ALL METAL STAMPING, INC.
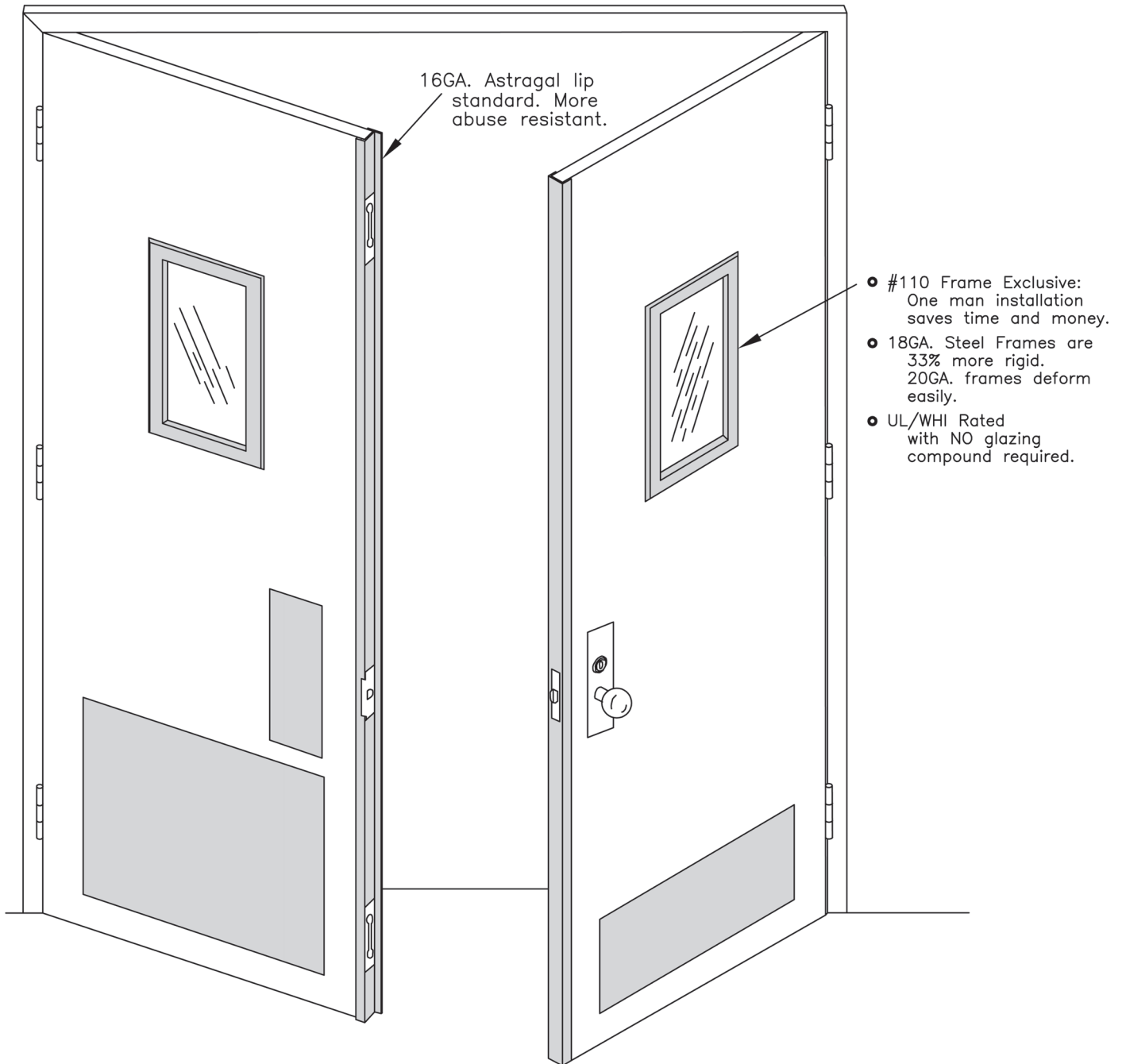
411 W. Spruce St.
P.O. Box 485

Abbotsford, WI 54405-0485

Phone (715) 223-6324
FAX (715) 223-3352
www.AllMetalStamping.com

FIRE DOOR HARDWARE

Listed by **c(UL)us LISTED** and **Warnock Hersey c H us**

16GA. Astragal lip standard. More abuse resistant.

- #110 Frame Exclusive: One man installation saves time and money.
- 18GA. Steel Frames are 33% more rigid. 20GA. frames deform easily.
- UL/WHI Rated with NO glazing compound required.

• Door Light Frames •
• Metal Door Edges & Astragals (machined to your specifications) •
All Available in Steel or Stainless Steel

TABLE OF CONTENTS

This catalog can be downloaded from our website at www.AllMetalStamping.com. The Pricing Pages 14, 15, 16, 21, 24, 25, 27, and 29 can be obtained by email, fax, or mail by contacting us at 715-223-6324. We will send these pages to you as soon as possible.

Door Light Frames

Edge & Astragal Sets and 5" Channels

Standard & "Quick Ship" Services

Veneer Wrapped Products

Lead-time for standard product is 7-10 business days.
Actual ship date will depend on our production schedule.
Please refer to "Quick Ship" Services and Stock Size List for further details. Pages 28-29.

Other Items Available: **[Call for information and Quote]**
Kick/Armor Plates (Stainless Steel).
Dutch Door Shelves (CRS or Stainless Steel).
Aluminum Door Flashings.

ALL METAL STAMPING, INC.
411 W. Spruce Street
P.O. Box 485
Abbotsford, WI. 54405-0485

Phone: 715-223-6324   **www.AllMetalStamping.com**   **FAX: 715-223-3352**

MODEL 110 LOW PROFILE FIRE DOOR LIGHT FRAME

FOR STANDARD 1¾" DOOR AND ¼" GLASS AND SOME OTHER APPLICATIONS

ORDER INFORMATION:

ORDER SIZE = Inside dimension of frame, (W+H)
CUTOUT SIZE = Order size + $1\frac{1}{2}$"
GLASS SIZE = Order size + $\frac{3}{4}$"

MATERIAL:

18 GA. CRS frame is standard.
- 33% thicker than 20 GA. frames
- Maintains flat appearance

FINISH:

Beige polyester powder coating.
- Extremely durable
- Visually appealing

OPTIONS:

- 18 GA. Galvanized for exterior use.
- 18 GA. Stainless Steel for hospital and food service.
- Custom colors.
- Wood veneer wrapped in various species to match door.

PRODUCT RANGE:

- Low Profile feature available for 1" to $2\frac{3}{4}$" thick doors.
- Maximum Glass pocket with Low Profile feature is $\frac{5}{8}$" less than Door Thickness.

NARROW FACE FRAME

- Better proportioned
- Visually appealing
- Suitable for wood, metal or mineral core doors.
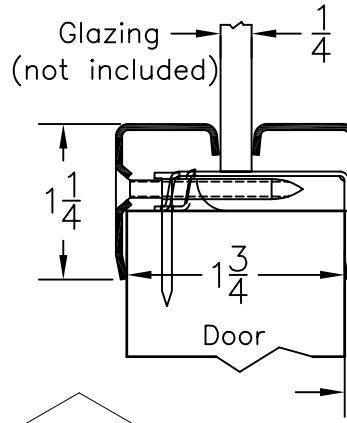
MOUNTING HOLES:

- 11" length or less, one hole centered.
- Over 11", three inches, maximum from corners. $11\frac{5}{16}$" maximum centers.

Glazing (not included)
$\frac{1}{4}$
$1\frac{1}{4}$
$1\frac{3}{4}$
Door
$\frac{5}{64}$

NO GLAZING COMPOUND, TAPE or INTUMESCENT is required for most label applications.
- Reduces cost
- Simplifies installation
- Improves appearance

LOW PROFILE
- Provides less interference for exit hardware.

Installation nails. (included)

WELDED STIFFENER
- Reduces corner flex.

"Exclusive"

NAIL-IN FASTENING METHOD

- Requires only one person to install.
- Significantly reduces installation time.
- Corridor side is fastener free, secure and attractive.

Glass NOT included.

#8 X $1\frac{1}{2}$" Phillips Sheet Metal Screw (included)

NO SHARP CORNERS
5/32 Radius

Laminated Glass NOT recommended See Glass Note.
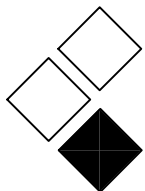
GLASS NOTE: For non-fire rated applications we recommend $\frac{1}{4}$" tempered glass. If laminated glass is used, glazing tape and light torque on the screws is required to prevent glass breakage.

◇ ALL METAL STAMPING, INC.

411 W. Spruce St., P.O. Box 485, Abbotsford, Wisconsin 54405-0485
Phone (715) 223-6324   www.allmetalstamping.com   Fax (715) 223-3352

Patent Pending

MODEL 110B LOW PROFILE FIRE DOOR LIGHT FRAME
FOR NON-STANDARD APPLICATIONS

ORDER INFORMATION:
ORDER SIZE = Inside dimension of frame, (WxH)
CUTOUT SIZE = Order size + $1\frac{1}{2}$"
GLASS SIZE = Order size + $\frac{3}{4}$"

MATERIAL:
18GA. CRS frame is standard.
- 33% thicker than 20 GA. Frames.
- Maintains flat appearance.

FINISH:
Beige polyester powder coating.
- Extremely durable
- Visually appealing

NARROW FACE FRAME:
- Better proportioned
- Visually appealing
- Suitable for wood, metal or mineral core doors.

OPTIONS:
- 18 GA. Galvanized for exterior use.
- 18 GA. Stainless Steel for hospital and food service.
- Custom colors.
- Wood veneer wrapped in various species to match door.
- Available for a variety of glass and door thicknesses.
- NOTE... Maximum glass pocket is $\frac{5}{8}$" less than door thickness.

MOUNTING HOLES:
- 11" length or less, one hole centered.
- Over 11", three inches, maximum from corners. $11\frac{5}{16}$" maximum centers.

