

American National Standard

Test Procedure and Acceptance Criteria for – Physical Endurance for Steel Doors, Frames and Frame Anchors



Standards As Tough As Steel.™

SPONSOR

Steel Door Institute

Approved July 10, 2018



American National Standard
Test Procedure and Acceptance Criteria for –
Physical Endurance for
Steel Doors, Frames and Frame Anchors

Secretariat
Steel Door Institute

Approved July 10, 2018

American National Standards Institute, Inc.

American National Standard

Approval of an American National Standard requires verification by ANSI that the requirements for due process, consensus, and other criteria for approval have been met by the standards developer.

Consensus is established when, in the judgement of the ANSI Board of Standards Review, substantial agreement has been reached by directly and materially affected interests. Substantial agreement means much more than a simple majority, but not necessarily unanimity. Consensus requires that all views and objections be considered, and that a concerted effort be made toward their resolution.

The use of American National Standards is completely voluntary; their existence does not in any respect preclude anyone, whether they have approved the standards or not, from manufacturing, marketing, purchasing, or using products, processes, or procedures not conforming to the standards.

The American National Standards Institute does not develop standards and will in no circumstances give any interpretation of any American National Standard. Moreover, no person shall have the right or authority to issue an interpretation of an American National Standard in the name of the American National Standards Institute. Requests for interpretations should be addressed to the secretariat or sponsor whose name appears on the title page of this standard.

CAUTION NOTICE: This American National Standard may be revised or withdrawn at any time. The procedures of the American National Standards Institute require that action be taken periodically to reaffirm, revise, or withdraw this standard. Purchasers of American National Standards may receive current information on all standards by calling or writing the American National Standards Institute.

Published by

Steel Door Institute
30200 Detroit Road, Cleveland, Ohio 44145-1967

Copyright © 2020 by Steel Door Institute
All rights reserved.

No part of this publication may be reproduced in any form, in an electronic retrieval system or otherwise, without prior written permission of the publisher.

Printed in the United States of America

ANSI/SDI A250.4-2018

Contents

Page

Foreword	ii
1 Purpose	1
1.1 Reference documents.....	1
2 Apparatus and equipment	1
2.1 Door opener	1
2.2 Hardware.....	1
3 Preparation for test.....	2
4 Test specimen	2
4.1 Doors	2
4.2 Frames	2
5 Swing test.....	3
5.1 Doors	3
5.2 Frame.....	3
6 Twist test	4
7 Acceptance criteria	4
7.1 Doors	4
7.2 Frames	5
Figures	
1 Swing Test Detail.....	2
1A Swing Test Detail.....	3
2 Twist Test	4
Performance Reports	
Swing Test Form 1	6
Swing Test Form 2	7
Twist Test Form 3	8
Annex	
A Acceptance Criteria for Laminated Doors.....	9

Foreword (This Foreword is not part of American National Standard A250.4-2018)

The material contained in this document has been developed under the auspices of the Technical Committee of the Steel Door Institute.

The original standard was issued on July 28, 1980 and was revised in 1987, 1994, 2001 and 2011. The current edition is a revision of the 2011 document with the contents being updated to reflect changes that have taken place in the steel door and frame industry since that time.

Suggestions for improvement gained in the use of this standard are welcome, and should be sent to the Steel Door Institute, 30200 Detroit Road, Cleveland, Ohio 44145-1967.

The organizations which approved this standard and are part of the Accredited Standards Committee A250 formed February 8, 1991, are as follows:

- Avitru, Developers of MasterSpec
- Builders Hardware Manufacturers Association
- Cedar Valley Associates
- D.H. Pace Company
- Door and Hardware Institute
- ESTM Services, LLC
- FM Approvals
- HMMA/Division of NAAMM
- Intertek
- Steel Door Institute
- Therma-Tru
- Underwriters Laboratories LLC
- Vetrotech Saint-Gobain

The Technical Committee of the Steel Door Institute, which developed this standard, had the following personnel at the time of approval:

- Steve Gilliam, Chairman
- Tom Popow, Vice Chairman
- J. Jeffery Wherry, Managing Director

<i>Organization Represented</i>	<i>Name of Representative</i>
Ceco	Tom Janicak
Curries	David Bill
Deansteel Manufacturing Company.....	Claus Heide
DCI	Tom Popow
Hollow Metal Xpress.....	Henry Ray
Mesker Door Company	Mike Mehaffy
MPI	David McConnell
Pioneer	Kamal Sheikh
Republic	Steve Gilliam
SMP	Terry Simpson
Steelcraft	Marilyn Latham

American National Standard

Test Procedure and Acceptance Criteria for – Physical Endurance for Steel Doors, Frames and Frame Anchors

1 Purpose

The primary purpose of this procedure shall be to establish a standard method of testing the performance of a steel door mounted in a hollow metal or channel iron frame installed with appropriate anchors, under conditions that might reasonably be considered an accelerated field operating condition.

