

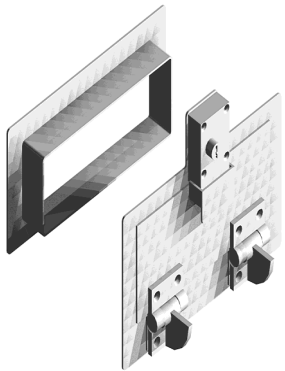
## The Western Detention Food pass Assembly

*This food pass assembly, exclusively by Western Detention, is a great option for adding the security and safety of a Food Pass / Cuff Port assembly to your existing door.*

*This package design is available for all Southern Steel and Folger Adam locks. Let us know what door thickness you have (2" or 1 3/4"), what brand lock you use and even the key code you would like us to match and we can custom tailor the ready-to-install assembly to your needs.*

*Call us today for a written quote*

**888-745-0530**

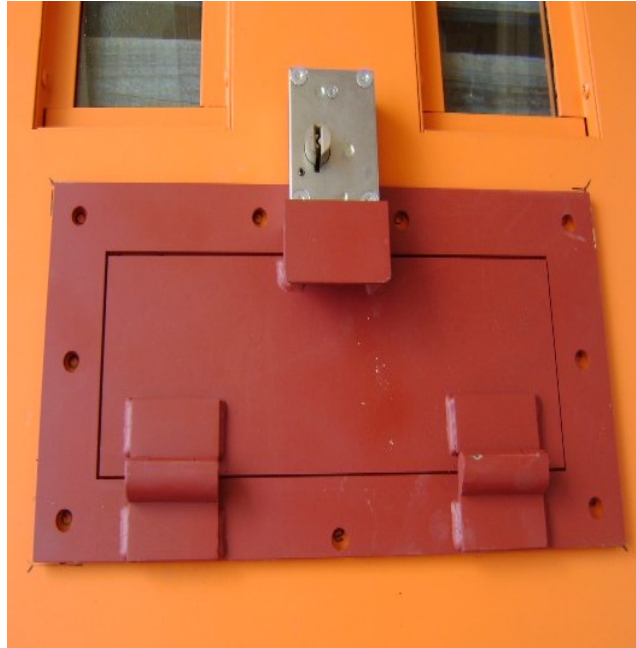


**The two piece design for easy installation**



# **WESTERN DETENTION**

Hardware products on demand.



Western Detention  
3711 E Deer Park-Milan Road  
Deer Park WA 99006

Phone: 888-745-0530

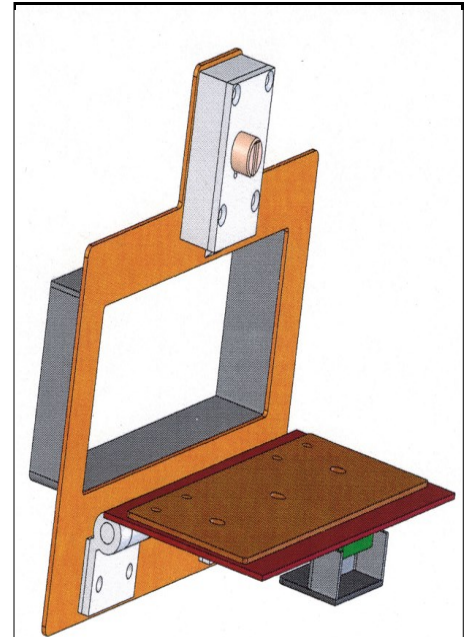
Fax: 509-292-2449

E-mail: [sales@westerndetention.com](mailto:sales@westerndetention.com)



# **WESTERN DETENTION**

Hardware products on demand.



**The Western Detention food pass assembly is the most cost effective way to provide security and convenience of a Food Pass / Cuff Port, without the high cost of replacing your door. For over 14 years, this assembly has been the preferred method for retrofitting into an existing door.**

**Food Pass Retro Install  
Assembly**

## Food Pass Installation 1 3/4" or 2" hollow metal door

The first step to installing the food pass in any door is removing and relocating the door to a safe work area. Start by laying the door flat on a set of wooden blocks. Any glass or hardware installed on the door that may be damaged during this installation process must be removed or properly protected.



Above shows a traced outline of a food pass assembly.

The second step to this installation is centering the food pass in the door. Start by laying the food door assembly at your desired height and check for clearances with glass and other hardware. When satisfied, simply trace your outline with a permanent pen.

The center hole will need to be cut larger than your outline. By adding a 1/2" to your outline, the hole should be 7" x 17 1/4".



Start your third step in this process by drilling the corners of your cut with a 1/4" drill bit. Proceed by making your cuts. I use a worm drive Skill Saw with a 7"x1/8" x DM-16mm Norton metal cut off blade part 89097. The door may need to be flipped and cut on the other side. Use your 1/4" holes as a guide.

## Welding the Assembly

Start your fourth step by preparing the door for welding by removing all paint in the weld areas. The assembly has pre-drilled holes designed for plug welding.



After the prep work is completed, align and tack weld one side of the assembly to the door. Flip the door and start on the other half of the assembly.



Be sure to securely clamp the two halves together as you continue to tack weld the assembly to the door.



The inside trim ring should line up correctly with the front door assembly. You can weld these two together if you plan to go back and grind the weld flush.



Once the assembly is tack welded and tested, continue by fully welding in the holes. After the assembly cools go back and grind the welds flush.



A little automotive spot putty will fill any divots you may have.



Finish the assembly by sanding any sharp or rough edges. Tape the door off and paint.