Glass (not included) $\frac{1}{4}$

$1\frac{1}{4}$

$1\frac{3}{4}$

Door

$\frac{5}{64}$

NO GLAZING COMPOUND, TAPE or INTUMESCENT is required for most label applications.
- Reduces cost
- Simplifies installation
- Improves appearance

LOW PROFILE
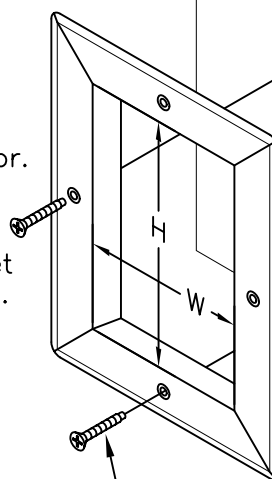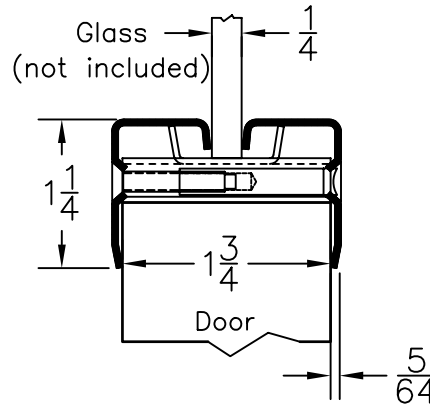- Provides less interference for exit hardware.

NO SHARP CORNERS
- 5/32 Radius

Vandal proof binder post (included).

Glass (not included)

W+3/4"

H

W

H+3/4"

#8-32 Phillips Head Machine Screw (included)

FRAME AND GLASS SUPPORTS (included)
Must be used for proper installation. Two required.

GLASS NOTE: For non-fire rated applications we recommend 1/4" Tempered Glass. If Laminated Glass is used, glazing tape and light torque on the screws is required to prevent glass breakage.

LAMINATED GLASS NOT RECOMMENDED SEE GLASS NOTE.

ALL METAL STAMPING, INC.
411 W. Spruce St., P.O. Box 485, Abbotsford, Wisconsin 54405-0485
Phone (715) 223-6324 www.allmetalstamping.com Fax (715) 223-3352

Patent Pending

MODEL 115 FIRE DOOR LIGHT FRAME

OUR PREVIOUS STANDARD UNIT

ORDER INFORMATION:

ORDER SIZE = Inside dimension of frame, (W+H)
CUTOUT SIZE = Order size + $1\frac{1}{2}$ "
GLASS SIZE = Order size + $\frac{3}{4}$ "

UL & WHI LISTED

Meets UL10B requirements for NEGATIVE PRESSURE and UL10C & UBC 7-2(1997) for POSITIVE PRESSURE. Refer to AMS Listing Specifications. Fire tested WITHOUT glazing compound, tape or intumescent.

MATERIAL:

18 GA. CRS frame is standard.
• 33% thicker than 20 GA. Frames

FINISH:

Beige polyester powder coating.
• Extremely durable
• Visually appealing

$\frac{1}{4}$

$\frac{3}{4}$

$1\frac{1}{2}$

$\frac{3}{16}$

1-3/4" & 1-3/8" ONLY

NO GLAZING COMPOUND, TAPE or INTUMESCENT

is required for most label applications.
• Reduces cost
• Simplifies installation
• Improves appearance

WELDED STIFFENER
• Reduces corner flex.

Vandal proof binder post (included).
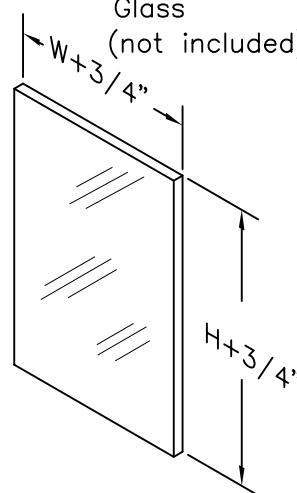
Glass (not included)

W+3/4"

H+3/4"

OPTIONS:

• 18 GA. Galvanized for exterior use.
• 18 GA. Stainless Steel for hospital and food service.
• Custom colors.
• Wood veneer wrap in various species to match door.

MOUNTING HOLES:

• 11" length or less, one hole centered.
• Over 11", three inches maximum from corners. $11\frac{5}{16}$" maximum centers.
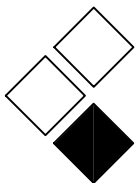
#8-32 Flat head machine screw. (included)

FRAME AND GLASS SUPPORTS (included)

Must be used for proper installation. Two required.

GLASS NOTE: For non-fire rated applications we recommend 1/4" Tempered glass. If laminated glass is used, glazing tape and light torque on the screws is required to prevent glass breakage.

LAMINATED GLASS NOT RECOMMENDED SEE GLASS NOTE.
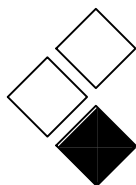
ALL METAL STAMPING, INC.

411 W. Spruce St., P.O. Box 485, Abbotsford, Wisconsin 54405-0485
Phone (715) 223-6324 Fax (715) 223-3352 Patent NO. 4,550,542

PAGE 3

www.allmetalstamping.com

Underwriters Laboratories Listings.

The UL Listings below apply to the following Glass Types.

- **WireLite NT or 7/16" Pyroshield Plus.**
- **Firelite NT, Keralite FR-F, or Pyran F (All Grades)**
- **5/16" Firelite Plus, Keralite FR-L, or Pyran L (Laminate).**

NOTE: The International Building Codes (IBC) no longer allows use of glass that is **not** safety rated in doors. Therefore we have removed all non-safety rated glass from these listings. If you have an approved use for a non-safety rated glass such as ¼" Wired Glass, WireLite, 3/16" FireLite, Keralite FR-R, or Pyran contact us to discuss your options.

Listings below are for Positive Pressure Rated (UL10C/UBC 7-2) openings for Styles listed below.
Negative Pressure Listings are available by contacting Customer Service.

c(UL)us LISTED Styles	Other Conditions or Restrictions	Rating (Minutes)	Max. Exposed Area Sq. In.	Max. Width of Exposed Area	Max. Height of Exposed Area	Glazing Tape Required
Glass Types: 7/16" Pyroshield; Firelite NT; Firelite Plus; Keralite FR-F; Keralite FR-L; Pyran F; Pyran L						
Unless Specified below Door Types are: Wood Core, Wood with Mineral Core, or Steel Doors with Honeycomb, Mineral Core, or Steel Stiffened Cores						
110, 110B, 115, 117M, 118, 118M	**All Glasses Listed**	20-45	1296	54"	54"	None
110, 110B, 115, 117M, 118, 118M	**All Glasses Listed**	20-45	2856	34"	84"	FG3000S45[2]
110, 110B, 115, 117M, 118, 118M	**All Glasses Listed Temperature Rise Doors**	60-90	100	12"	33"	None
110, 110B	**All Glasses Listed Non-Temperature Rise Doors**	60-90	300	15"	33"	None
110, 110B, 115, 117M, 118, 118M	**All Glasses Listed Non-Temperature Rise Doors**	60	Max. 1920 Single Lite 960	12" 24"	80" 36"	FG3000S90[2] HSS2000[1]
110, 110B, 115, 117M, 118, 118M	**Using Firelite, Keralite, or Pyran. Non-Temperature Rise Doors**	60	1296	54"	54"	FG3000S90[2]
110, 110B, 115, 117M, 118, 118M	**All Glasses Listed Non-Temperature Rise Doors**	90	Max. 2208 Single Lite 552	12"	46"	FG3000S90[2] HSS2000[1]
110, 110B, 115, 117M, 118, 118M	**Using Firelite, Keralite, or Pyran. Non-Temperature Rise Doors**	90	1296	54"	54"	FG3000S90[2]
Glass Types: WireLite NT						
110, 110B, 115, 117M, 118, 118M	**Using Wirelite NT**	20-45	1296	54"	54"	None
110, 110B, 115, 117M, 118, 118M	**Using Wirelite NT** **Steel Doors ONLY**	20	3289	35-3/4"	92"	FG3000S45[2]
110, 110B, 115, 117M, 118, 118M	**Using Wirelite NT** **Steel Doors ONLY**	45	2856	34"	84"	FG3000S45[2]
110, 110B, 115, 117M, 118, 118M	**Using Wirelite NT Temperature Rise Doors**	60	100	10"	33"	None

c(UL)us LISTED Styles	Other Conditions or Restrictions	Rating (Minutes)	Max. Exposed Area Sq. In.	Max. Width of Exposed Area	Max. Height of Exposed Area	Glazing Tape Required
Glass Types: WireLite NT						
Unless Specified below Door Types are: Wood Core, Wood with Mineral Core, or Steel Doors with Honeycomb, Mineral Core, or Steel Stiffened Cores						
110, 110B, 115, 117M, 118, 118M	Using Wirelite NT Non-Temperature Rise Doors **Wood Doors ONLY**	60	1296	54"	54"	None
110, 110B, 115, 117M, 118, 118M	Using Wirelite NT Non-Temperature Rise Doors **Wood Doors ONLY**	60	960	12"	80"	FG3000S90[2]
118M	Using Wirelite NT Temperature Rise Doors	90	100	10"	33"	None
110, 110B, 115, 117M, 118, 118M	Using Wirelite NT Non-Temperature Rise Doors **Steel Doors ONLY**	90	552	12"	46"	FG3000S90[2]
Glass Types: Firelite NT or Firelite Plus						
118, 118M	Using Firelite NT or Firelite Plus	180	100	12"	33"	None

Note 1: PEMKO HSS2000 must be applied to the perimeter of the Glass as shown on Page 7 when using 7/16" Pyroshield Plus.

Note 2: When PEMKO FG3000 Glazing Tape is required it must be applied as shown on Page 7. When using PEMKO FG3000S45 or FG3000S90 a special glass pocket is required.

5/16" Firelite Plus; 5/16" Keralite FR-L; and 3/8" Pyran-L require a special glass pocket due to the glass thickness.

Multiple lites are ONLY allowed in doors approved for multiple lites and the combined total of visible light cannot exceed the maximum square inches or maximum width and height dimensions allowed.

Note: Model #110 is limited to a glass weight of 85 lbs. (WireLite NT weights 2.4 lbs./Sq. Ft.; 7/16" Pyroshield Plus weights 5.6 lbs./Sq. Ft.; 5/16" Firelite Plus weights 4.0 lbs./Sq. Ft. Please consider #118, #118M, or #117M for heavier glass.