The user of this performance standard must temper their usage with the knowledge that there are many variables that affect door and frame performance, such as different hardware, anchors, glass and louver cutouts, field modification by parties other than the manufacturer, environmental factors, such as heat, cold, moisture, etc.

1.1 Reference documents

ANSI/BHMA A156.1-2013 *Butts and Hinges*

ANSI/BHMA A156.3-2014 *Exit Devices*

ANSI/BHMA A156.4-2013 *Door Controls – Closers*

2 Apparatus and equipment

The apparatus and equipment used shall be the same when testing doors or frames with frame anchors. The main testing structure shall be constructed as shown in figures 1 and 2. The structure shall conform to the parts shown, except the opening width and height are permitted to vary to allow the testing of various door sizes. The test frame for testing doors and frames shall be anchored in such a manner as to ensure rigidity.

The swinging mechanism shall be in two parts:

2.1 Door opener

The door opener shall be an air cylinder positioned at 65° to the plane of the door in its closed and latched position that will actuate an exit device mounted on the test door. The contact point shall be set to push the door open 60° ± 5°, and retract to allow the door closer to bring the door back into its original closed position and then begin the cycle again. See the requirements in figures 1 and 1A.

2.2 Hardware

The exit device, door closer and hinges used in testing shall be selected based on the door manufacturers' recommendations for the testing level described in Swing Test Form 1. The manufacturer and model numbers shall be recorded in the report. All hardware shall be applied to the door and frame with fasteners provided by the hardware manufacturer (for example, machine screws or sex bolts) in the location recommended by the door manufacturer. The hardware shall conform to the latest editions of American National Standards ANSI/BHMA A156.1, 3 and 4. The device shall be set to close the door at a rate of 15 cycles, ± 1, per minute.

Inspect all hardware and silencers at regular intervals, and adjust or replace as necessary. It is acceptable to apply lubrication to hinges and exit devices.

Note: Where the applicable BHMA Test Standards have been followed, this information shall be recorded in the test report.

3 Preparation for test

The door shall be hung in the frame on the hinges. Care shall be taken to ensure the hinges are properly applied to the door and frame as recommended by the hinge manufacturer, and any hinge fillers or shims, are in place. The clearances between the door and the frame shall be recorded in the test report.

The door frame shall be securely fastened to the test frame opening structure in accordance with the door manufacturer's instructions. The manufacturer is permitted to select anchors for specific wall applications (i.e., wood stud anchors or steel stud anchors, loose or welded in or existing masonry wall anchors).

Silencers shall be installed on the frame and the stop face of the door shall contact the silencers. The frame shall be plumb, square, and rigid.

When applicable, wall surface materials (e.g., dry-wall) shall be applied to the test frame opening at

the frame throat to simulate actual construction conditions.

4 Test specimen

4.1 Doors

Unless specified otherwise, the test shall be performed on a 3'-0" x 7'-0" nominal size door. A detailed description of the construction of the door and the applicable processes such as welding, bonding, etc., used for attaching components, shall be recorded in the test report, Swing Test Form 1, under the "remarks" section.

4.2 Frames

Unless specified otherwise, the test shall be performed on a 3'-0" x 7'-0" nominal size frame having a 5 3/4" jamb depth. A detailed description of the door frame and the applicable processes such as welding, bonding, etc. used for attaching components, shall be recorded in the report, Swing Test Form 2, under the "remarks" section.

