



**WILLO PRODUCTS
COMPANY** SINCE 1945

Detention Locking Systems & Controls

7/13/2023

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Reference: Proposal for Wedge realignment and continuous hinge

Maria,

I conducted a site visit on 6-26-2023 at the Charles B. Webster Detention Facility. Upon arrival, I met with you and Major Mitchell from the facility.

We spoke about the issues that were being experienced at the Charles B. Webster Detention Center. Major Mitchell informed me that the facility is addressing the *need to keep the cell doors closed.*

By securing the doors the inmates **will not be able to remove the glazing tape from the window lite and place it within the detention lock.**

By securing the doors the inmates **will not be able to "Rack" the hollow metal doors. "Racking" is when an inmate places an object in the frame opening and slams the door. If this activity is performed repeatedly it will lead to hinge failure. The failure could be the destruction of the hinge or the hinge pads located within the frame or door.**

The one conducting our tour took us to Pod F, block B. At block B we were shown cells 1-12. All cells experienced the same issue; the doors were racked. The hinges were either bent or the hinge pads within the frame were broken. Due to the racking, of all the cell doors, the doors cannot be secured. Please see the attached pictures showing the hinge area destruction and the misalignment of the locking system.

Willo Products can remove the broken and bent hinges, and install a continuous hinge on the officer side of the cell opening. We will attach filler plates in old hinge locations and weld a continuous hinge on the face of the door and frame areas. With the addition of the continuous hinge, the hinges will no longer be able to be racked.



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The Racking of the Hinges caused other issues that must be addressed:

1. Due to the doors being left open, inmates abused the security hardware. Debris is lodged in the locking system. This debris will need to be removed from the locks. The removal of the debris will restore the functionality of the locking system.
2. The strike of the Wedge is welded to the door. The lock housing receiver of the Wedge (where the lock is located) is welded to the frame. The doors and frames are out of alignment due to the racking. When we install the continuous hinge we will have to align the door and frame. We may be able to do this with the use of blocks and spacers placed under and around the door to regain the proper plane. We will also reattach the alignment plates before welding to the frame (Please see attached pictures)
 - a. If the alignment cannot be accomplished by the above method we will have to remove and replace the back plate of the strike side of the Wedge.
 - i. This is accomplished through the following steps:
 1. Disassembling the wedge
 2. Grind off the welds that secure the back plate to the hollow metal door.
 3. Weld up and clean up the hollow metal door
 4. Attach Wedge alignment brackets
 5. Reweld the back plate to the hollow metal door
 6. Reassemble the strike side Wedge
3. We Propose that our technicians come and attempt to align the door using the method identified with number two above. While present he will remove debris from the lock and the door will be secure. *The packing of the lock will persist unless the doors are left in the closed position. In the closed position, the inmate cannot rack the door or pack the lock.*
4. If the mock-up is not successful then we will have to upcharge the facility by implementing (2) (A) (i) and the steps that follow itemized above.



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Maria,

We Propose the Following Scope of Work for the Continuous hinge replacement in Pods C, F, and G.

Overview:

In Pods F and G, we will remove and set aside for reuse the shroud cover plate. We will weld the continuous hinge to the door. After the hinge is attached we will add blocks and spacers to align the door and frame. After proper alignment is achieved we will weld the continuous hinge to the frame side. After welding is complete we will remove the alignment plates and reattach the shroud cover plate.

In Pod C we will remove security hinges and add a continuous hinge before we install the Wedge locking system.

Scope of Work

We Propose to Demolish the Following Materials in Pods C, F, and G:

- 642 (each) detention hinges
- Demolished hinges will be disposed of in the facilities dumpster

We Propose to Remove and Reuse the Following Materials:

- 146 (each) The shroud on the Wedge locking system will be removed and reinstalled after proper alignment is achieved. This activity will take place in Pods F and G.

We Propose to Furnish and Install the Following Materials:

- 214 (Each) Continuous Hinge for cell doors in F, G, and C pods

The Following are Clarifications to our Scope of Work:

- Work area is to be clear of inmates when our installation efforts are taking place.



