

Maintenance of Installed Hollow Metal Products

The Hollow Metal Manufacturers Association (HMMA) recommends that all openings be inspected at least annually. Your local Authority Having Jurisdiction (AHJ) may have additional requirements.

HMMA's recommends the following inspections:

1. Hardware operation:

- a. Hardware fasteners: Tighten, repair or replace as required.
- b. Fully open and close door, checking for free swing without interference or binding.
 1. Hinges/Pivots: Adjust or replace as required.
 2. Latching hardware: Check for proper operation and latch engagement. Adjust, repair or replace latching device or strike as required.
 3. Control Hardware: Check for proper operation. Adjust, repair or replace as required.

2. Clearances:

Check operating clearances of the opening. The clearance between the top and vertical edges of the door and the frame, and the meeting edges of doors swinging in pairs, shall be 1/8 in. +/- 1/16 in. (3.18 mm +/- 1.59 mm) for steel doors and shall not exceed 1/8 in. (3.18 mm) for wood doors.

- a. When shimming of hardware is required to meet required clearances, steel shims are to be used.

3. Glazed openings:

- a. Glazing: Inspect for breakage. Replace in accordance with code-compliant product.
- b. Glazing compounds/sealants: Inspect for cracks and shrinkage that would affect the integrity of the seal. Repair or replace as required.
- c. Removable glazing stop: Ensure that all stops are present and secure. Replace or secure as required.

4. Frame anchorage:

Inspect that the frame is securely fastened. If not, adjust accordingly and re-inspect for: square, plumb, aligned and twist according to HMMA 840, "Installation and Storage of Hollow Metal Doors and Frames."

- a. Frame product with exposed anchorage (compression, existing wall, etc.) can be adjusted to address many of these issues.
- b. Frame product with unexposed anchors may require removal of frame, wall repair, or frame repair and/or replacement

5. Perimeter and joint sealant:

Exterior hollow metal frame products should be sealed for air and water infiltration in accordance with HMMA 820-TN03, "Guidelines for Glazing of Hollow Metal Transoms, Sidelights and Windows." Inspect for cracks and shrinkage that might affect the integrity of the seal. Repair or replace as required.

6. Gasketing:

Inspect for rips, splits or improper setting in gaskets. Adjust or replace gaskets as required.

7. Painted finishes:

Inspect surfaces for coating failure or surface abrasion. Damaged areas should be sanded and re-finished with a commercial direct to metal (DTM) primer and paint, or paint. For additional information refer to NAAMM/HMMA TechNote HMMA-840 TN01-01 "Painting Hollow Metal Products" and NAAMM/NOMMA AMP 500-06 "Metal Finishes Manual".

8. Dents:

Dents affecting operation of an opening must be repaired. If the dent cannot be repaired, the product must be replaced. Dents that do not affect the operation of the opening can be repaired by commonly accepted sheet metal repair practices. For fire rated openings, pending acceptance of the local authority having Jurisdiction, dents in the door faces measuring no greater than 1/8 in. in depth and less than 14 inches in length can be filled with industrial automotive body filler provided that no fracturing of the door face or corrosion is present. If corrosion or fracturing of the of the door faces is visible on a fire rated door, replacement of the door leaf is recommended.