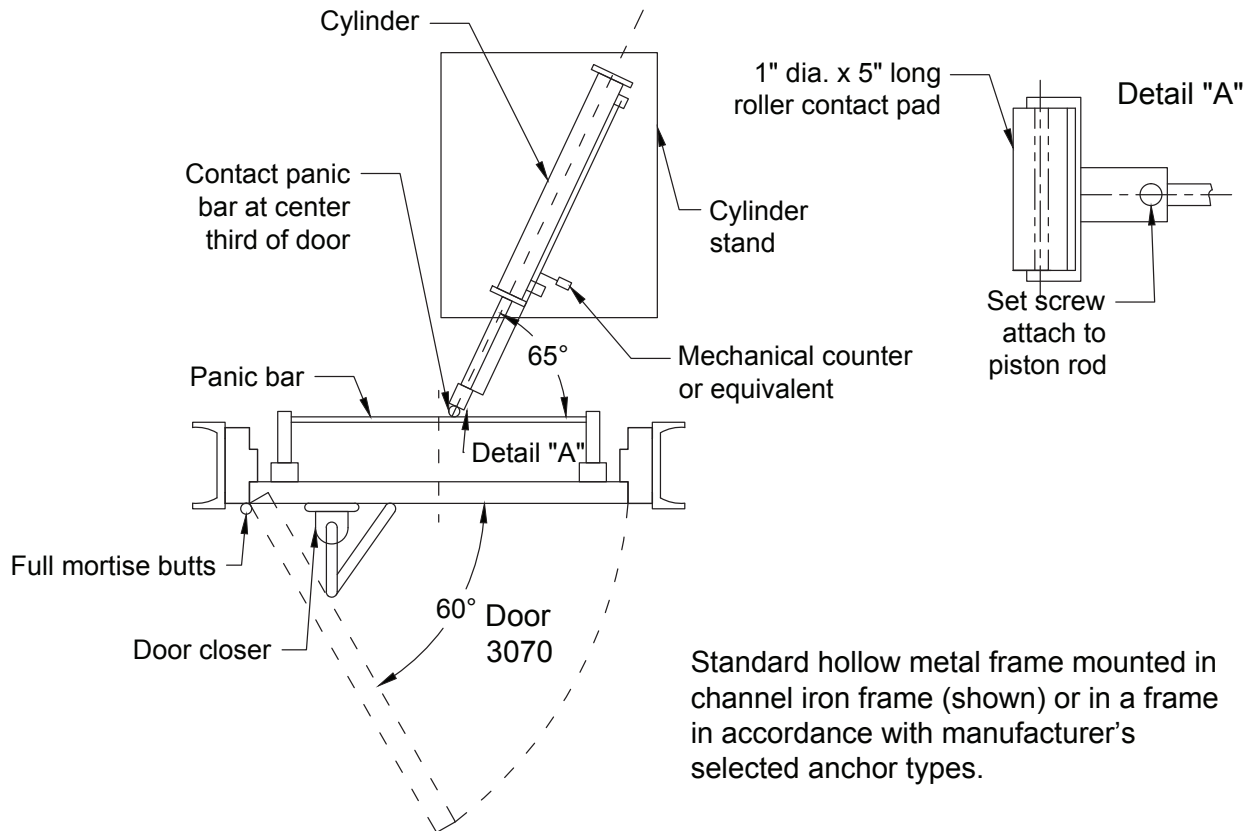


Figure 1 – Swing test detail for standard frame

A detailed description of the frame and anchoring system which shall cover all details of the anchors, as well as the means of attachment in the frame and the weight of the door used for the test shall be recorded in the test report, Swing Test Form 2.

5 Swing test

5.1 Doors

Duration of the test shall be 250,000 cycles with latching for Level C doors; 500,000 cycles with latching for Level B doors; and 1,000,000 cycles with latching for Level A doors. A general inspection of the door shall be made at 25,000 cycle intervals for the first 100,000 cycles and at 50,000 cycles thereafter. A mechanical counter or equivalent shall be used to record the cycles.

The general inspection shall cover perimeter clearances between door and frame and all components readily accessible, such as door face skins, exposed hinge and lock stiles, flush closing chan-

nels, end closures, hinge reinforcements, and lock body/face plate reinforcements and shall cover the integrity of assembly methods used to connect the door components.

Doors which have passed the cycling criteria at one level shall be deemed to have passed all lower levels. The results shall be recorded on a standard performance report, Swing Test Form 1.

5.2 Frames and frame anchors

Duration of the test shall be 250,000 cycles for Level C frames; 500,000 cycles for Level B frames; and 1,000,000 cycles for Level A frames. A general inspection of the frame shall be made at 25,000 cycle intervals for the first 100,000 cycles and at 50,000 cycle intervals thereafter.