CONDITIONS OF UL LISTINGS & APPROVALS

1. Frames can be manufactured from either 18 GA. or 16 GA. Steel, Galvanized Steel, or Stainless Steel.

2. Mullions are **UL Listed** when installed using a single sheet of labeled glazing materials listed on Page 4.

3. Custom Shape Frames are **UL Listed** to 1296 in.[2] for 20-45 Minute with no dimension greater than 54"; and to 100 in.[2] for 60-90 Minute Installations with a maximum dimensions of 12" wide x 33" high. This includes Crosses, Triangles, Hexagons, etc.
   Temperature Rise restrictions apply to 60 & 90 Minute Positive Pressure Installations

4. **Veneer Wrapped Frames** do not require use of compound, tape, or intumescent up to 1296 in.[2] for 20 & 45 Minute Wood Doors with no dimensions exceeding 54", and to 100 in.[2] (300 in.[2] for Style #110/#110B) in 60 & 90 Minute Wood Doors with maximum dimensions of 12" wide x 33" high (15" wide x 33" high for Style #110/110B). Restrictions for "Large Light Sizes" apply with the following exceptions. 45 Minute installations are limited to 2695 in.[2] with a maximum visible lite size of 35" wide x 77" high using **7/16" Pyroshield Plus, Firelite, Keralite, or Pyran**. 60-90 Minute Non-Temperature Rise installations are limited to a maximum visible light of 1296 in.[2] with no dimensions exceeding 54" when using **Pyroshield Plus, Firelite, Keralite, or Pyran.** No additional restrictions when using WireLite NT.

5. Door Light Frames manufactured for doors 1 ⅜" to 2 ¼" thick can be labeled and used in appropriately labeled doors.

6. Hollow Metal Doors approved to use a clip system, in lieu of full perimeter channels, can use the AMS Hollow Metal Door Clips. See Page 9.

Page 5

Underwriters Laboratories Listings.

The UL Listings below apply to the following Glass Types.

- **FireGlass 20, PyroEdge 20, or PyroSwiss   (Tempered Glass).**

Styles	Other Conditions or Restrictions	Rating (Minutes)	Max. Exposed Area Sq. In.	Max. Width of Exposed Area	Max. Height of Exposed Area	Glazing Tape Required
c(UL)us LISTED						
Positive Pressure Listing Specifications (UL10C/UBC 7-2)						
Glass Types: FireGlass 20, PyroEdge 20, or PyroSwiss						
Door Types are: Wood Core, Wood with Mineral Core, or Steel Doors with Honeycomb, Mineral Core, or Steel Stiffened Cores						
110, 110B, 115, 117M, 118, 118M	All Glasses Listed	20	1296	54"	54"	None
110, 110B, 115, 117M, 118, 118M	All Glasses Listed	20	2856	34"	84"	FG3000S45[1]
Negative Pressure Listing Specifications (UL10B)						
Door Types are: Wood Core, Wood with Mineral Core, or Hollow Metal Doors.						
110, 110B, 115, 117M, 118, 118M	All Glasses Listed	20	1296	30"	54"	None
110, 110B, 115, 117M, 118, 118M	All Glasses Listed	20	2856	34"	84"	FG3000S45[1]

Note 1: When PEMKO FG3000 Glazing Tape is required it must be applied as shown on Page 7.
  When using PEMKO FG3000S45 a special glass pocket is required.
PyroEdge and PyroSwiss are both available in thicknesses greater than ¼" and require a special glass pocket. Multiple lites are ONLY allowed in doors approved for multiple lites and the combined total of visible light cannot exceed the maximum square inches or maximum width and height dimensions allowed.

Note: Model #110 is limited to a glass weight of 85 lbs. FireGlass 20 & PyroEdge 20 weight 3.0lbs/Sq. Ft.; PyroEdge 20 3/8" weights 4.5lbs/Sq. Ft.; PyroSwiss weights 2.6lbs.Sq. Foot.   Please consider #118, #118M, or #117M for heavier glass.

CONDITIONS OF UL LISTINGS & APPROVALS

1. Frames can be manufactured from either 18 GA. or 16 GA. Steel, Galvanized Steel, or Stainless Steel.

2. Mullions are **UL Listed** when installed using a single sheet of labeled glazing materials listed above.

3. Custom Shape Frames are **UL Listed** to 1296 in.[2] with no dimension greater than 54" for positive pressure doors; and to 1296 in.[2] with a maximum width of 30" and a maximum height of 54" for negative pressure doors. This includes Crosses, Triangles, Hexagons, etc.

4. **Veneer Wrapped Frames** do not require use of compound, tape, or intumescent up to 1296 in.[2] for 20 Minute Wood Doors with no dimensions exceeding 54" for positive pressure doors , and to 1296 in.[2] for 20 Minute Wood Doors with a maximum width of 30" and a maximum height of 54" for negative pressure doors. Installations over 1296 in.[2] can have a maximum of 2856 in.[2] of visible light with a maximum lite size of 34" wide x 84" high using FireGlass 20, PyroEdge 20, or PyroSwiss when installed with PEMKO FG3000S45 glazing tape as shown on Page 7. Multiple lites are allowed in doors approved for multiple lites but the combined total of visible light cannot exceed 2856 in.[2] or the maximum width and height dimensions.

5. Door Light Frames manufactured for doors 1 ⅜" to 2 ¼" thick can be labeled and used in appropriately labeled doors.

6. Hollow Metal Doors approved to use a clip system, in lieu of full perimeter channels, can use the AMS Hollow Metal Door Clips. See Page 9.

UL Large Door Light Frames Installation Requirements
## for 20 and 45 Minute Hollow Metal & Wood Doors (See Pages 4, 5, & 6)

34"

84"
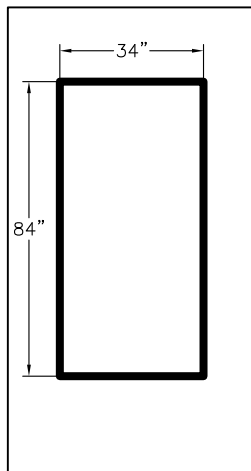
The maximum visible glass area allowed is 34" wide x 84" high or 2856 sq. in. **Exception** 20 Minute WireLite NT can have a maximum visible glass area of 35-3/4" wide x 92" high or 3289 sq. in. in HM Doors.

120" Max. Steel Door
96" Max. Wood Door

Maximum visible glass for Veneered Frames with 45 Min. Rating is 2695 sq. in. with max. dimensions of 35" x 77". **Exception:** WireLite NT is approved for HM Doors ONLY.

12"

84"
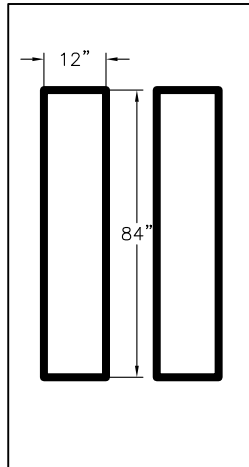
In 20 & 45 Min. Doors multiple Vision Lites are allowed, but the combined total visible glass area allowed is 2856 sq. in. per door. Veneered Frames in 45 Min. Doors are limited to 2695 sq. in. with 35" x 77" max. dimensions. **Exception:** WireLite NT is approved for HM Doors ONLY.

24"

36"

Apply FG3000S45 to frame lip as shown.

Wood Door or Hollow Metal Door
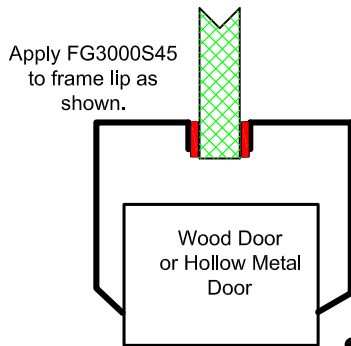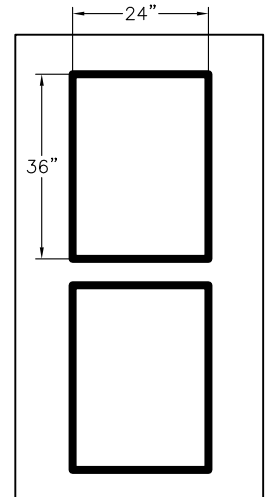
Multiple Lites are ONLY allowed in doors approved for multiple lites.

Listed Glazing Products
Wired Glass:
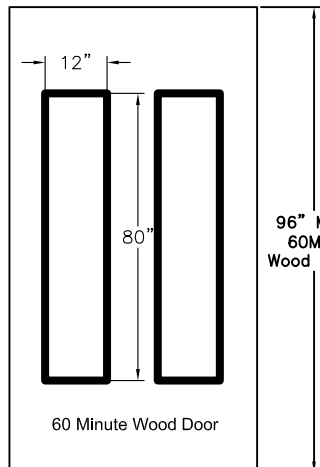$\frac{7}{16}$" Pyroshield Plus
WireLite NT

Non-Wired Glass:
**Firelite NT; Firelite Plus
Keralite FR-F; Keralite FR-L
Pyran F; Pyran L**

20 Minute Tempered Glass: FireGlass 20; PyroEdge 20; PyroSwiss

---

for 60 and 90 Minute Hollow Metal & Wood Doors (See Pages 4 & 5)
Temperature Rise Doors are limited to 100 sq. in.
Non Temperature Rise Doors are limited as below.

12"

80"

96" Max. 60Min. Wood Door

60 Minute Wood Door

When using $\frac{7}{16}$" Pyroshield Plus, or WireLite NT the guidelines below apply.

Pyroshield Plus can have multiple lites with a maximum of 1920 sq. in. of visible light in 60 Minute Door. Maximum visible glass area allowed is 12" wide x 80" high or 24" wide x 36" high with no lite larger than 960 sq. in.

WireLite NT in 60 Minute Wood Doors is limited to visible glass area of 960 sq. in. with maximum dimensions of 12" wide x 80" high.

Pyroshield Plus can have multiple lites, but the total number must not exceed 4 per door. The largest approved configuration is four (4) 12" x 46" lites or 552 sq. in. (as shown at right). The combined total visible lite area allowed is 2208 sq. in. per door.

WireLite NT in 90 Minute HM Doors is limited to a maximum visible glass area of 552 sq. in. with maximum dimensions of 12" wide x 46" high.
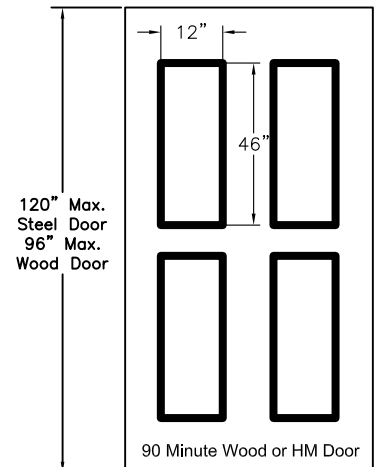
For other approved glasses see size limitations on Pages 4 & 5.

