

NEED STATEMENT FOR DETENTION, PRISON & CUSTODIAL

NEED STATEMENT MAX SECURITY LOCKS: **LOCK-UP. PRISON. CUSTODIAL. JAIL.** **DETENTION. INSTITUTIONAL. WEAPONRY.**

A. Swing Door (Manual)

1	Approved Safety2u; Southern Steel Detention Lockset 1070A Series ASTM Approved Automatic Slam Shut Mechanical Lock size 9" L x 5" H x 1-1/2" TK , weight 11 lbs. stainless steel latch bolt with (2) 1/4", come with SECURITY LATCH deadlock actuator size 3/4" x 1/2" diameter case-hardened steel insert pins, silicon bronze/copper alloy paracentric cylinder with approved ASTM F-1577-96 (mechanical release operation cycle test, cylinder test, mechanical release force test, horizontal impact test, testing on fire doors) Certified Impact Test Grade 1 with single cylinder. Comes with: Approved Safety2u; Southern Steel 4C Bolt Keeper and dust box come with security fasteners screws. Approved Safety2u; Southern Steel Detention Lockset 1070A Mounting and Service Plate come with Mounting Plate. High Security Detention ASTM Approved Mounting Plate size & weight varies with application. Made with 7-gauge steel plate to be attached to door with Lock size 11-7/8" H, 11-7/8" W, 2" TK. Approved Safety2u; Southern Steel 218 Detention Escutcheon size 3" DIA x 105" TK weight 2 lbs., material stainless steel come with security fasteners, used to provide a close fit between a paracentric cylinder and the keyhole. Approved Safety2u; Southern Steel 204FMSS Institutional Hinges, (4 units) each hinge features cast stainless steel leaves with integral security stud and non-removable stainless- steel pin with brass between its leaves. Stainless Steel US32D finished, size 4-1/2" x 4-1/2" x 3/16", weight 0.68kg c/w 1 year warranty or manufacturer defect, ASTM F1758 certified Impact Test Grade 1.
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2	Approved Safety2u; Southern Steel Detention Lockset 1010A Series Mechanical Deadlock size 4.4" L x 3.15" H x 1.35" TK, weight 4.5 lbs., steel lockbolt, silicon bronze/copper alloy cylinder with approved ASTM F-1577-01 (mechanical release operation cycle test, cylinder test, mechanical release force test, horizontal impact test) Certified impact test-grade 1 with double cylinder. Comes with: 1. Approved Safety2u; Southern Steel 470c Bolt Keeper and dust box come with security fasteners screws. 2. Approved Safety2u; Southern Steel Detention Lockset 1010A Mounting and Service Plate come with Mounting Plate. High Security Detention ASTM Approved Mounting Plate size & weight varies with application. Made with 7-gauge steel plate to be attached to door with Lock size 11-7/8" H, 11-7/8" W, 2" TK. 3. Approved Safety2u; Southern Steel 218 Detention Escutcheon size 3" DIA x 105" TK weight 2 lbs., material stainless steel come with security fasteners, used to provide a close fit between a paracentric cylinder and the keyhole. 4. Approved Safety2u; Southern Steel 204FMSS Institutional Hinges, (4 units) each hinge features cast stainless steel leaves with integral security stud and non-removable stainless- steel pin with brass between its leaves. Stainless Steel US32D finished, size 4- 1/2" x 4-1/2"x 3/16", weight 0.68kg c/w 1 year warranty or manufacturer defect, ASTM F1758 certified Impact Test Grade 1.
3	Approved Safety2u; Southern Steel Detention Lockset 1080A Series Mechanical Deadlock size 5-1/2" L x 3-7/8" H x 1-1/2" TK, weight 7 lbs., steel lockbolt, silicon bronze/copper alloy cylinder with approved ASTM F-1577-01 (mechanical release operation cycle test, cylinder test, mechanical release force test, horizontal impact test) Certified impact test-grade 1 with double cylinder. Comes with: 1. Approved Safety2u; Southern Steel 4c Bolt Keeper and dust box come with security fasteners screws. 2. Approved Safety2u; Southern Steel Detention Lockset 1080A Mounting and Service Plate come with Mounting Plate. High Security Detention ASTM Approved Mounting Plate size & weight varies with application. Made with 7-gauge steel plate to be attached to door with Lock size 11-7/8" H, 11-7/8" W, 2" TK. 3. Approved Safety2u; Southern Steel 218 Detention Escutcheon size 3" DIA x 105" TK weight 2 lbs., material stainless steel come with security fasteners, used to provide a close fit between a paracentric cylinder and the keyhole. 4. Approved Safety2u; Southern Steel 204FMSS Institutional Hinges, (4 units) each hinge features cast stainless steel leaves with integral security stud and non-removable stainless- steel pin with brass between its leaves. Stainless Steel US32D finished, size 4- 1/2" x 4-1/2"x 3/16", weight 0.68kg c/w 1 year warranty or manufacturer defect, ASTM F1758 certified Impact Test Grade 1.