The general inspection shall cover perimeter clearances between door and frame and all frame components readily accessible, such as corner clips and screws, corner tabs and slots, head and jamb tabs/slots hinge reinforcements, and strike

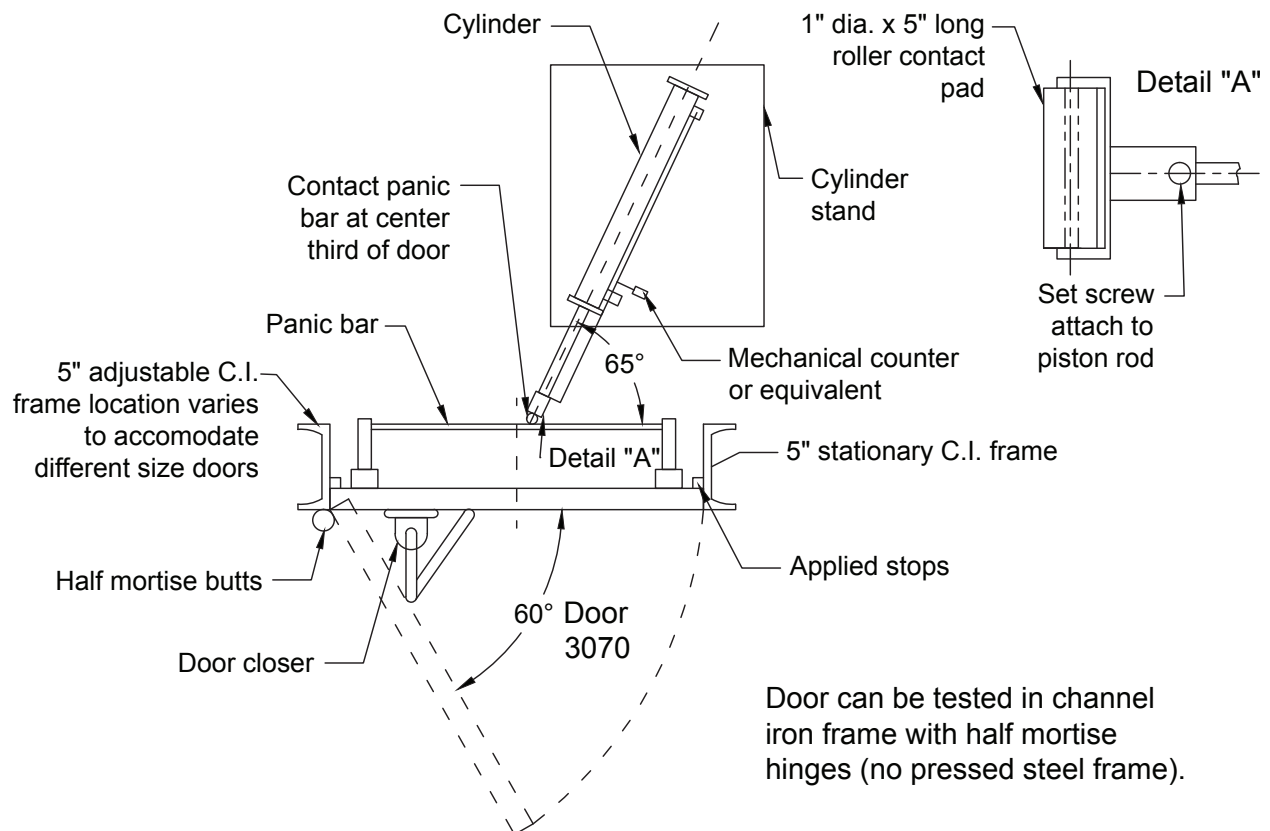


Figure 1A – Swing test detail for channel iron frame

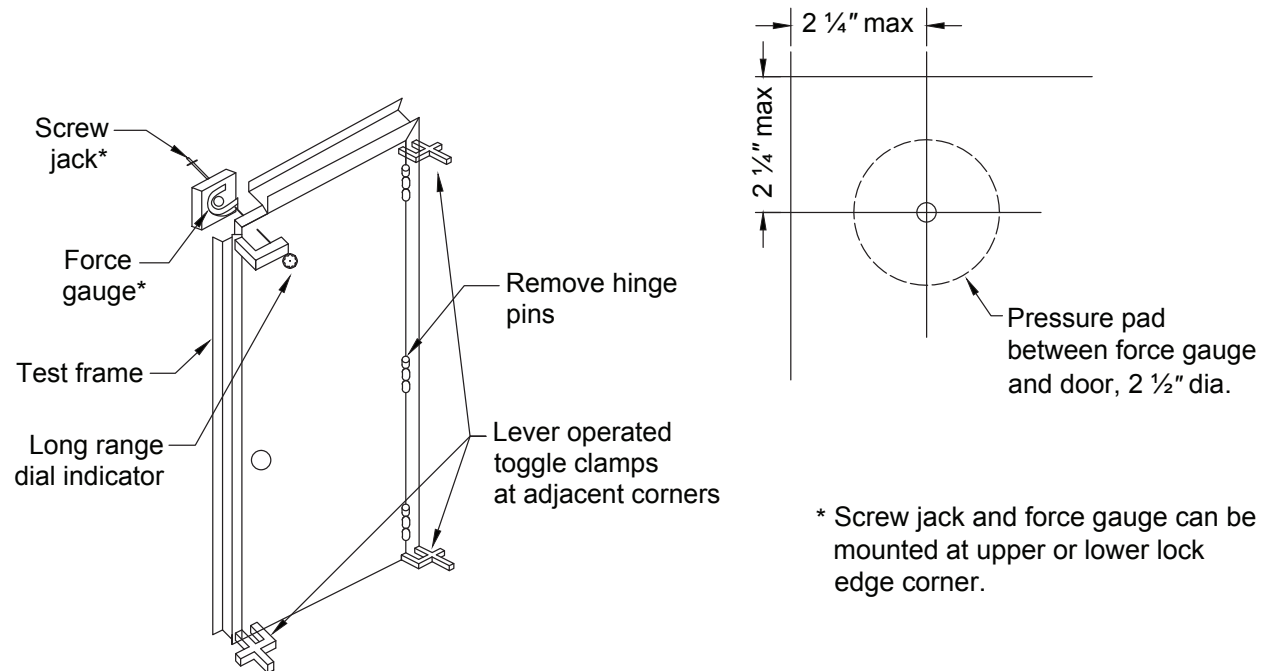


Figure 2 – Twist test detail

reinforcements and shall cover the integrity of assembly methods used to connect the frame components

Door frames which have passed the cycling criteria at one level shall be deemed to have passed all lower levels. The results shall be recorded as part of the test report, Swing Test Form 2.

6 Twist test

The twist test is applicable in evaluating door construction only.

The deterioration of the door strength during the cycle test, if any, shall be checked through a series of twist tests. These twist tests shall be performed before the cycle test begins and then at 25,000 cycle intervals for the first 100,000 cycles and at 50,000 cycle intervals for the balance of the test.

During the twist test, the hinge pins and silencers shall be removed from the door and frame assembly and the exit device shall be unlatched. The door is then clamped in place as noted in figure 2. If necessary to facilitate twist testing, the door is permitted to be taken from the test fixture and installed in a separate twist fixture. Loads in 30 lb. increments shall be applied at the upper or lower lock edge corner through the screw jack and force