12"

46"

120" Max. Steel Door
96" Max. Wood Door

90 Minute Wood or HM Door

Apply FG3000S90 to frame lip as shown.
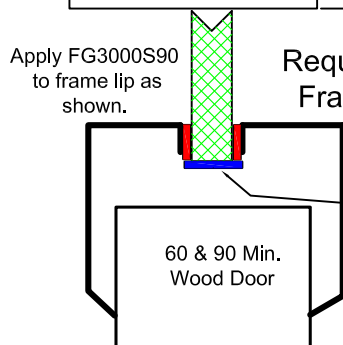
Requires Special Frame Pocket.

60 & 90 Min. Wood Door

Apply HSS2000 around perimeter of glass as shown on 60 & 90 Min. Wood Doors. Does **NOT** apply when using WireLite NT or Ceramic Glasses listed on Page 4 or 5.

Apply FG3000S90 to frame lip as shown.

Hollow Metal Door

Page 7
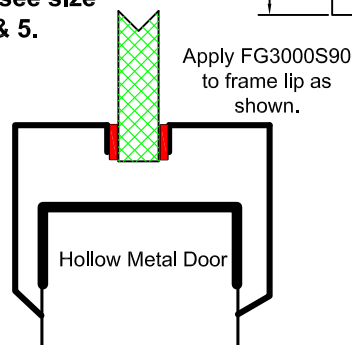
Underwriters Laboratories Listings

The glasses on this page must be installed using our Style #118 or #118M ONLY with Setting Blocks. Special Installation Instructions are provided to ensure the glass is installed in the door correctly. Be sure to indicate exactly what glass will be used on your installation when you place your order. Multiple lites are ONLY allowed in doors approved for multiple lites.

ᶜ(UL)ᵁˢ LISTED Glazing Type	Positive Pressure Ratings ONLY	Maximum Visible Light	Maximum Width	Maximum Height	Glass Thickness	Tape Thickness: ⅜" wide PVC w/Adhesive both sides	Number of AMS Preformed Setting Blocks required
[1] Firelite IGU	20 – 45 & 60 Minute Non-Temperature Rise	3204 in.[2]	36"	89"	20 Min. = ¼" / 45 Min. = ¾" / 60 Min. = 1"	⅛"	2 AMS Preformed Setting Blocks
[1] Firelite IGU	60 Minute Temperature Rise	100 in.[2]	12"	33"	1"	⅛"	2 AMS Preformed Setting Blocks
Pilkington Pyrostop	45 Minute	3724 in.[2]	41 5/8"	89 ¾"	¾"	1/16" and silicone wet seal	2 AMS Preformed Setting Blocks
[2] Pilkington Pyrostop	60 Minute	3724 in.[2]	41 5/8"	89 ¾"	⅞" And 1"	1/16" and silicone wet seal	2 AMS Preformed Setting Blocks
SwissFlam 45-N2	45 Minute	Steel 2635 in.[2] Wood 2397 in.[2]	36" 36"	77 ½" 70 ½"	¾"	1/16" and [3] silicone sealant	2 AMS Preformed Setting Blocks
[2] SwissFlam 60-N2 [2] ContraFlam N2	60 Minute	3325 in.[2]	36"	95"	1"	1/16" and [3] silicone sealant	2 AMS Preformed Setting Blocks
[4] Keralite FR-Ultra Non-Temperature Rise	20-90 Minute	1222 in.[2]	23"	53"	¾"	1/16" and [3] silicone sealant	2 AMS Preformed Setting Blocks
[4] Keralite FR-Ultra Temperature Rise	60-90 Minute	100 in.[2]	12"	33"	¾"	1/16" and [3] silicone sealant	2 AMS Preformed Setting Blocks

UL Footnotes:

[1] Firelite IGU is an insulated Glass Unit for exterior use. The Door Light Frame must be sealed around the outer perimeter of the frame as well as around the glass to protect from water infiltration. Follow Glass manufacturer's installation instructions. Do NOT use pure silicone sealant.

[2] These glasses maintain a temperature rise of no more that 250º F above ambient and are acceptable for Temperature Rise rated Fire Doors. Use of these glasses in sizes exceeding 100 in.[2] in 60 Minute Fire Rated Openings requires prior approval of the Authority Having Jurisdiction (AHJ). Ensure glazing is approved before installing.

[3] One Part neutral curing silicone: Dow Corning 795, by Dow Corning; Siliglaze-II 2800, by General Electric Co.; or Spectrum 2, by Tremco Inc.

[4] Use of Keralite FR-Ultra in 60 and 90 Minute Fire Rated Openings is limited to 100 in.[2] when used in Temperature Rise rated Fire Doors. Use of this glass in sizes exceeding 100 in.[2] in 60 and 90 Minute Fire Rated Openings requires approval of the Authority Having Jurisdiction (AHJ). Ensure glazing is approved before installing.
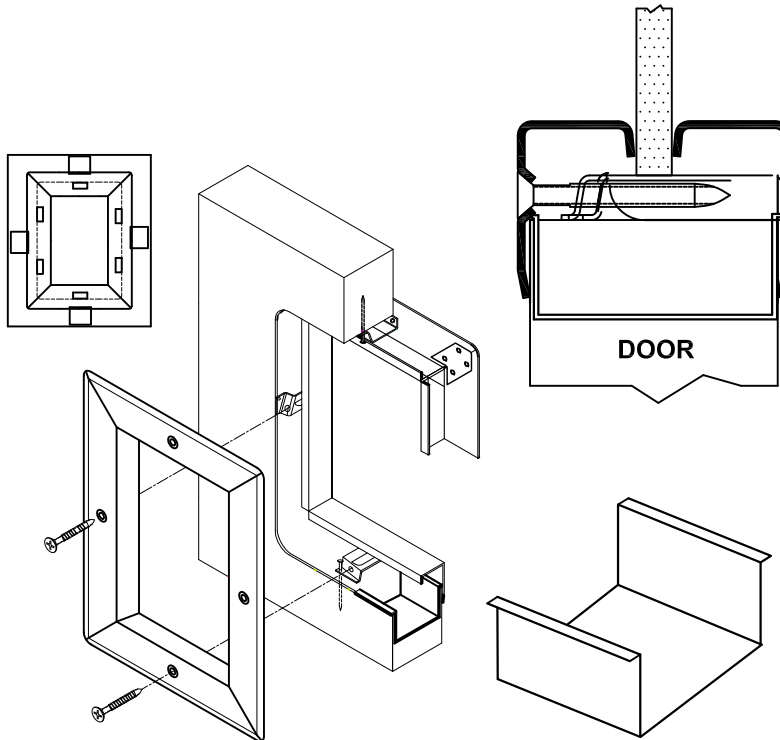
Installation Instructions
Hollow Metal Door Clip
(24 Ga. Galvanized Steel)

For Steel Doors: If the door is approved to use a clip system refer to Clip System below, otherwise reinforce the cutout per your UL or WHI procedure or follow the AMS Perimeter Channel procedure at the bottom of this page.

DOOR

Refer to door manufacturer's installation instructions. If approved to use a clip system follow those instructions as to the number of clips required.

Minimum Requirements
A minimum of 1 clip per side - centered. Any side over 50" requires 2 clips per side evenly spaced. More clips can be added to ensure sufficient strength.

Door Thickness: $1\frac{3}{4}$" Doors ONLY.

AMS Part No.: 1175-008

Installation Instructions
Hollow Metal Door Perimeter Channels (18 Ga. CRS)
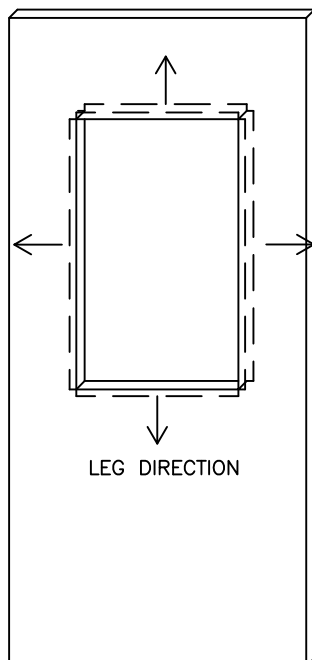
1. Cut top, bottom, and side channels the same length as the cutout dimensions.

2. Install channels by tapping into the opening until channels are flush with cutout.

3. Tack weld into place.

LEG DIRECTION

Warnock Hersey Listings.

Listings below are for Positive Pressure Rated (UL10C/UBC 7-2) openings for Styles listed below.
Negative Pressure Listings are not available for the glasses listed above.

Warnock Hersey C H US Styles	Other Conditions or Restrictions	Rating (Minutes)	Max. Exposed Area Sq. In.	Max. Width of Exposed Area	Max. Height of Exposed Area	Glazing Tape Required
Unless Specified below Door Types are: Wood Core, Wood with Mineral Core, or Steel Doors with Honeycomb, Mineral Core, or Steel Stiffened Cores						
110 & 115	SuperLite I-W[3]	20-45	1296	36"	54"	None
118 & 118M	SuperLite I-W[3]	20-45	1200	36"	54"	None
110, 115, 118 & 118M	SuperLite I-W	60-90	100	10"	33"	FG3000S90[1]
110 & 115	WireLite NT Steel Doors ONLY	20	1296	36"	54"	None
118 & 118M	WireLite NT Steel Doors ONLY	20	1200	36"	54"	None
110 & 115	WireLite NT	45	1296	36"	54"	FG3000S45[1]
118 & 118M	WireLite NT	45	1200	36"	54"	FG3000S45[1]
110, 115, 118 & 118M	WireLite NT	60-90	100	10"	33"	FG3000S90[1]
110 & 115	SuperLite I-XL	20 No Hose	1296	36"	54"	FG3000S45[1]
118 & 118M	SuperLite I-XL	20 No Hose	1200	36"	54"	FG3000S45[1]
110 & 115	SuperLite I-XL	45 No Hose[2]	1296	36"	54"	FG3000S45[1]
118 & 118M	SuperLite I-XL	45 No Hose[2]	1200	36"	54"	FG3000S45[1]
110, 115, 118 & 118M	SuperLite I-XL Steel Doors ONLY	60-90 No Hose[2]	100	10"	33"	FG3000S90[1]
118 & 118M	SuperLite X-90[4]	90	100	10"	33"	None

Note 1: When PEMKO FG3000 Glazing Tape is required it must be applied as shown below. When using PEMKO FG3000S45 or FG3000S90 a special glass pocket is required.

