STANDARD WELDED FRAMES
SERIES SQ, SR, SC AND SU

14 gage minimum steel reinforcement for surface applied hardware is installed before assembly (per template) when specified.

D or C MULLION WEB SHOWN REMOVED TO WRAP WALL

Standard slip-in or welded anchors are used at jambs, see sheet F12-2.

The elevation shown above is a basic example of the design freedom possible with Ceco standard series welded frames. Additional examples of standard elevations are shown on page F12-4.

Custom elevations are also available.

The welded connections above are illustrated on page F12-2.

For more on standard series frames see sheets F1 thru F2.
FRAME CORNER INTERSECTIONS
AND OPTIONS

1. MITERED HEAD OR BORROWED LITE SILL
   - V2 = FACE WELD ONLY (DIE MITER)
   - V3 = FULL FACE & WEB WELD (DIE MITER)
   - V5 = FULL FACE & WEB WELD (SAW MITER)

2. HEAD OR SILL
   - V6 = FACE WELD ONLY (BUTTED CORNER)

3. HEAD
   - V8 = FACE WELD ONLY

4. HORIZ. MULLION
   - V9 = FACE WELD BOTH SIDES

5. VERTICAL MULLION
   - V8 = FACE WELD ONLY
   - V6 = FACE WELD ONLY (BUTTED SILL)

6. JAMB
   - V6 WELDED
   - V8 WELDED
   - Sidelite Sill
   - * BRACING STRAP WHEN SILL IS OVER 4" HIGH

7. VERTICAL MULLION
   - V8 WELDED
   - 1/8" STEEL ANGLE AND 1/4"-20 NS ABOVE AND BELOW
   - D or C mullion web shown removed to wrap wall
   - V8 = FACE WELD ONLY

8. JAMB
   - 1/8" STEEL ANGLE AND 1/4"-20 NS ABOVE AND BELOW
   - IN-FIELD: FASTEN ANCHOR TO FLOOR, SLIP-FIT MULLION OVER ANCHOR

RETURN TO TOP
Typical Series SQ (equal double rabbet) or Series SU (unequal double rabbet) profiles are illustrated — other profiles or conditions e.g. single rabbet or cased opening are also available. Except where shown, mitered and welded components are notched or coped as necessary, fitted together and welded. Mitered frame corners require that faces be of equal size. Welded areas are ground smooth and spot primed in preparation for necessary finish painting. Welded units may require some field assembly, when sizes exceed 8'0" x 8'0".

Various carrier limitations involving size, frame configurations, along with safety concerns with weight are some factors. Contact CECO for specific design details.
The elevations on this page represent, schematically, a basic selection of popular designs which should satisfy most project needs. They have been standardized to expedite the estimating and ordering process. Easily tailored to suit contract conditions (dimensionally or proportionately), they can also be modified by adding elements: lites, door openings, impost, mullions, panels, louvers and special head treatments. By combining units in the field (by welding, splicing, splicing or by using pre-engineered corners), multiple door openings or window walls spanning large horizontal or vertical spaces can be achieved. Single swing, double swing, banks of door openings, Dutch frames, arched frames, communicating openings and an extensive selection of fire door frames are available.