B. Sliding Door (Manual)

1	Approved Safety2u; Southern Steel Detention Lockset 1030A Automatic Deadlock size 10" H x 3-1/2" W x 1-1/2" TK, weight 12 lbs. Key activated unlocking. Hook bolt snap locks upon closing. Final 3/8" of door travel pushes plunger pin against door jamb and deadlocks. Comes with: 1. Approved Safety2u; Strike Plate with security fasteners screws. 2. Approved Safety2u; Southern Steel Detention Lockset 1030A Mounting and Service Plate come with Mounting Plate. High Security Detention ASTM Approved Mounting Plate size & weight varies with application. Made with 7-gauge steel plate to be attached to door with Lock size 11-7/8" H, 11-7/8" W, 2" TK. 3. Approved Safety2u; Southern Steel 218 Detention Escutcheon size 3" DIA x 105" TK weight 2 lbs., material stainless steel come with security fasteners, used to provide a close fit between a paracentric cylinder and the keyhole. 4. Approved Safety2u; Southern Steel 1300 Track Set for manually operated sliding doors where mechanical or electric single-point locking is acceptable with adjustable door hanger and roller assembly, removeable cover, door silencers, bottom door guide. Cover box made with 10-gauge steel, rollers 2-3/4" outside diameter with permanently lubricated roller bearings.
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C. Keys, Parts & Accessories

1	Approved Safety2u; Southern Steel Paracentric Key high-quality detention lock type with cylinders and keys cast bronze/copper alloy key size 4-3/4" x 5/32" TK weight 0.09kg, tensile strength 60,000 p.s.i and 20,000 p.s.i yield strength for Rockwell hardness 73 minimum HRM.
2	Approved Safety2u; Southern Steel 204FMSS Institutional Hinges, (4 units) each hinge features cast stainless steel leaves with integral security stud and non-removable stainless- steel pin with brass between its leaves. Stainless Steel US32D finished, size 4- 1/2" x 4-1/2"x 3/16", weight 0.68kg c/w 1 year warranty or manufacturer defect, ASTM F1758 certified Impact Test Grade 1.
3	Approved Safety2u; Southern Steel 4C @ 470C Bolt Keeper and dust box come with security fasteners screws.
4	Approved Safety2u; Southern Steel Detention Lockset 1010A, 1070A, 1080A, 1030A Mounting and Service Plate come with Mounting Plate. High Security Detention ASTM Approved Mounting Plate size & weight varies with application. Made with 7-gauge steel plate to be attached to door with Lock size 11-7/8" H, 11-7/8" W, 2" TK.
5	Approved Safety2u; Southern Steel Detention 10105 Head or Foot Bolt of size of 5-3/8" H x 2- 3/4" W x 1-7/8" TK and 5.5 lbs. weight come with 1" diameter bolt size, 3/4" bolt throw and galvanized standard finish that used for the inactive leaf of pairs of swinging hollow metal, grating or steel plate doors. This also come with 10105R Foot Bolt Floor Receptacle of size 3" H x 1-5/8" DIA x 1-5/8" sq. Base, 2.25 lbs. and 10105K Key.
6	Approved Safety2u; Southern Steel 218 Detention Escutcheon size 3" DIA x 105" TK weight 2 lbs., material stainless steel come with security fasteners, used to provide a close fit between a paracentric cylinder and the keyhole.
7	Approved Safety2U Security Screws Flat Head Torx Tamperproof SS Undercut. FH 1/4-20 x 1/2 SS UNC.
8	Approved Safety2u Maintenance: a. Rust Remover. b. Anti-Rust Coating. Contains: Xylene 30 – 60%, Toluene 10 - <30%, Ethoxy Propanol 10 – <30%, Methanol <20%.