Note 2: SuperLite I-XL requires the approval of the Authority Having Jurisdiction (AHJ) because the glass does not pass the hose stream portion of the fire test. Ensure glazing is approved before installing.

Note 3: SuperLite I-W is 5/16" thick and requires a special glass pocket.

Note 4: SuperLite X-90 is ¾" thick and requires a special glass pocket.

Apply FG3000 to frame lip as shown.

Wood Door or Hollow Metal Door

Note: Model #110 is limited to a glass weight of 85 lbs. (WireLite NT weights 2.4 lbs./Sq. Ft.; SuperLite I-W weights 3.0 lbs./Sq. Ft.; SuperLite I-XL weights 3.0 lbs./Sq. Ft.) Please consider #118, or #118M for heavier glass. SuperLite X-90 weights 9.0 lbs./Sq. Ft. and can only use our Style #118 or #118M.
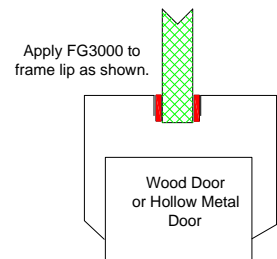
Multiple lites are ONLY allowed in doors approved for multiple lites and the combined total of visible light cannot exceed the maximum square inches or maximum width and height dimensions allowed.

Warnock Hersey Listings

The glasses on this page must be installed using our Style #118 or #118M ONLY with Setting Blocks. Special Installation Instructions are provided to ensure the glass is installed in the door correctly. Be sure to indicate exactly what glass will be used on your installation when you place your order. Multiple lites are ONLY allowed in doors approved for multiple lites.

Warnock Hersey C [WH] US Glazing Type	Positive Pressure Ratings ONLY	Maximum Visible Light	Maximum Width	Maximum Height	Glass Thickness	Tape Required	Number of AMS Preformed Setting Blocks required
[1]SuperLite I-XL IGU	20 – 45 Minute Without Hose Stream	1200 in.[2]	36"	54"	¾"	Pemko FG3000S45 & Seal perimeters	2 AMS Preformed Setting Blocks
[1]SuperLite I-XL IGU	60 Minute Without Hose Stream	100 in.[2]	10"	33"	¾"	Pemko FG3000S90 & Seal perimeters	2 AMS Preformed Setting Blocks
[2]Pyrobel-45	45 Minute	1200 in.[2]	36"	54"	Single Interior ⅝" / Single Exterior ¾"	⅛" x ½" PVC Tape w/Adhesive one side And [4]Silicone Sealant	2 AMS Preformed Setting Blocks
[2]Pryobel-60	60 Minute	100 in.[2]	10"	33"	Single Interior 1"	⅛" x ½" PVC Tape w/Adhesive one side And [4]Silicone Sealant	2 AMS Preformed Setting Blocks
[3]SuperLite II-XL 45	45 Minute	1200 in.[2]	36"	54"	Standard ¾" / Thin Profile ½"	⅛" x ⅝" PVC Glazing Tape both faces	2 AMS Preformed Setting Blocks
[3]SuperLite II-XL 60	60 Minute	100 in.[2]	10"	33"	Standard 1-⅛" / Thin Profile ⅞"	⅛" x ⅝" PVC Glazing Tape both faces	2 AMS Preformed Setting Blocks

WHI Footnotes:

[1]SuperLite I-XL IGU 20-60 Minutes: This glazing is approved for use in **Steel Doors ONLY**. Requires AHJ approval for 45-60 Minute applications because this is a directional product that was tested without hose stream. Must be installed with Pemko FG3000S45 or FG3000S90 Glazing Tape as listed above. The Door Light Frame must be sealed around the outer perimeter of the frame as well as around the glass to protect from water infiltration. **Available for installation with our #118 or #118M Door Light Frame with Setting Blocks**. Weights 6.0 lbs./Sq. Ft.

WHI Footnotes Continued:

[2]Pyrobel 45 & 60 Minutes: This glazing is approved for use in Steel or Wood Doors. These glasses maintain a temperature rise of no more than 250° F above ambient at 30 Minutes. All Pyrobel must be sealed with neutral cure silicone around perimeter of both sides (See Footnote #4). For Exterior applications the Door Light Frame must be sealed around the outer perimeter of the frame to protect from water infiltration. **Available for installation with our #118 or #118M Door Light Frame with Setting Blocks.** Pyrobel-45 Interior weights 8.2 lbs./Sq. Ft.; Pyrobel-45 Exterior weights 9.8 lbs./Sq. Ft.; Pyrobel-60 Interior weights 12.3 lbs./Sq. Ft.

[3]SuperLite II-XL 45-60 Minutes: This glazing is approved for use in Steel or Wood Doors. These glasses maintain a temperature rise of no more than 250° F above ambient at 45 and 60 Minutes respectively. Must be installed with 1/8" x 5/8" PVC Glazing Tape. **Available for installation with our #118 or #118M Door Light Frame with Setting Blocks.** SuperLite II-XL standard weights 8.0 lbs./Sq. Ft.; SuperLite II-XL 60 1-1/8" standard weights 9.0 lbs./Sq. Ft.

[4]One part neutral curing silicone: Dow Corning 795, by Dow Corning; Siliglaze-II 2800, by General Electric Co.; Spectrum 2, by Tremco Inc.

Warnock Hersey Listings

The WHI Listings below apply to the following Glass Types:
• **SuperLite 20.**

Warnock Hersey **C ⓦ US** **Styles**	**Other Conditions or Restrictions**	**Rating (Minutes)**	**Max. Exposed Area Sq. In.**	**Max. Width of Exposed Area**	**Max. Height of Exposed Area**	**Glazing Tape Required**
Positive Pressure Listing Specifications (UL10C/UBC 7-2)						
110 & 115	**SuperLite 20**	**20 No Hose**	**1296**	**36"**	**54"**	**None**
118 & 118M	**SuperLite 20**	**20 No Hose**	**1200**	**36"**	**54"**	**None**

WHI NOTE:

Positive Pressure 20 Minute No Hose installations. SuperLite 20 is approved without hose stream and is approved for use in Steel or Wood Doors. The glass thickness for SuperLite 20 can be between ¼" & ½". Listing parameters are shown in the chart above. A special glass pocket is required when using Glazing Tape or if the glass is thicker than ¼".

Note: Model #110 is limited to a glass weight of 85 lbs. (¼" SuperLite 20 weights 3.0 lbs./Sq. Ft.)

CONDITIONS OF WHI LISTINGS & APPROVALS

1. Frames can be manufactured from 18 GA. or 16 GA. Steel, Galvanized Steel, or Stainless Steel.

2. Door Light Frames manufactured for 1 ⅜" to 2 ¼" thick doors can be labeled and used in appropriately Labeled Doors.

3. Hollow Metal Doors approved to use a clip system, in lieu of full perimeter channels, can use the AMS Hollow Metal Door Clips. (See Page 9).

All Metal Stamping, Inc. Labeling Policy

All Metal Stamping, Inc. labels frames which meet our UL and/or WHI listings and approvals. It is the End User's responsibility to ensure all components used in the opening meet or exceed the fire ratings required. Our frames are only approved for use with the glasses listed on Pages 4 through 12. Use of any other glazing or improper installation voids our fire rating. All Door Light Frames and glazing combinations must be used in appropriately approved door assemblies. Interpretation of Building Codes may vary. Consult with the local authority having jurisdiction (AHJ) to determine appropriate standards for your area.

NOTE: The International Building Codes (IBC) no longer allows use of glass that is **not** safety rated in doors.   Therefore we have removed all non-safety rated glass from the listings in this catalog. If you have an approved use for a non-safety rated glass contact us to discuss your options.

Non-Fire Rated Glazing Recommendations

We highly recommend tempered glass over laminated glass in non-fire rated applications to prevent glass breakage. We also recommend glazing tape be used with all non-fire rated installations. Add allowance for glazing tape to the glass thickness to determine proper glass pocket.
     Example: 1/16" glazing tape both sides + 1/4" glass = 3/8" glass pocket.
If laminated glass is used we recommend you install with glazing tape and light torque on the screws to prevent glass breakage.

SEALED INSULATED GLASS: Insulated glass sometimes has a Seal up to 1/2" wide. Use our Style #118M or #118 to ensure this sealer is hidden from view upon installation.

Top Coating Instructions for Fire Door Hardware

STANDARD FINISH: Beige polyester powder coating. Gray polyester powder coating is also available. These coatings are tough, corrosion resistant, and provide a very durable surface. Special colors are lacquer, industrial enamel, or powder coatings dependent on color.

TOP COATING FIRE DOOR HARDWARE: Many top coats have good compatibility with powder coatings. Exceptions are some enamels, many latex, and water based paints. It is necessary that the surface be thoroughly sanded prior to the application of **any** top coat. Make sure the surface is clean and dry. To ensure compatibility always **test paint a small area** on a non-visible portion of the product and check for proper adhesion **before** proceeding. Final finish of the product is the responsibility of the purchaser. We do not warrant the suitability of the product for any particular application.
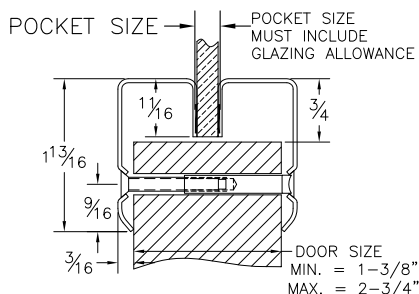

LIMITED WARRANTY: ALL METAL STAMPING, INC. WARRANTS ALL DOOR HARDWARE TO BE FREE FROM DEFECTS IN MATERIALS AND WORKMANSHIP. Purchaser assumes responsibility to verify and determine that color, finish, and quality of materials will meet required specifications. No claim shall be allowed unless the Purchaser gives notice to manufacturer within 30 days from the date materials are received. If color match, finish quality, or glass and cutout fit are not satisfactory, **DO NOT INSTALL. UPON INSTALLATION THIS WARRANTY ENDS. Manufacturer's only obligation shall be replacement, refinishing, or refund of the original purchase price, at our option. THESE ARE THE EXCLUSIVE REMEDIES PROVIDED, AND ALL METAL STAMPING, INC. SHALL NOT BE LIABLE FOR ANY OTHER DAMAGES, INCLUDING, ANY OTHER DIRECT, INDIRECT, INCIDENTAL, OR CONSEQUENTIAL DAMAGES.** This warranty does not apply to door hardware which has been abused, altered, improperly installed, used with incompatible or inappropriate components (EX. Oversized Glass), exposed to corrosive environments, or environments for which the product is not intended. No material shall be returned without prior authorization. This warranty extends only to the original Purchaser who is buying the hardware from All Metal Stamping, Inc. for purposes of resale or use in the ordinary course of their business.