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We Exclude the Following From our Scope of Work:

- Detention hollow metal doors and frames
- Repair to the hollow metal door at the hinge location if inmates have compromised the integrity of the door due to abuse.
 - If outside sheeting is in need of repair before the continuous hinge is attached we will document the opening, and itemize the material and labor necessary for the repair. These repairs will have to be approved before we attach the continuous hinge to the existing door.
- Repair or replacement of parts for the Wedge locking system in Pods F and G.
- Detention glass or glazing
- Finish paint or painting
- Smoke or fume remediation
- Replacement of the backplate on the strike side of the Wedge. If replacement is required a change order will be required to cover the additional material and labor cost.
- Tax
- Prevailing wage or union workers
- Paint or painting of hollow metal doors, frames
- Touch-up to paint
- Caulk or calking
- Furnish temporary electric power, water, toilet facilities, and lighting for our installation efforts.

Pricing and Terms:

To perform the Scope of Work as outlined above we quote **\$309,028.00**, no tax included.

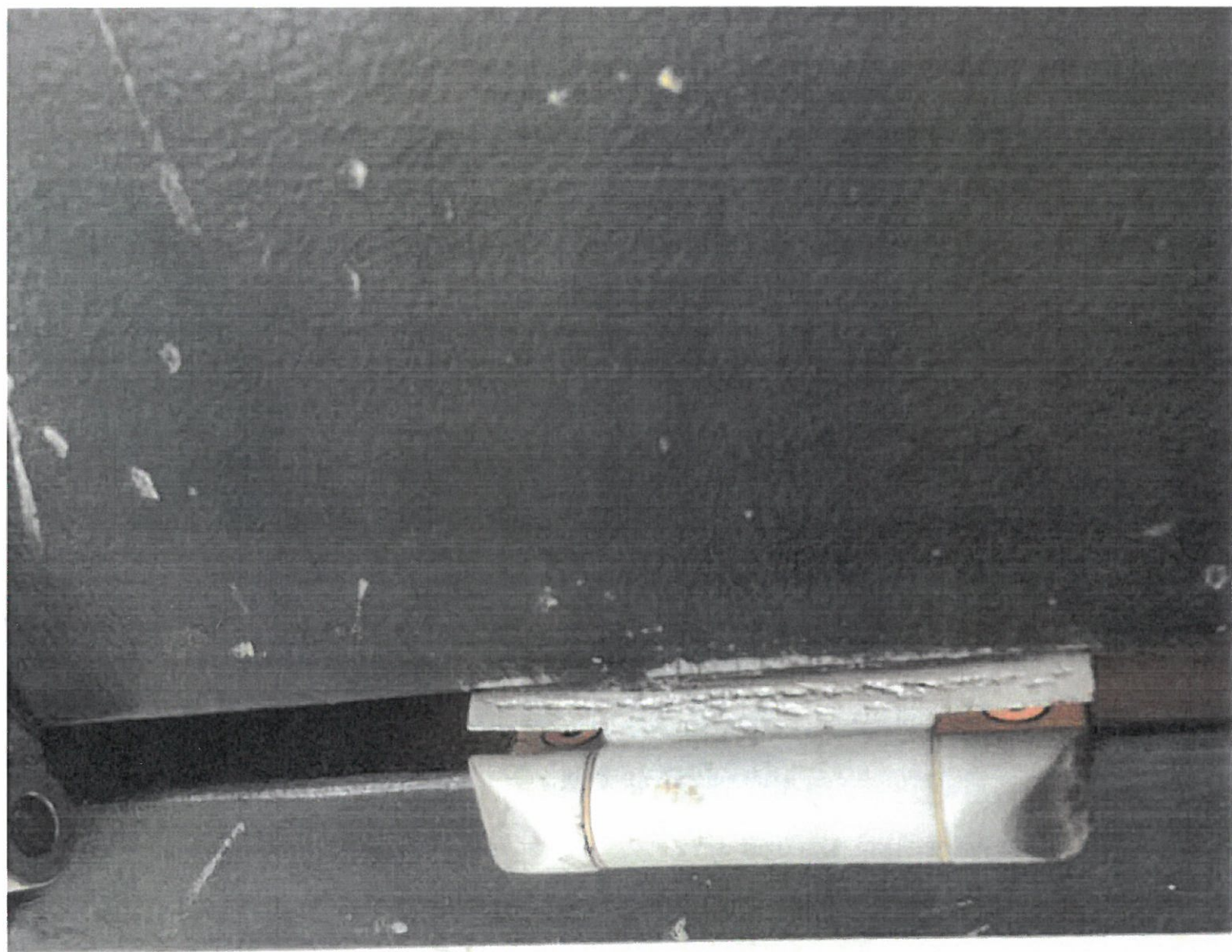
If approved we would like to schedule a mock-up to confirm we can align the door and frame without the removal of the Strike Backplate in pods F and G.