METHOD STATEMENT FOR DETENTION SECURITY GRILLE



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METHOD STATEMENT

MONOLITHIC INSTALLATION METHOD

(FOR NEW BUILDING PROJECTS)

Safety2u HIGH SECURITY DOOR

MECHANICAL (MANUALLY OPENING)

SWING, SINGLE LEAF

MILD STEEL GRILLE DOOR AND FRAME

LOCATION: PRISON CELL

This document outlines a comprehensive hybrid *need cum method statement* for off-site precision fabrication and on-site monolithic installation of a **Safety2u High Security Prison Grille Door and Frame** complete with all vital components to ensure its practical operability and long-term integrity inclusive of information on requirements for material specifications and relevant certification; contractor registration and installer/welder prerequisite qualifications. The ultimate purpose is to ensure the installed high security designated door meets the highest security standards in compliance with prison security regulations implemented and complemented by a quality installation process adhering to project requirements and safety standards.

A. NEED STATEMENT

1 Approved Safety2u; Grille Door Leaf Specification (Off-site fabrication)

1.1 Approved Safety2u; Grille Door Leaf major parts comprising:

1.1.1 Approved Safety2u; Outer frame mild steel flat bar

Size **50mm (W) x 12mm (Thick)** providing the overall rectangular shape, rigid outer frame support and perimeter welding termination for vertical infill core structure (20mm diameter mild steel round bars) and intermediate horizontal bracings (50mm x 12mm mild steel flat bars) for *long term grille door stability and performance*.

The nett height of the grill door leaf is such that upon installation, a 10mm gap exists with the underside of door head Rectangular Hollow Section and a 15mm gap is effectively created between the Finish Floor Level FFL) with the underside of the outer frame's mild steel flat bar.



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The nett width of the grill door leaf must allow for the practical precision operation gap tolerance for the hinges and lockset's barrel bolt, security latch, strike plate and bolt keeper harmonised combined working mechanism.

The positions and size of 4 nos. hinges (Safety2u; Southern Steel 204FMSS Institutional Hinges) as indicated in item 3.2 below, must fit perfectly with the rebate (cut-out) positions and size formed within the outer frame flat bar thickness to enable flush mounting of the hinges during site installation.

1.1.2 Approved Safety2u; Vertical mild steel solid round bars

Size **20mm diameter** spaced at **100mm** centre to centre providing the infill core structure of the door grille, running *vertically* between the intermediate *horizontal* bracing flat bars through 20 -21mm diameter punched holes ensuring secured intersecting vertical and horizontal bars, permanently locked into position and all welded together.

Additionally, intermediate vertical mild steel solid bars of 20mm diameter similarly running through 20-21mm diameter punched holes, are provided in between the main vertical bars (spaced at 100mm apart) around a dedicated area of the security lock mounting box position, terminating at the intermediate horizontal bracing flat bars above and below for an **enhanced security area of approximately 700mm horizontally and 1100mm vertically**, displaying a closely spaced vertical mild steel solid bar of 20mm diameter at 50mm c/c ensuring an out of reach key hole beyond detainee's reachable arm's length.

1.1.3 Approved Safety2u; Horizontal intermediate mild steel flat bars

Size **50mm (W) x 12mm (Thick)** at top, middle (flanking security lockset mounting box) and bottom sections provide a balanced distribution of horizontal bracings across the grille door height for added strength and to keep the vertical round bars in place via the punched holes. The opening side-centrally positioned security lockset mounting box (size 300 x 300mm) is flanked by horizontal bracing mild steel flat bars, all welded together for robust performance during slam shut operations for long term functional integrity.

