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

**HARDWARE LOCATION**

(180° Hardware with Weld plates Only)

<table>
<thead>
<tr>
<th>DOOR HEIGHT</th>
<th>DIM &quot;A&quot;</th>
</tr>
</thead>
<tbody>
<tr>
<td>72&quot;</td>
<td>72 3/8&quot;</td>
</tr>
<tr>
<td>78&quot;</td>
<td>78 3/8&quot;</td>
</tr>
<tr>
<td>80&quot;</td>
<td>80 3/8&quot;</td>
</tr>
<tr>
<td>84&quot;</td>
<td>84 3/8&quot;</td>
</tr>
<tr>
<td>90&quot;</td>
<td>90 3/8&quot;</td>
</tr>
<tr>
<td>96&quot;</td>
<td>96 3/8&quot;</td>
</tr>
<tr>
<td>100&quot;</td>
<td>100 3/8&quot;</td>
</tr>
<tr>
<td>102&quot;</td>
<td>102 3/8&quot;</td>
</tr>
<tr>
<td>108&quot;</td>
<td>108 3/8&quot;</td>
</tr>
<tr>
<td>114&quot;</td>
<td>114 3/8&quot;</td>
</tr>
<tr>
<td>120&quot;</td>
<td>120 3/8&quot;</td>
</tr>
</tbody>
</table>

**IMPORTANT:**

Dimensions shown are measured up from the finished floor line.

**FINISHED FLOOR**

**WELD PLATE LOCATIONS**

(DURULITE Industrial, Postal & Standard)

**TOP OF LOWER WELDPLATE (PIVLL Block)**

**BOTTOM OF UPPER WELDPLATE (V-CAM)**

**HOLE DIMENSIONS**

**CENTER LINE OF JAMB**

**UP**

**CENTER LINE OF TEMPLATE**

**Figure 1-A**

**Figure 1-B**

**Figure 2**

**Figure 3**