Pricing is valid for 30 days. We quote net 30 days no retainage allowed.

If Willo Products receives a Change order or Purchase Order for the above scope of work before the 2nd week of July then materials and our installation crews will be on-site in late September to begin our installation efforts. If you have any questions please feel free to call.

Sincerely,

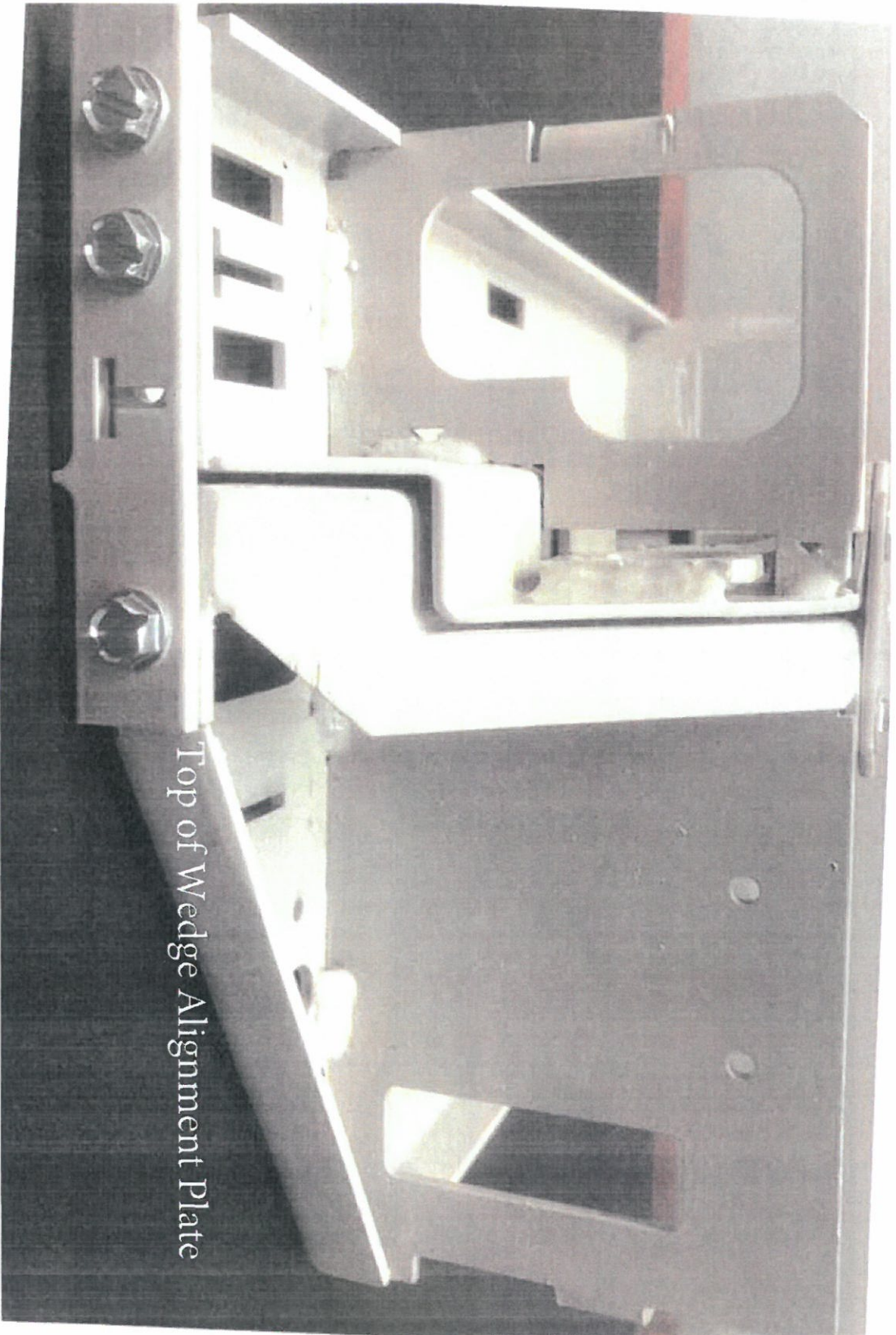