1.2 Approved Safety2u; Grille Door Leaf Nominal Size: 2010mm(H) x 750mm(W) with a 15mm gap with Finish Floor Level (FFL)

2 Approved Safety2u; Door Frame Specification (Off-site fabrication):

2.1 Approved Safety2u; Door frame

Overall size 2100mm(H) x 900mm(W) constructed of mild steel Rectangular Hollow Section (RHS) size **100mm x 75mm x 3mm** thick complete



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with integrated **Stopper** comprising Square Hollow Section (SHS) size **19mm x 19mm x 1.6mm** thick all welded together with the Rectangular Hollow Section door frame on three sides.

2.2 Approved Safety2u; Strut Bar

Fabricated from **20mm** diameter mild steel round bar horizontally positioned and factory-welded to the bottom part of door frame posts as additional strengthening for sustained dimensional rigidity control to prevent twisting/deformation of door frame during delivery (off-site loading and on-site unloading); to maintain overall clear opening consistency after installation and in anticipation of possible destructive impacts during concreting

2.3 Approved Safety2u; Anchor Bars

L-shape design to function as permanent anchorage of Door Frame to RC wall. Fabricated from 20mm diameter x 300mm long mild steel round bar bent into an L-shape with 200mm long side x 75mm short side (bent). Not factory welded, subject to on-site welding (refer to monolithic installation section item 7.2 below on work sequencing).

3. Approved Safety2u Components (Operational function).

3.1 Approved Safety2u; Southern Steel 204FMSS Institutional Hinge (on-site installation)

3.1.1 Approved Safety2u; Heavy-duty stainless-steel hinges with integral security stud and non-removable stainless-steel pin.

Size 114.3mm x 114.3mm x 4.76mm

Quantity required per grille door: 4 nos.

3.1.2 Approved Safety2u; Recommended positioning of hinges to support heavy duty door deadload during closed position and dynamic loading during slam-shut operation:

1. Distance from the top of the door leaf to hinge 1 is **200mm**.
2. Distance between hinge 1 and hinge 2 is **200mm**.
3. Hinge 4 is **200mm** from the bottom of the door leaf outer frame (flat bar)
4. Hinge 3 is positioned between hinges 2 and 4.

3.2 Approved Safety2u; Mounting Box (on-site installation)

3.2.1 Approved Safety2u; The square mounting box size **300mm x 300mm x 50mm is constructed from one piece of galvanised mild steel plate with double-bent edges to form a tough enclosure complete with screw-on plate cover and welded to the adjacent mild steel flat bars for a secure precision fitting to withstand repeated slam-shut door operation.**



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3.2.2 This placement strategy aims to secure the key access point, preventing detainees from reaching or tampering with the keyhole. It enhances security by ensuring that the key and its mechanism are protected within a robust enclosure, thereby minimizing the risk of unauthorized access or manipulation. This approach helps maintain control over access to sensitive areas and enhances overall security measures within the facility.

3.3 Approved Safety2u; Southern Folger Lockset (on-site installation)

3.3.1 Approved Safety2u; Southern Steel High Security Detention Lockset 1070A
ASTM Approved Automatic Slam Shut Mechanical Lock constructed from stainless steel with a silicon bronze paracentric cylinder comprising the following dimensions:

1. Lock Size: Length 228.6mm (L) x 127mm (H) x 38.1mm (T).
2. Weight: 4.99 kg.
3. Stainless Steel Latch Bolt: 6.35mm
4. Security Latch Deadlock Actuator: 19.05mm (L) x 12.7mm (Diameter) case-hardened steel insert pins.

3.3.2 Approved Safety2u; Southern Steel 4c @ 470 Bolt Keeper and Dust Box
complete with security fastener screws.

3.3.3 Approved Safety2u; Southern Steel 218 Detention Escutcheon (ASTM Approved):

1. Escutcheon Diameter: 76.2mm
2. Thickness: 2.67mm
3. Weight: 0.907 kg

3.4 Approved Safety2u; Utilities Hole (off-site fabrication)

The clear opening dimensions are **250mm** horizontally x **90mm** vertically, positioned at the same level as mounting box, adjacent to the hinged side of the door assembly. This hole is formed by using 50mm (Wide) x 12mm (Thick) to match the existing vertical and horizontal bracing flat bars that it is welded to.