ODD THICKNESS DOOR or GLASS
For Styles other than the #110 or #110B

CROSS SECTION VIEWS

POCKET SIZE → ← POCKET SIZE MUST INCLUDE GLAZING ALLOWANCE

$\frac{3}{4}$

$1\frac{1}{2}$

$\frac{15}{16}$

$\frac{3}{16}$

DOOR SIZE MIN. = 1-3/8" MAX. = 2-3/4"

POCKET SIZE → ← POCKET SIZE MUST INCLUDE GLAZING ALLOWANCE

$\frac{3}{8}$

$\frac{3}{4}$

$1\frac{1}{2}$

$\frac{15}{16}$

$\frac{3}{16}$

DOOR SIZE MIN. = 1-3/8" MAX. = 2-3/4"

POCKET SIZE → ← POCKET SIZE MUST INCLUDE GLAZING ALLOWANCE

$\frac{3}{8}$

$\frac{1}{2}$

$1\frac{1}{2}$

$\frac{9}{16}$

$\frac{3}{16}$

DOOR SIZE MIN. = 1-3/8" MAX. = 2-3/4"

POCKET SIZE → ← POCKET SIZE MUST INCLUDE GLAZING ALLOWANCE

$1\frac{1}{16}$

$1\frac{1}{16}$

$1\frac{13}{16}$

$\frac{15}{16}$

$\frac{3}{16}$

DOOR SIZE MIN. = 1-3/8" MAX. = 2-3/4"

POCKET SIZE → ← POCKET SIZE MUST INCLUDE GLAZING ALLOWANCE

$\frac{1}{2}$

$1\frac{1}{16}$

$1\frac{13}{16}$

$\frac{15}{16}$

$\frac{3}{16}$

DOOR SIZE MIN. = 1-3/8" MAX. = 2-3/4"

POCKET SIZE → ← POCKET SIZE MUST INCLUDE GLAZING ALLOWANCE

$1\frac{1}{16}$

$\frac{3}{4}$

$1\frac{13}{16}$

$\frac{9}{16}$

$\frac{3}{16}$

DOOR SIZE MIN. = 1-3/8" MAX. = 2-3/4"

Style #117M (Patent Pending)
Order Information:
Order Size = Inside Dimension of Frame (W x H)

Cutout Size = Order Size + $1\frac{1}{2}$"

Glass Size = Order Size + $\frac{3}{4}$"

Style #105M
Order Information:
Order Size = Inside Dimension of Frame (W x H)

Cutout Size = Order Size + $1\frac{1}{2}$"

Glass Size = Order Size + $\frac{3}{4}$"
Frame includes 2 Frame & Glass Supports (See Page 3)

Style #105
Order Information:
Order Size = Inside Dimension of Frame (W x H)
Cutout Size = Order Size + 1"

Glass Size = Order Size + $\frac{3}{4}$"

Style #118M
Order Information:
Order Size = Inside Dimension of Frame (W x H)

Cutout Size = Order Size + $2\frac{1}{8}$" **($2\frac{1}{4}$" for glasses listed on Pg.8 & 11)***

Glass Size = Order Size + $1\frac{5}{16}$" **(1" for glasses listed on Pg.8 & 11)***
Frame includes 2 Frame & Glass Supports (See Page 3)
*Frames on Pg. 8 & 11 include Setting Blocks.

Style #118MSP (Patent Pending)
Order Information:
Order Size = Inside Dimension of Frame (W x H)

Cutout Size = Order Size + $2\frac{1}{8}$"

Glass Size = Order Size + $1\frac{5}{16}$"

Style #118
Order Information:
Order Size = Inside Dimension of Frame (W x H)

Cutout Size = Order Size + $1\frac{1}{2}$" **($1\frac{1}{2}$" for glasses listed on Pg.8 & 11)***

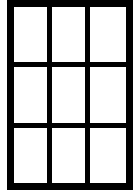Glass Size = Order Size + $1\frac{3}{8}$" **(1" for glasses listed on Pg.8 & 11)***
*Frames on Pg. 8 & 11 include Setting Blocks.

> **Glass Note: Laminated Glass NOT recommended.**
> **See "Non-Fire Rated Glazing Recommendations" on Page 13.**

FRAMES with MULLIONS use a SINGLE SHEET OF GLASS & provide a DIVIDED LIGHT APPEARANCE

3/4" PAINTED ALUMINUM-TAPE ON MULLIONS

1. **DESCRIPTION**   **Our lowest cost option.**
   - 3/4" Square Aluminum Tubing with milled flush intersections
   - Install directly to glass with double backed tape included. Attaches very securely to glass (no gaps).High quality - lowest cost. Mullions are shipped knocked down for installation at the time the frames are installed.

2. **PRICING**
   - Mullions are priced on a multiplier basis depending on size and complexity of the grid. Please call for Quote.   Veneer wrapped Mullions are available (See Page 30), but carry NO Fire Rating. Call for Quote.

3. **LIMITATIONS FOR MULLIONS**: All Styles
   - 1/4" maximum glass pocket for a 1-3/4" Door. For a 2-1/4" Door the maximum glass pocket is 3/4". Minimum Door thickness is 1-3/4".

5/8" PAINTED STEEL WELDED MULLIONS

1. **DESCRIPTION**
   - Door Light Frame with wire welded mullions to give a divided light appearance.
   - Mullions - 18 GA.- 5/8" square steel tubing.

2. **PRICING**
   - Mullions are priced on a multiplier basis depending on size and complexity of the grid. Please call for Quote.
   - For Galvanized or Stainless Steel applications 1"-3" Formed Mullions must be used. Please request information.
   - Mullions are available welded into a 3/4" Tube **SURROUND**. Call for Quote.

3. **LIMITATIONS FOR MULLIONS**: Cross mullions have 1/16" offset to conceal tube edge radii (See Page 19).
   - #110/#110B w/Cross Mullions: 1/4" maximum glass pocket for a 1-3/4" Door. For a 2-1/4" Door the maximum glass pocket is 3/4". Minimum Door thickness is 1-3/4".
   - #110/#110B w/One Way Mullions: 3/8" maximum glass pocket for a 1-3/4" Door. For a 2-1/4" Door the maximum glass pocket is 7/8".

1" TO 3" STEEL FORMED MULLIONS

1. **DESCRIPTION**
   - Door Light Frame with formed mullions with a face dimension of 1" to 3" giving a divided light appearance. Available in: 18 GA. Painted Cold Rolled Steel, Painted Galvanized, or Stainless Steel.
   - Wire welded to frame from inside mullions to provide a clean appearance.
   - Mullions are priced on a multiplier basis depending on size and complexity of the grid. Please call for information and a Quote.
   - Maximum glass pocket in 1-3/4" door is ¾".

UL LISTING

Door Light Frames with Aluminum or Steel Mullions carry the same **UL Fire Rating** as our Standard Frames when installed using a single sheet of listed glazing material. Aluminum mullions can be veneer wrapped (See Page 30) but carry **NO** Fire Rating. Steel mullions cannot be veneered.

3/4" Painted Aluminum Tape on Mullions

Mullions are attached to the glass with 1/2" x 1/32" Double sided Foam Tape
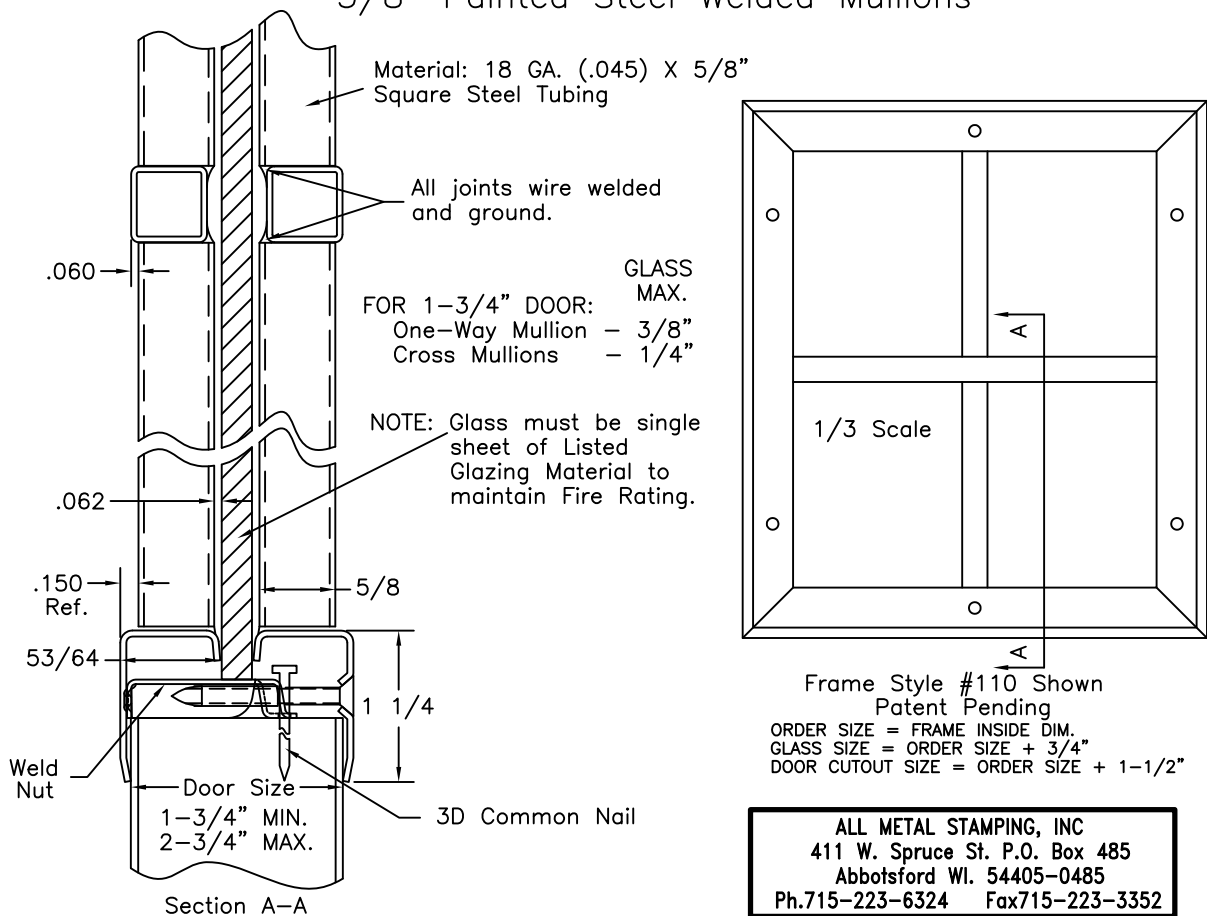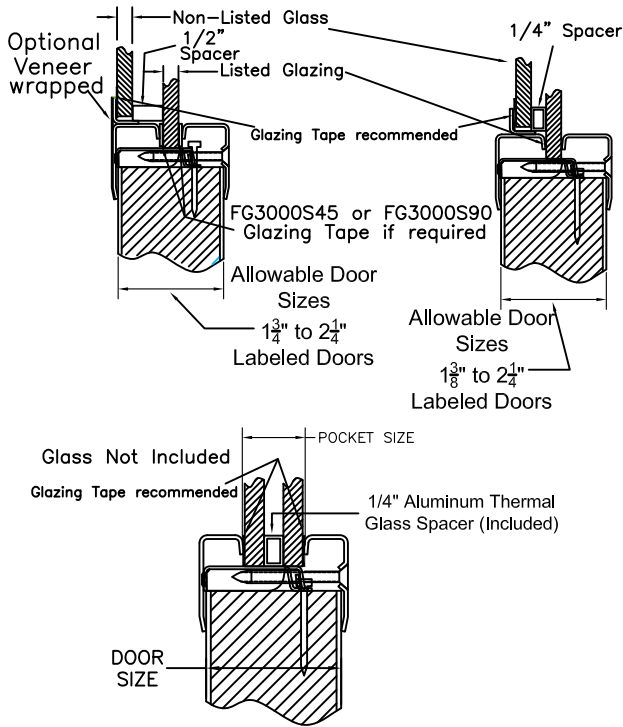
Material: Extruded Aluminum 3/4" square