gauge in the area illustrated in figure 2. The deflection noted on the dial indicator shall be plotted against the load applied to the corner on Twist Test Form 3. A maximum 300 lb. load shall be applied. The load shall then be reduced in 30 lb. increments and corresponding deflections recorded and plotted on Twist Test Form 3. A smooth curve drawn through the points shall graphically demonstrate the reaction of the door to increasing and decreasing pressures at different cycle intervals.

At the completion of each twist test, the hinges shall be reassembled by means of inserting the hinge pins, silencers shall be reinstalled, the exit device shall be latched, and the assembly shall be subjected to another 25,000 or 50,000 cycles. The condition of the silencers shall be noted and replacements made where deemed necessary.

7 Acceptance criteria

7.1 Doors

7.1.1 Doors shall not show any visual indication of metal fatigue, cracking or deformation at hardware cutouts or along form contours. Door must remain operable during the test. If the door fails to operate, it will be deemed to have passed the last passed cycle.

7.1.2 Doors of laminated construction (cores laminated to face sheets, channels or stiffeners laminated to face sheets, etc.) shall not delaminate in excess of 10% of the total surface area.

7.1.3 In doors of welded construction (stiffeners or channels welded to face sheets, etc.) breakage of welds shall not exceed 10% of the total weld of those face stiffeners.

7.1.4 Top, bottom or edge channels shall remain securely in place, without any weld breakage.

7.1.5 Where seams occur on doors, there shall be no opening or spreading of the seam.

7.1.6 All hardware reinforcements shall remain securely in place and show no visual signs of metal fatigue, cracking or deformation.

7.1.7 As a result of the twist test, the maximum deflection permitted shall not exceed 2 ½" when loaded to 300 lb. for Level C. For Level B and Level A doors the maximum deflection shall not exceed 1 ¼" when loaded to 300 lb.