4. Approved Safety2u; Material Specification and Compliance Requirements

4.1 Requirement for MS-certified steel or equivalent BS/EN/ASTM complete with manufacturers mill test certificates (MTC) in compliance with JKR (approved supplier), CIDB (Product Certification) and SIRIM or other Department of Standards Malaysia's (DSM) accredited testing bodies as material approval benchmark. Other relevant authorities (e.g., PDRM, MINDEF etc.) may impose additional security compliance (if applicable) such as impact resistance or forced-entry tests.



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4.1.1 Approved Safety2u; Grille Door Leaf Outer Frame and Bracing Flat Bars (50mm x 12mm MS Flat Bar) standard reference MS 1195: Hot-rolled steel sections or equivalent BS EN10025 -2: structural steel grades (S275JR) with minimum yield strength of ≥ 275 MPa and tensile strength of 410-560MPa.

4.1.2 Approved Safety2u; Vertical Solid Bars (20mm Diameter MS Round Bar) standard reference MS146: Hot-rolled steel bars for general structural use or equivalent BS EN 10025- 2 or ASTM A36 with minimum yield strength of ≥ 275 MPa or ≥ 250 MPa respectively and tensile strength of 400-560 MPa.

4.1.3 Third-Party Testing & QAQC

Tensile test and chemical composition analysis (as per MS 146/BS EN 10025).

5.0 Approved Safety2u; Painting Specification for Grille Door Leaf and Frame:

1. To be in accordance with JKR Standard Specifications for Building Works.
2. All paints to be used shall be those supplied by approved manufacturers.
3. The quality of paints shall comply to MS 125 in respect of oil/enamel paints.
4. The steel surfaces to be painted shall be dry, free from dirt, oil grease and other deleterious matter. Ensuring that surfaces are free from these impurities is essential for achieving a durable and high-quality paint finish. This preparation ensures that the paint adheres properly and that the finished surface is uniform and free from defects.
5. All priming to shop fabricated components shall be done at shop.

Approved Safety2u First coat: One (1) coat of approved metallic primer (applied at factory before delivery to site – to be under mild steel grille door contractor's scope of work).

Approved Safety2u Undercoats and finish coat: One (1) coat of premium alkyd undercoat unless specified and shall be finished with two (2) finishing coats of gloss/semi-gloss fungus resisting alkyd paint. (Note: to be under Main Contractor's scope of work).

6. Approved Safety2u; Construction Sequence for High Security Grille Door with Monolithic Installation in RC Walls.

This construction sequence ensures the proper integration of the security grille door with the reinforced concrete (RC) wall using a monolithic approach.

6.1 Approved Safety2u; Pre-Installation Preparation, site assessment, delivery and unloading.

6.1.1 Approved Safety2u; Liaison with main contractor on important dimension information and clarification for shop drawing preparation. Submission of shop drawings and approval.



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- 6.1.2 Approved Safety2u; Off-site fabrication of grille door based on approved shop drawings; application of metallic primer (anti-rust) to door frame and grille door.
- 6.1.3 Approved Safety2u; Pre-delivery site visit – assessment of delivery logistics and materials unloading location in relation to installation location preferably within hoisting radius of mobile or tower crane.
- 6.1.4 Approved Safety2u; Delivery to site based on agreed delivery schedule (Work Program) with main contractor for monolithic integration with identified concreting works to floor slab and kerb/upstand beam. Unloading of materials at a suitable location with main contractor's permission preferably to avoid double handling during hoisting for installation.
- 6.1.5 Approved Safety2u; Before concreting the structural floor slab, the main contractor must identify and verify preferably with their surveyor's grid line related markings indicating the locations of security grille doors and panels in relation to the relevant kerbs/upstand beams (location and size as per drawing) with exposed reinforcement bars and links above the structural floor level (SFL) after concreting.
- 6.1.6 Approved Safety2u; In a situation where floor concreting works has to proceed prior to installation of door frames, the area around the base of the door frames should be left unconcreted to facilitate post-concreting door frame installation where 50mm embedment of the door frame posts.
- 6.1.7 Approved Safety2u; Concreting to floor slab by main contractor to correct structural floor level (SFL for FFL screed finish and FFL for floor hardener finish ranging from **2mm to 5mm** thick on RC floor). Part of floor under door frame width is not concreted to accommodate **50mm** deep termination of RHS door frame base welded to floor rebar. After installation of security grille panel, the main contractor can complete the concreting of the floor area patch at the door frame base that was intentionally left out during concreting to facilitate welding of door frame base to the exposed floor rebar.
- 6.1.8 Approved Safety2u; Where a floor hardener is specified as the floor finish to the RC floor surface, the **strut bar** is situated **50mm** below the Finish Floor Level (FFL) and **65mm** from the underside of the flat bar outer frame of the grille door leaf which has a gap of **15mm** with the Finish Floor Level (FFL).