NOTE: Glass must be single sheet of Listed Glazing Material to maintain Fire Rating.

3/4

3/4

53/64

1 1/4

GLASS MAX.

FOR 1-3/4" DOOR:
One-Way Mullion — 3/8"
Cross Mullions — 1/4"

CAUTION: MULLIONS CANNOT BE ADJUSTED AFTER TAPE MAKES CONTACT WITH GLASS

DO NOT PEEL BACKING FROM ADHESIVE TAPE UNTIL READY FOR FINAL PLACEMENT.

Weld Nut

Door Size
1-3/4" MIN.
2-3/4" MAX.

3D Common Nail

Section A—A

A

A

Frame Style #110 Shown
Patent Pending
ORDER SIZE = FRAME INSIDE DIM.
GLASS SIZE = ORDER SIZE + 3/4"
DOOR CUTOUT SIZE = ORDER SIZE + 1-1/2"

ALL METAL STAMPING, INC
411 W. Spruce St. P.O. Box 485
Abbotsford WI. 54405-0485
Ph.715-223-6324   Fax715-223-3352

5/8" Painted Steel Welded Mullions

Material: 18 GA. (.045) X 5/8" Square Steel Tubing

All joints wire welded and ground.

GLASS MAX.

FOR 1-3/4" DOOR:
One-Way Mullion — 3/8"
Cross Mullions — 1/4"

NOTE: Glass must be single sheet of Listed Glazing Material to maintain Fire Rating.

.060

.062

.150 Ref.

53/64

5/8

1 1/4

1/3 Scale

A

A

Weld Nut

Door Size
1-3/4" MIN.
2-3/4" MAX.

3D Common Nail

Section A—A

Frame Style #110 Shown
Patent Pending
ORDER SIZE = FRAME INSIDE DIM.
GLASS SIZE = ORDER SIZE + 3/4"
DOOR CUTOUT SIZE = ORDER SIZE + 1-1/2"

ALL METAL STAMPING, INC
411 W. Spruce St. P.O. Box 485
Abbotsford WI. 54405-0485
Ph.715-223-6324   Fax715-223-3352

CROSS SECTION VIEWS

Optional Veneer wrapped

Non—Listed Glass
1/2" Spacer
Listed Glazing
1/4" Spacer

Glazing Tape recommended

FG3000S45 or FG3000S90 Glazing Tape if required

Allowable Door Sizes
$1\frac{3}{4}$" to $2\frac{1}{4}$"
Labeled Doors

Allowable Door Sizes
$1\frac{3}{8}$" to $2\frac{1}{4}$"
Labeled Doors

Glass Not Included
Glazing Tape recommended

POCKET SIZE

1/4" Aluminum Thermal Glass Spacer (Included)

DOOR SIZE

DOUBLE or TRIPLE GLAZED FRAMES

PATENT PENDING
STYLE #110-D2 Double Glazed (shown)
STYLE #110/#110B-T Triple Glazed
Order Size: Visible Dimensions of Center Pane (W x H)
Glass Size:

Center Pane: Order Size $+\frac{3}{4}$"

Outer Pane(s): Order Size $-\frac{1}{4}$"

Cutout Size: Order Size + $1\frac{1}{2}$"

UL Listed 20, 45, and 60 Minutes when seated pane is listed glazing material. The outer pane can be listed or non-listed glazing material.

PATENT PENDING
STYLE #110-D1 Double Glazed (shown)
Order Size: Visible Dimensions of Frame (W x H)

Glass Size: Order Size $+\frac{3}{4}$"

Cutout Size: Order Size + $1\frac{1}{2}$"

NO Fire Rating.

> **Glass Note: Laminated Glass NOT recommended.**
> **See "Non-Fire Rated Glazing Recommendations" on Page 13.**

Glazing Tape recommended

1/4" or 9/16" Leaded Glass Not Included

9/16" or 1/4" Aluminum Thermal Glass Spacer (Included) use additional glazing tape to eliminate looseness or rattling.

Listed Glazing Not Included

1/2
13/16
2 1/16
9/16"
1 1/2" #115 Frame Shown

Extend Lead 1/8"

(2) Frame & Glass Supports Included. Use on bottom only.

1/4" Min. 1/2" Max. Leaded Glass Not Included

Glazing Tape recommended

(2) Frame & Glass Supports Included. Use on bottom only.

3/4 .730
1 1/2"
9/16
1—1/2" #115 Frame Shown

1/4" 3/16"

Leaded Glass Not Included

Glazing Tape recommended

7/16"
1 1/2" #115 Frame Shown
9/16"

18 Guage Frame Support Included (2 per Unit) Use on bottom only

FRAMES for LEAD LINED DOORS

STYLE #115-L1 for doors leaded under the skins or down the center. Patent #4,550,542
Order Size: Visible Dimensions of Center Pane (W x H)
Glass Size:

Center Pane: Order Size $+\frac{3}{4}$"

Outer Pane(s): Order Size $-\frac{3}{16}$"

Cutout Size: Order Size + $1\frac{5}{8}$"

Minimum Width = $2\frac{1}{2}$"

Maximum Width or Height = 33"

UL Listed 20, 45, and 60 Minutes when seated pane is listed glazing material and the outer pane is Leaded Glass.

STYLE #115-L2 or #105M-L2 for doors leaded under the skins. Patent #4,550,542
Order Size: Visible Dimensions of Frame (W x H)

Glass Size: Order Size $+\frac{3}{4}$"

Cutout Size: Order Size + $1\frac{5}{8}$"

NO Fire Rating.

STYLE #115-L3 or #105-L3 for doors leaded down the center. Patent #4,550,542
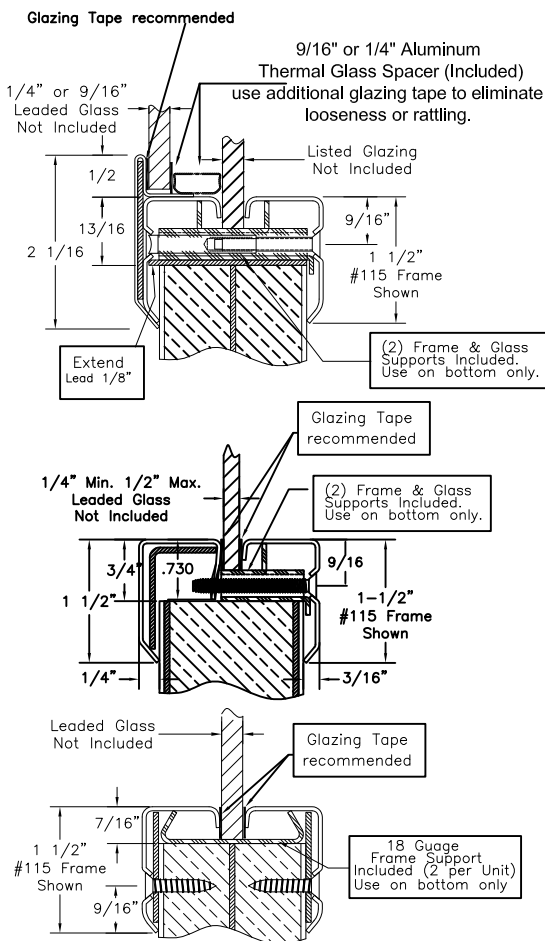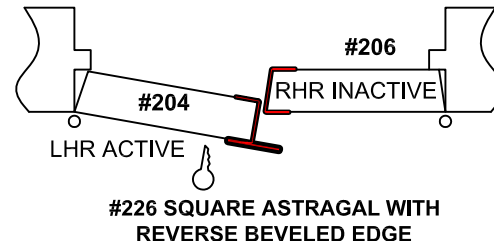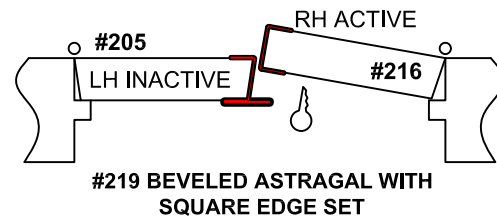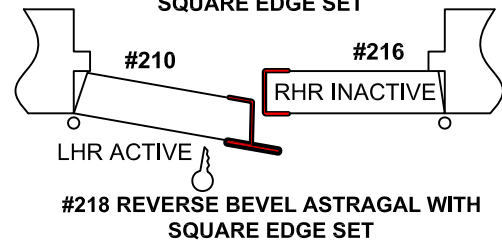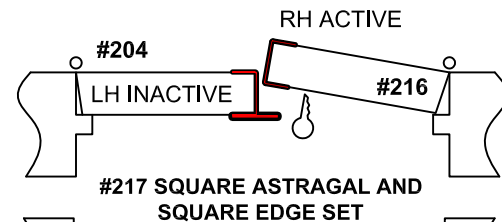Order Size: Visible Dimensions of Frame (W x H)

Glass Size: Order Size $+\frac{3}{4}$"

Cutout Size: Order Size $+\frac{7}{8}$"
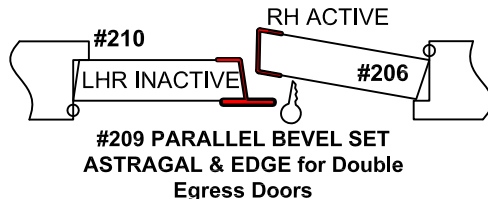
NO Fire Rating.