7.1.8 Permanent deflection for doors shall not exceed ⅛" when load is removed after each twist test.

7.1.9 Tapped holes shall not strip.

7.1.10 At the completion of the swing and twist tests, the door shall be fully operable. If the door becomes inoperable, the door will be considered to have failed and the previous passed cycle will be recorded.

7.1.11 Upon completion of the foregoing checks and measurements, remove door from test structure and cut door into four equal sections with a horizontal and a vertical cut at the center of the door height and door width. Internal construction of door shall be inspected visually for delamination, metal fatigue, cracking and weld failure. The results of this inspection shall be recorded in the test report.

7.2 Frames and frame anchors

7.2.1 Frames shall remain plumb, square, rigid, and show no visual signs of metal fatigue, cracking, or deformation at hardware cutouts or along form contours.

7.2.2 Corners shall stay aligned with seams in a closed position.

7.2.3 Perimeter clearances between door and frame shall not be greater than ⅛" from those listed at onset of test.

7.2.4 All hardware reinforcements shall remain securely in place and show no visual signs of metal fatigue, cracking or deformation.

7.2.5 Tapped holes shall not strip.

7.2.6 At any time during the test, the frame shall not limit door operation. If during the test the door becomes inoperable, it shall be determined whether a defective door frame, hardware reinforcement, hinge, frame anchor, etc., caused the failure and shall be so noted in the test report.

Performance Report — Swing Test Form 1

Date _____

Test# _____

Manufacturers _____

Type and Size of Doors _____

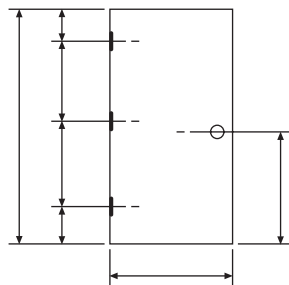
Weight of Door _____

Inspection at indicated cycle intervals ⁽¹⁾	1 25 M	2 50 M	3 75 M	4 100 M	5 150 M	6 200 M	7 250 M	8 300 M	9 350 M	10 400 M	11 450 M	12 500 M	13 550 M	14 600 M	15 650 M	16 700 M	17 750 M	18 800 M	19 850 M	20 900 M	21 950 M	22 1000 M		
Condition of edge weld/bond																								
Condition of lock prep.																								
Condition of hinge prep.																								
Top																								
Center																								
Bottom																								
Condition of top closure																								
Condition of bottom closure																								
Condition of door core/stiffeners																								
Condition of panels — general																								
							Level C Door ↑						Level B Door ↑											Level A Door ↑

⁽¹⁾ Indicates condition in appropriate columns:

S — Satisfactory

Use footnotes under Remarks for further explanation



Hinge Manufacturer & Number _____

Lock Manufacturer & Number _____

Closer Manufacturer & Number _____

Remarks:

Performance Report — Swing Test Form 2

Date _____

Manufacturers _____

Test# _____

Jamb Width _____

Type and Size of Frame _____

Weight of Door _____

Type of Anchors _____

Inspection at indicated cycle intervals ⁽¹⁾	1 25 M	2 50 M	3 75 M	4 100 M	5 150 M	6 200 M	7 250 M	8 300 M	9 350 M	10 400 M	11 450 M	12 500 M	13 550 M	14 600 M	15 650 M	16 700 M	17 750 M	18 800 M	19 850 M	20 900 M	21 950 M	22 1000 M	
Condition of general appearance																							
Condition of perimeter clearance																							
Condition of strike prep.																							
Condition of hinge prep.																							
Top																							
Center																							
Bottom																							
Condition of silencers																							
Condition of wall anchors																							
Condition of floor anchors																							
Condition of miters																							

Level C Door ↑

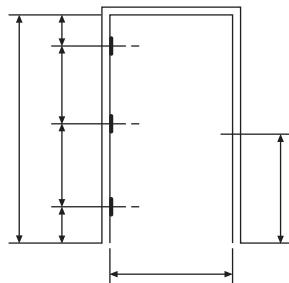
Level B Door ↑

Level A Door ↑

⁽¹⁾ Indicates condition in appropriate columns:

