

Welded Locker Specifications

General Design: Steel Lockers are to be welded body construction with resistance spot welds no greater than 6" apart. Pop rivets shall be used to attach the locker frame to the body and hinges to the doors. Doors to be provided with steel recessed handles, flush decorative louvers, and quiet latches as detailed in this specification.

Materials: Doors, frames, and body parts shall be fabricated from prime quality, class one mild cold and hot rolled steel free from buckle, scale or other imperfections (A.S.T.M.-A1008).

Finish: All steel components shall be thoroughly cleaned and phosphatized for rust resistance in a five-stage pre-treatment process. A high grade of polyester / epoxy powder paint is to be applied electrostatically with a gloss reading of between 55 and 65. The finish shall have a salt spray rating of 250 hours or more.

Doors (except box style): To be die formed from one piece 16 gauge steel with right angles flanges on all four edges and two formations on hinge and lock sides. All doors shall have a 24 gauge ribbed pan stiffener resistance welded to provide extra rigidity and noise dampening. Each door shall have two rubber bumpers to contact the door frame when closed. Ventilation louvers shall be incorporated at the top and bottom of the door and shall not protrude beyond the face of the door for flush appearance. The louver width shall adjust proportionately with the door width. Additional ventilation holes shall be punched in the top and bottom door flange. Doors are punched to accept number plates.

Box Style Doors: Shall be die formed from one piece 18 gauge steel with right angle flanges on all four edges and two formations on hinge and lock sides. Ventilation louvers shall be incorporated at the top of door and shall not protrude beyond the face of the door for flush appearance. Additional ventilation holes shall be punched in the top and bottom door flange. Doors are punched to accept number plates.

C-Thru Doors (except box style): To be formed from one piece of 16 gauge steel with right angle flanges on all four edges and two formations on hinge and lock sides. Doors have rectangular cutouts on the front face for see through panels. Panels are made from $\frac{3}{16}$ " PMMA (Polymethyl Methacrylate). Panels are held against the inside face of the door by channels resistance welded to the inside of the door. There are no exposed fasteners on the outside of the door.

C-Thru Box Style Doors: Shall have Polycarbonate doors that incorporate internal corner-to-corner reinforcements for added strength.

Ventilated Doors: To be formed from one piece of 14 gauge steel with right angle flanges on all four edges and two formations on hinge and lock sides. The specially designed 1 $\frac{1}{2}$ " x $\frac{29}{32}$ " diamond shaped ventilation slots allow clear visibility to locker interior.

Door Frames: Vertical members shall be formed from 16 gauge steel into a channel shape with an extra return bend to provide a continuous full height door strike. Horizontal members shall be formed from 16 gauge steel into a channel shape and resistance welded to the frames with precision fixtures. Intermediate horizontal members shall be welded on double and triple tier locker frames.

Hinges: Shall be two inches high. 5 knuckle, full loop, tight pin style securely welded to the frame and riveted to door. Locker doors over 42 inches high shall have three hinges; doors 42 inches or less shall have two hinges.

Handles (except box style): Shall be recessed style and formed from 20 gauge steel as standard (or stainless steel as optional), finger lift shall be included. Recess shall be deep enough such that padlocks or built in locks will not protrude past face of the door. A recess is to be provided in handle to accommodate a number plate which will not protrude beyond the face of the handle. Handle to be securely fastened to the door by four rivets. Standard handle to be painted with black powder paint.

Latching Mechanism (except box style): Shall be the lift-latch style with spring actuated latches that permit securing the door with padlock or built-in locks engaged. Single tier lockers have a three point tamper-proof latch located at the top, center and bottom of the locking channel. Shorter doors are secured with two latches. Locking device to be tamper resistant and latches made of nylon (21-SP) for strength and quietness of operation. Latch hooks shall be electrically welded to the strike side of the locker frame to engage the nylon latches.

Latching Mechanism Box Style: Shall have zinc plated hasp attached to door and corresponding hasp welded to locker frame. Doors can be secured with either padlock or built-in lock.

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Body Parts: Shall be fabricated from 24 gauge steel. Backs to be one piece construction without holes for clean appearance. Sides to be off-set at the front to fit flush inside the frame, rear flange formed at right angles to fit around back. The front flange of the sides shall be punched to secure the frame assembly; otherwise there shall be no other holes. Tops, bottoms and shelves shall be formed at right angles on all four sides. The front shelf flange shall have a triple bend for safety.

Interior Configuration: Coat hooks are formed from steel with a “ball” point and are resistance welded to the locker body. Optional double prong hooks may be added by bolting to the center of the locker shelf.

Single Tier: Shall have a hat shelf with three single prong coat hooks, one on either side and one in rear. Coat rods will be provided on lockers 18-24” in depth. All single tier lockers to be provided with a hat shelf.

Double & Triple Tier: Shall have three single prong coat hooks.

Box Lockers: Do not have coat hooks.

Installation: Lockers should be installed level and square. For user safety, lockers must be secured to the wall and/or floor prior to operation. Adjacent lockers should be bolted together.