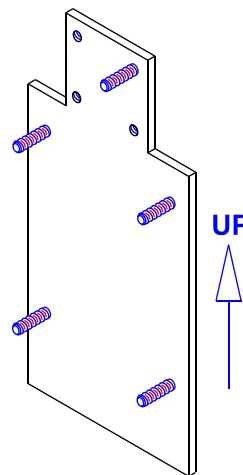


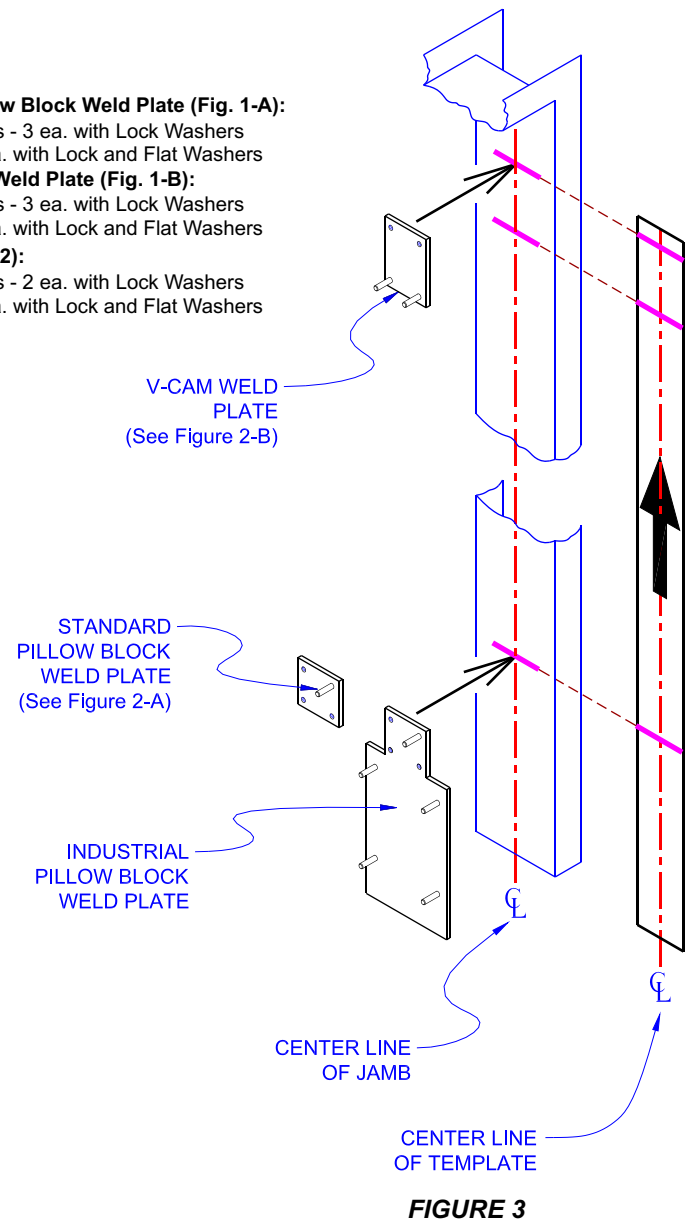
FIGURE 2



Standard 90°
FIGURE 1-B



Industrial & Postal 90°
FIGURE 1-A



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Title: WELD PLATE INSTRUCTIONS
Scale: N.T.S. DWG Name: WELDPLATES.DWG
Drawn By: MLW Sheet 1 of 1 Date: 11-08-01