S — Satisfactory

Use footnotes under Remarks for further explanation



Hinge Manufacturer & Number _____

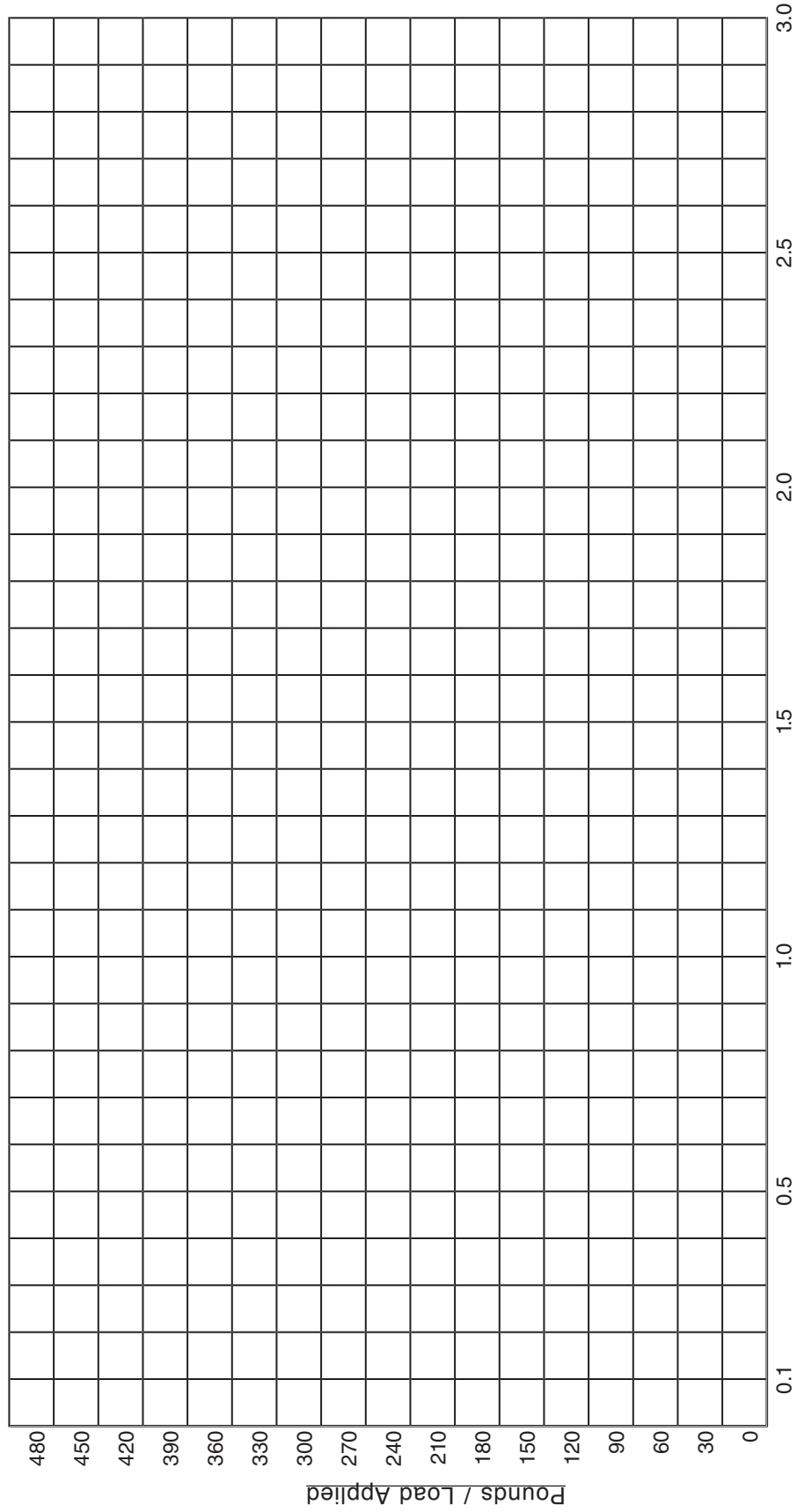
Lock Manufacturer & Number _____

Remarks:

Performance Report – Twist Test Form 3

Test No. _____ Date _____

Product Description _____



Inches / Deflection

Annex A
(informative)

Acceptance Criteria for Laminated Doors

Doors of laminated construction (cores laminated to face sheets, channels or stiffeners laminated to face sheets, etc.) shall not delaminate in excess of 10% of the total laminated surface area.

