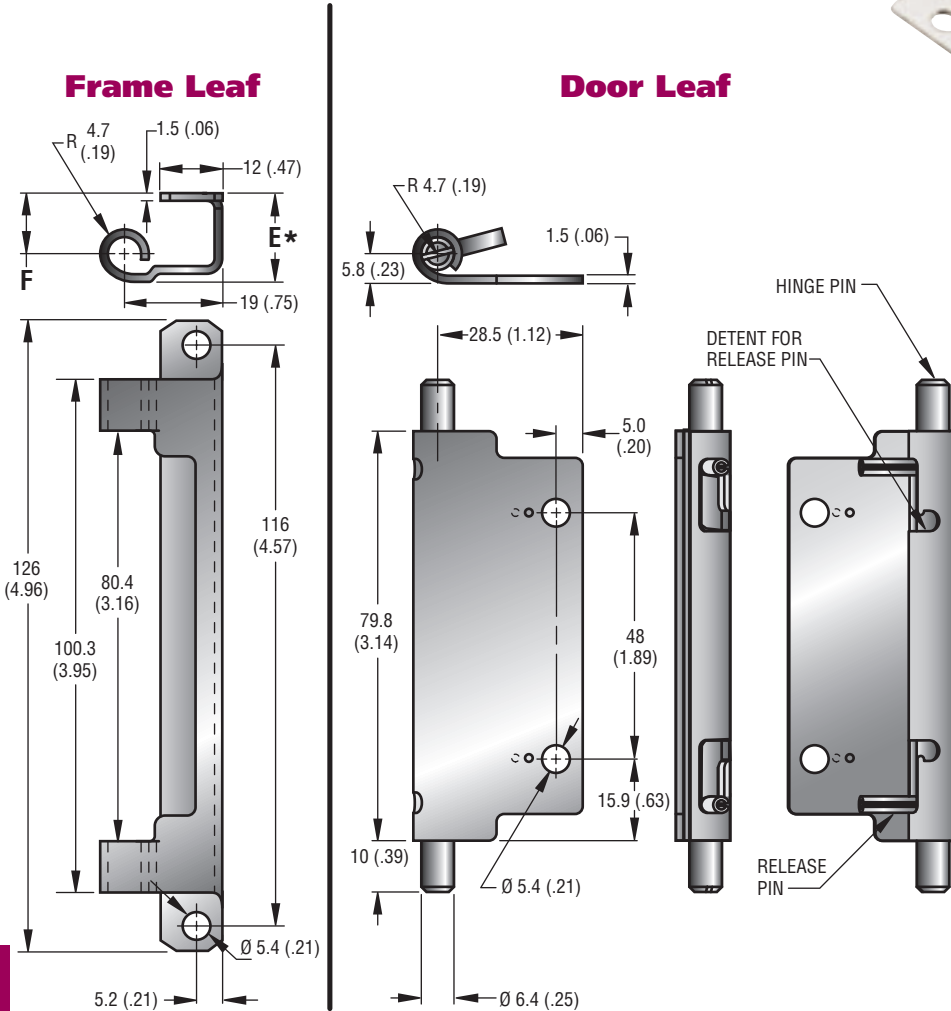
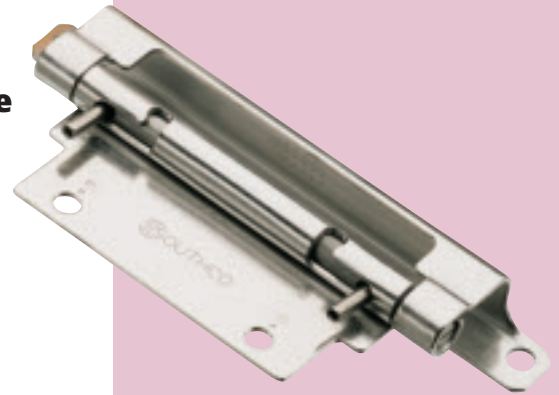


Southco Hinges

Concealed, Removable Style

- Mounts inside the frame of formed doors
- Hinge and hardware are concealed
- Allows the door to be removed from the hinge side
- Three styles to suit your door configuration



Material and Finish

Steel Version

FRAME LEAF, DOOR LEAF: 1010 steel, zinc plate plus chromate dip, yellow.
 HINGE PINS: 12L14 steel, zinc plate plus yellow chromate dip and clear organic coating.
 RELEASE PINS: 420 Stainless steel, passivated.
 INTERNAL SPRING: 302 Stainless Steel, passivated.

