This TDS details the installation requirements of Fleming R-Series, replacement frames. This series is designed for installation in existing frames.

1. **Size Opening**
   It is important to ensure that the R-Series frame is sized as follows:
   
   a) R-Series frame rabbet width = existing frame rabbet width less 3/4” (19.1mm) (minimum)
   
   b) R-Series frame rabbet height = existing frame rabbet height less 3/8” (9.5mm) (minimum)

2. **Assemble Frame**
   a) Insert jamb rabbet tab into slot at each end of head
   
   b) Ensure that face miters on jambs and head are tight and that the corners are square
   
   c) Bend the tabs at each head rabbet slot downwards away from the door opening

3. **Set Frame**
   a) Slide the assembled R-Series frame into the existing frame rabbet opening
   
   b) Place a temporary wooden spreader between the jambs at the floor. The spreader must be square, at least 1” (25mm) thick and almost as wide as the jamb depth of the R-Series frame
   
   c) Shim the bottom of the R-Series jambs to the same elevation so that the head is level
   
   d) Beginning with the hinge jamb, plumb and square the R-Series frame. Adjust for alignment and twist using shim stock as necessary
   
   e) Install a second temporary wooden spreader at the mid-height of the frame to maintain correct frame rabbet width

4. **Anchor Frame**
   a) For existing metal frames (hollow metal or aluminum), drill pilot holes (# 29 drill [.136” / 3.45mm diameter]) at each punched and countersunk face and rabbet anchor location. Pilot hole are not required for existing wood frames
   
   b) Secure R-Series frame to existing frame with # 8 x 3/4” (19mm) undercut, flat head screws
   
   c) Remove temporary wooden spreaders and re-check plumb, square, alignment and twist