AVAILABLE PUBLICATIONS

Specifications

- ANSI/SDI A250.6** Recommended Practice for Hardware Reinforcing on Standard Steel Doors and Frames
- ANSI/SDI A250.8** Specifications for Standard Steel Doors and Frames (SDI-100)
- SDI-108** Recommended Selection & Usage Guide for Standard Steel Doors
- SDI-118** Basic Fire Door, Fire Door Frame, Transom/Sidelight Frame, and Window Frame Requirements
- SDI-128** Guidelines for Acoustical Performance of Standard Steel Doors and Frames
- SDI-129** Hinge and Strike Spacing
- SDI-133** Guideline for Specifying Steel Doors & Frames for Blast Resistance

Test Procedures

- ANSI/SDI A250.3** Test Procedure & Acceptance Criteria for Factory Applied Finish Coatings for Steel Doors and Frames
- ANSI/SDI A250.4** Test Procedure & Acceptance Criteria for Physical Endurance for Steel Doors, Frames and Frame Anchors
- ANSI/SDI A250.10** Test Procedure & Acceptance Criteria for Prime Painted Steel Surfaces for Steel Doors and Frames
- ANSI/SDI A250.13** Testing and Rating of Severe Windstorm Resistant Components for Swinging Door Assemblies for Protection of Building Envelopes (Not applicable for FEMA 320/361 or ICC-500 Shelters)
- SDI-113** Standard Practice for Determining the Steady-State Thermal Transmittance of Steel Door and Frame Assemblies
- SDI-131** Accelerated Physical Endurance Test Procedure for Steel Doors

Construction Details

- ANSI/SDI A250.11** Recommended Erection Instructions for Steel Frames
- SDI-110** Standard Steel Doors & Frames for Modular Masonry Construction
- SDI-111** Recommended Details for Standard Steel Doors, Frames, Accessories and Related Components
- SDI-122** Installation Troubleshooting Guide for Standard Steel Doors & Frames

Miscellaneous Documents

- SDI-112** Zinc-Coated (Galvanized/Galvannealed) Standard Steel Doors and Frames
- SDI-117** Manufacturing Tolerances for Standard Steel Doors and Frames
- SDI-124** Maintenance of Standard Steel Doors & Frames
- SDI-127** Industry Alert Series (A-L)
- SDI-130** Electronic Hinge Preparations
- SDI-134** Glossary of Terms for Hollow Metal Doors and Frames
- SDI-135** Guidelines to Measure for Replacement Doors in Existing Frame Openings

MEMBERS OF THE STEEL DOOR INSTITUTE

CECO

AN ASSA ABLOY DOOR GROUP COMPANY
9159 Telecom Drive
Milan, TN 38358-3425
(731) 686-8345
www.cecodoor.com

CURRIES

AN ASSA ABLOY DOOR GROUP COMPANY
1502 12th Street, P.O. Box 1648
Mason City, IA 50402-1648
(641) 423-1334
www.curries.com

DEANSTEEL MANUFACTURING CO.

931 S. Flores Street
San Antonio, TX 78204-1406
(210) 226-8271
www.deansteel.com

DCI

7980 Redwood Avenue
Fontana, CA 92336-1638
(909) 770-5700
www.doorcomponents.com

HOLLOW METAL XPRESS

602 S. 65th Avenue
Phoenix, AZ 85043
(623) 936-7000
www.HMXpress.com

MESKER DOOR, LLC

3440 Stanwood Boulevard
Huntsville, AL 35811-9021
(256) 851-6670
www.meskerdoor.com

MPI

319 North Hills Road
Corbin, KY 40701
(606) 523-0173
www.metalproductsinc.com

PIONEER INDUSTRIES, INC.

AN ASSA ABLOY DOOR GROUP COMPANY
111 Kero Road
Carlstadt, NJ 07072
(201) 933-1900
www.pioneerindustries.com

PREMIER STEEL DOORS & FRAMES

2840 Sterlington Road
Monroe, LA 71203
(318) 361-0796
www.trustpremier.com

REPUBLIC DOORS & FRAMES

155 Republic Drive
McKenzie, TN 38201-0580
(731) 352-3383
www.republicdoor.com

SMP

AN ASSA ABLOY DOOR GROUP COMPANY
5678 Concours Street
Ontario, CA 91764
(909) 593-2100
www.secmet.com

STEELCRAFT

9017 Blue Ash Road
Cincinnati, OH 45242
(513) 745-6400
www.steelcraft.com



Standards As Tough As Steel.™

STEEL DOOR INSTITUTE

30200 DETROIT ROAD • CLEVELAND, OHIO 44145
440.899.0010 • FAX 440.892.1404 • www.steeldoor.org