Stainless Version

FRAME LEAF, DOOR LEAF: 304 Stainless Steel, passivated.
 HINGE PINS: 303 Stainless Steel, passivated plus clear organic coating.
 RELEASE PINS: 420 Stainless steel, passivated.
 INTERNAL SPRING: 302 Stainless Steel, passivated.

Hinges
Door Positioning

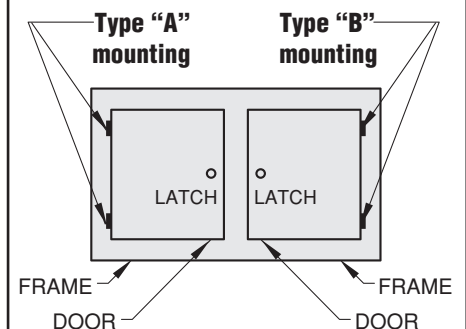
* Select the frame leaf with a value of **E** best suited to the configuration of your door. The dimension **E** + 0.6 (.02) = the distance from the outside surface of your frame to the inside surface of your door.

SERIES	PART NUMBERS (BULK PACKAGED **)				FRAME LEAF DIMENSIONS		PART NUMBERS (ONE ASSEMBLY PER BAG †)	
	Frame Leaf		Door Leaf		E*	F	Steel	Stainless Steel
	Steel	Stainless Steel	Steel	Stainless Steel				
1	F6-901 •	F6-901-1 •	F6-940 •	F6-940-1 •	17 (.67)	11.8 (.47)	F6-1 •	F6-1-1 •
2	F6-902 •	F6-902-1 •			20 (.79)	14.8 (.58)	F6-2 •	F6-2-1 •
3	F6-903 •	F6-903-1 •			23.4 (.92)	18.2 (.72)	F6-3 •	F6-3-1 •

These Part Numbers specify bulk packaged parts. **IMPORTANT: For one complete assembly, order 1 FRAME LEAF Part Number and 1 DOOR LEAF.

† These Part Numbers specify assemblies packaged 1 FRAME LEAF and 1 DOOR LEAF per bag.

Mounting Options

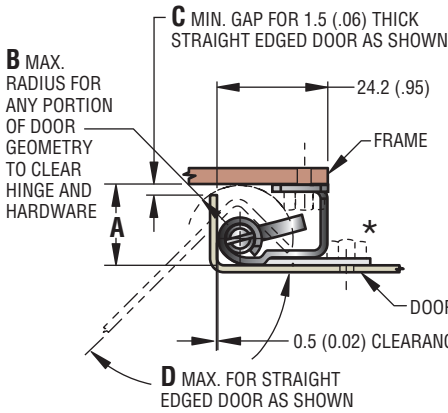


Same hinge can be used for both Type "A" and Type "B" mounting.