Where a **50mm** thick screed is specified as the floor finish to the RC floor surface, the strut bar is **100mm** below the Finish Floor Level (FFL) and **115mm** from the bottom of the flat bar outer frame of the grille door leaf which has a gap of **15mm** with the Finish Floor Level (FFL).



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B. METHOD STATEMENT

6.2 Approved Safety2u; Door Frame Installation (monolithic – before concrete pouring).

6.2.1 Approved Safety2u; Positioning of MS RHS Door Frame:

Securely hoist the MS RHS door frame into position along the designated gridline within the allocated space between the kerb/upstand beams and wall reinforcement. Maintain proper alignment, verticality and planarity using temporary bracing supports. Ensure a minimum concrete cover of 25mm around the steel frame to prevent corrosion.

6.2.2 Approved Safety2u; Anchor Bars spot welding for permanent anchorage:

Spot weld one end of the anchor bars to the MS RHS door frame and the other ends to the wall rebars. Space the anchor bars at 400 – 600mm intervals to the MS RHS door jambs and door head.

6.2.3 Approved Safety2u; Emir Bina Sdn Bhd to perform a final inspection for all spot welding of security grille door RHS frame sides and top anchor bars to upstand beam reinforcement, column or sides and top wall reinforcement respectively to achieve the desired overall stability before formwork installation.

6.2.4 Approved Safety2u; The surrounding structural component formwork must be precisely (as possible) erected around the security grille door frame to ensure minimal leaking of cementitious slurry during concreting which will affect the security door frame cleanliness. Any visible concrete slurry spillage on the door frame surface should be cleaned immediately.

6.2.5 Approved Safety2u; Grille Door Leaf handling – **do not install the security grille door at this stage. It should be installed after concrete curing post RC wall formwork removal.**

6.2.6 Approved Safety2u; After formwork removal, the alignment of all door grille RHS frame and grille panel positions shall be subjected to a final joint inspection with the main contractor.

6.3 Approved Safety2u; Security Grille Door Leaf Installation after concrete curing.

6.3.1 Approved Safety2u; Fixing **204FMSS Institutional Security Hinges after the RC wall reaches sufficient strength. Align the hinges properly and secure both hinge leaves with security screws for door leaf to be fully supported into position and operable (swing smoothly for closing and opening).**



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- 6.3.2** Approved Safety2u; Installation of **Mounting Box** (welded to MS flat bars at designated 300mm x 300mm opening of security grille door).
- 6.3.3** **Approved Safety2u; Southern Steel High Security Detention Lockset 1070A** installation into Mounting Box including installing the Plate Cover with security screws. Ensure It functions correctly.
- 6.3.4** **Approved Safety2u; 4C Bolt Keeper and Dust Box** installation – position and weld flush with the MS RHS door frame with all the necessary refined adjustments and gap tolerance to ensure effective slam-shut operation of security grill door leaf.
- 6.3.5** **Approved Safety2u; 218 Escutcheon** installation only after the Lockset, Bolt Keeper and Dust Box are in full working harmony enabling precise slam-shut door operation. This sequence allows for precise alignment and ensures that the Escutcheon covers any gaps or exposed areas around the Lockset. Align the Escutcheon with the Lockset keyhole position and secure the Escutcheon using appropriate security fasteners to ensure firm attachment.
- 6.3.6** **Approved Safety2u; Carry** out final inspection to ensure that all components are securely fastened and that the High Security Grille Door functions smoothly with precise operation of mechanical locking and unlocking mechanism.
- 6.3.7** **Approved Safety2u;** The completed security grille installation with the correct door swing should be fully complemented with the necessary documents namely door schedule, locks schedule, key zone schedule, original certified ASTM Test certifications and Direct Factory Warranty.

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