

# **ROLLING STEEL INDUSTRIES**

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## **SPECIFICATIONS OF ROLLING STEEL DOOR**

1. **CURTAIN:** Curtain shall be constructed of interlocking steel flat or curve slat panels 2.75" high and .75" deep. Each slat shall be cold roll formed from a single steel sheet of **20 gauge galvanized steel**. The ends of alternate slats shall be fitted with **malleable iron end locks** to maintain slat alignment and prevent steel-to-steel wearing as well as ensuring long lasting smooth operation.  
  
\*\*\* Curtain will have optional clear poly carbonate insert vision lights in groups of four. Each group of lights will be approximately 11" wide x 4 ¾" high.
2. **GUIDES:** Guides shall be cold roll formed from a single galvanized steel sheet of .125" thickness to create a self supporting seven leg 4" wide x 3" deep steel guide. Both guides shall be fitted with removable bellmount curtain stops to allow smooth operation. Each guide shall be continuous from the bottom of the opening to the top of the opening and extend above the opening header to support the coil brackets. Guides shall fasten to wall or wall framing with adequate fasteners not more than 30" apart.  
  
2A. **ALTERNATIVE GUIDES:** Fabricated from three cold rolled galvanized steel angles 8 GA thickness bolted together from a 3" wide guide.
3. **WEATHER SEALS:** Provide PVC clip on weather seal on each guide. At door head use 1/8" thick continuous sheet secured to inside of hood. (OPTIONAL)
4. **COUNTERBALANCE/SPRING ASSEMBLY:** Door shall be balanced by adjustable steel helical torsion spring mounted on a solid steel shaft and housed in a structural steel barrel that connects to the door curtain. All bearings shall be greased sealed and self lubricating.
5. **BOTTOM BAR:** Bottom bar shall be constructed of one (1) custom roll formed galvanized steel section with optional vinyl or neoprene weather seal on lower edge. The custom bottom bar is designed to interlock with slat contour.
6. **HOOD:** Hood shall be constructed of 24 gauge galvanized or painted over galvanized steel formed to fit the contour of the end brackets.
7. **OPERATION:** The door can be operated by manual push-up operation, manual pull chain, or electric motor.  
\*\*\**Any motorized door must be equipped with a reversing safety device.*