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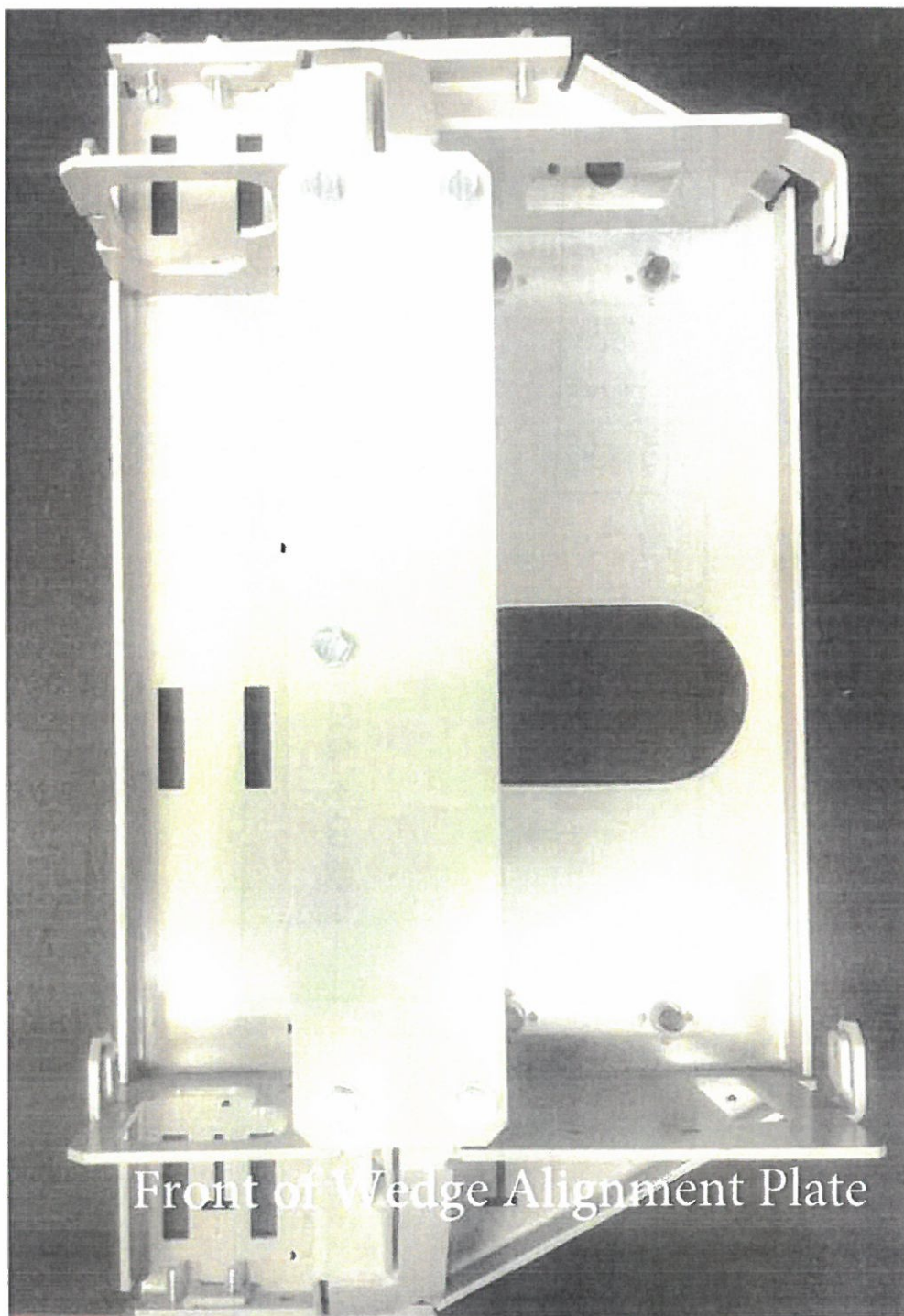




Bottom of Wedge Alignment Plate



Top of Wedge Alignment Plate



Front of Wedge Alignment Plate

A
SIZE

PROJECTIONS

TOLERANCES UNLESS OTHERWISE SPECIFIED:		
PLACES	INCH	NOTE
.XX	± .030	ACCEPTABLE BURR ± 10% OF MATERIAL THICKNESS
.XXX	± .015	ALL TOLERANCES ARE NON-CUMULATIVE
.XXX	± .005	ALL DIMENSIONS APPLY TO PART BEFORE ANY FINISH IS APPLIED
.XXX	± .005	
ANGLE	3°	