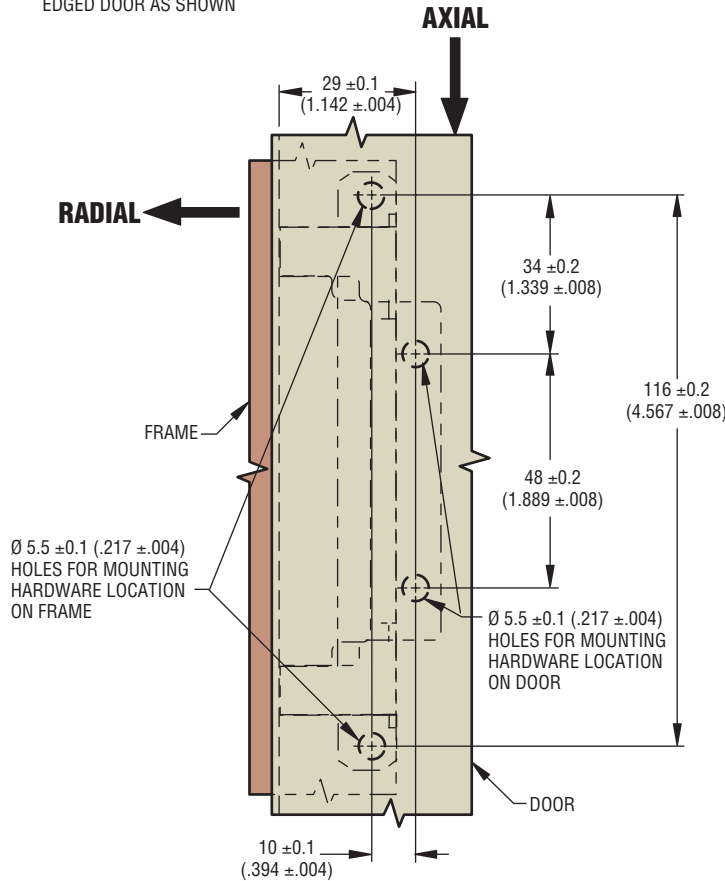
millimeter (inch)
 millimeter
 (inch)

Dimensions without tolerances are for reference only.

Panel Preparation



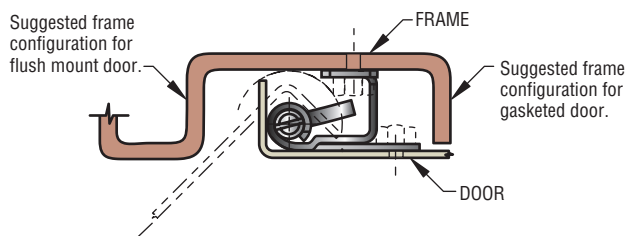
SERIES	PANEL PREPARATION DIMENSIONS			
	A	B	C	D
1	17.1 (.67)	10.9 (.43)	3.2 (.13)	132°
2	20.1 (.79)	12.7 (.50)	3.9 (.15)	125°
3	23.5 (.93)	15.3 (.60)	4.4 (.17)	118°



Hinges may be fastened to door and frame by:

- M5 or No. 10 Hardware. Machine screws are recommended for mounting frame leaf.
- *Hex jam nuts. Verify clearance with door edge. Depending on jam nut orientation, full rotation may be obstructed.
- Welding.

Additional Mounting Options



Installation

There are two methods of installation. One method may be more appropriate for your application;

Type A:

1. Mount the assembled door leaf, frame leaf assembly directly to the inside surface of the door.
2. With appropriate support under the door, position the door against the frame and attach as necessary.
3. Remove the supports which may have been used to support the weight of the door during installation.

Type B:

1. Mount the leaves to the door and frame respectively.
2. With appropriate support under the door, position the door against the frame, align the hinge leaves, and move the release pins out of the detents.
3. Check each door leaf to assure that release pins are fully engaged in the knuckle of the frame leaf.
4. Remove the supports which may have been used to support the weight of the door during installation.

Product Strength Guidelines

(To assist in your product selection; samples are available for your evaluation.)

Steel Version

Maximum axial work load: 500 N (112 lbs.)
 Maximum radial work load: 300 N (65 lbs.)
 Ultimate axial load: 800 N (180 lbs.)
 Ultimate radial load: 340 N (76 lbs.)

Stainless Steel Version

Maximum axial work load: 800 N (180 lbs.)
 Maximum radial work load: 300 N (65 lbs.)
 Ultimate axial load: 1340 N (300 lbs.)
 Ultimate radial load: 440 N (100 lbs.)

millimeter (inch)
 millimeter
 (inch)

Dimensions without tolerances are for reference only.