> **Glass Note: Laminated Glass NOT recommended.**
> **See "Non-Fire Rated Glazing Recommendations" on Page 13.**

715-223-6324
FAX: 715-223-3352

ALL METAL STAMPING, INC.
411 W. Spruce Street, P.O. Box 485
Abbotsford, WI. 54405-0485
www.AllMetalStamping.com

UL & WHI LISTED EDGE & ASTRAGAL SETS

EDGE & ASTRAGAL SETS ARE LISTED TO 90 MIN. UL/WHI.
DOUBLE EDGE SETS ARE LISTED TO 90 MIN. UL/WHI.
Listed under both Negative & Positive Pressure Standards.
UL & WHI Listed in Steel and Stainless Steel.
UL Listed with Veneer Wrapping - Negative & Positive Pressure.
WHI Listed with Veneer Wrapping - Negative Pressure ONLY.

#205 · RH ACTIVE · LH INACTIVE · #206

**#207 STANDARD BEVEL SET
ASTRAGAL & EDGE**

#206 · RH ACTIVE · LH INACTIVE · #206

**#208 DOUBLE EDGE SET - BEVELED (Shown)
#223 DOUBLE EDGE SET - SQUARE (#216 + #216)
#224 1 SQUARE/1 BEVELED (#216 + #206)
#225 EDGE SET-PARALLEL BEVELED (#227 + #206)
#225 for DOUBLE EGRESS DOORS**

#210 · RH ACTIVE · LHR INACTIVE · #206

**#209 PARALLEL BEVEL SET
ASTRAGAL & EDGE for Double
Egress Doors**

#210 · #206 · RHR INACTIVE · LHR ACTIVE

**#211 REVERSE BEVEL SET
ASTRAGAL & EDGE**

#204 · RH ACTIVE · LH INACTIVE · #206

**#212 SQUARE ASTRAGAL WITH
BEVELED EDGE**

#204 · RH ACTIVE · LH INACTIVE · #216

**#217 SQUARE ASTRAGAL AND
SQUARE EDGE SET**

#210 · #216 · RHR INACTIVE · LHR ACTIVE

**#218 REVERSE BEVEL ASTRAGAL WITH
SQUARE EDGE SET**

#205 · RH ACTIVE · LH INACTIVE · #216

**#219 BEVELED ASTRAGAL WITH
SQUARE EDGE SET**

#206 · RHR INACTIVE · #204 · LHR ACTIVE

**#226 SQUARE ASTRAGAL WITH
REVERSE BEVELED EDGE**

OTHER ITEMS
* LEAD LINED ASTRAGALS.
* DUTCH DOOR and TRANSOM CHANNELS. #222
* DUTCH DOOR SHELVES.
* "T", "Z", and FLAT ASTRAGALS.
* HINGE EDGE and LOCK EDGE PROTECTORS.
* ALUMINUM DOOR FLASHINGS.

* Standard finish is beige powder paint.

* All bevels are $\frac{1}{8}$" in 2".

* Punched and coined for #8 X $\frac{3}{4}$" Phillips
  Flat Head Screws (included).

* Hole Centers 12" or less, $3\frac{1}{2}$" Max. from
  ends and machined openings.

* AMS Machining Templates must be completed
  for each machined item (forms available on website).

* All items available in Stainless Steel.

EDGE & ASTRAGAL SPECIFICATIONS

Standard Edges are 20 GA. (.035) CRS
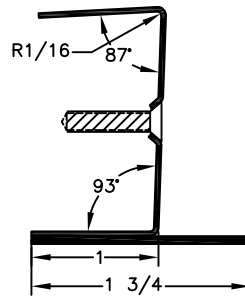**Astragal Flanges are 16 GA. (.062) CRS**
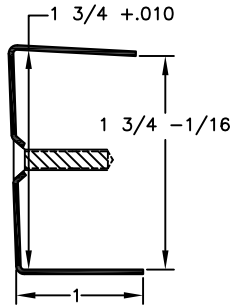
#206 Beveled Edge (shown)
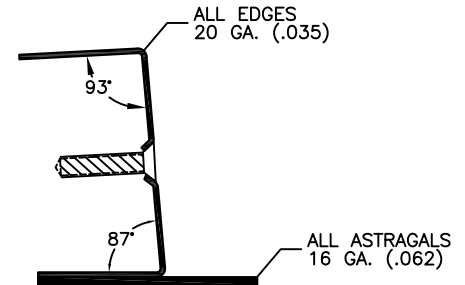**#216 Square Edge (No Bevel)**
#227 Beveled Edge Machined w/Strike open to low side of bevel.
#231 "L" Shaped Lock Edge Protector - Beveled
#233 "L" Shaped Lock Edge Protector - Square
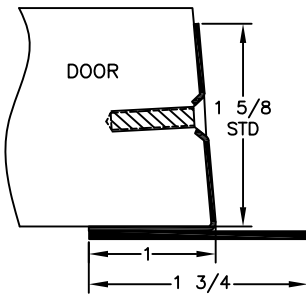
#205 Std. Beveled Astragal

#210 Reverse Beveled Astragal
#204 Square Astragal (No Bevel)

"T" (18 Ga.), "Z" (16 Ga.) & Flat Astragals (14 Ga.)
No Fire Ratings
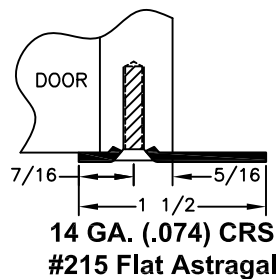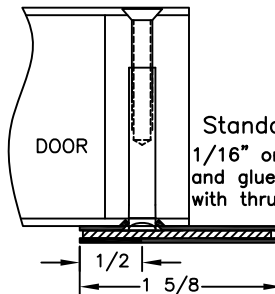

14 GA. (.074) CRS
#215 Flat Astragal

18 GA. (.048) CRS Edge/16 GA. (.062) Astragal
#229 "T" Astragal - Reverse Bevel (shown)
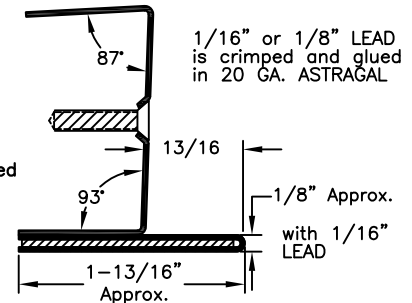**#213 "T" Astragal - Beveled**
#214 "T" Astragal - Square

Lead Lined Astragals

Standard Binder Post
1/16" or 1/8" lead is crimped and glued in 18 GA. Astragal with thru bolt attachment.

18 GA. (.048) CRS Std.
#236 Lead Lined
Flat Astragal
(No Fire Ratings)

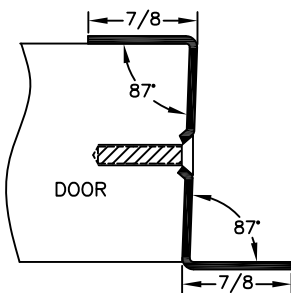1/16" or 1/8" LEAD is crimped and glued in 20 GA. ASTRAGAL

Lead Lined Astragal #205L Std. Bevel (shown)
Lead Lined Astragal #204L Square (No Bevel)
Lead Lined Astragal #210L Reverse Bevel
UL Listed to 60 Minutes
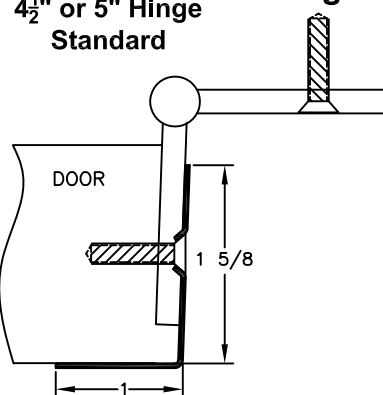**WHI Listed to 20 Minutes**
Listings apply to Astragal & Edge Sets ONLY

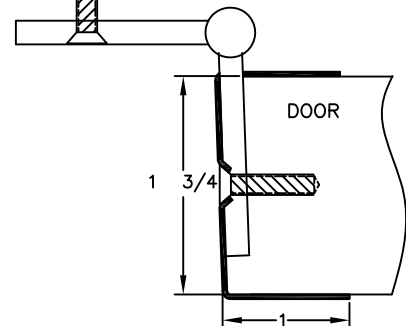**16 GA. (.062) CRS Standard**
#238 "Z" Astragal - Beveled (shown)
#239 "Z" Astragal - Reverse Bevel
#237 "Z" Astragal - Square

Punchouts For
4½" or 5" Hinge
Standard

Hinge Edge Protectors

Available in:
20 GA. CRS Painted
20 GA. or 18 GA. SS

#232 "L" Shaped - Beveled
#235 "L" Shaped - Square

#230 "U" Shaped - Beveled
#234 "U" Shaped - Square

Pricing Pages 24 & 25 are available by Email or FAX

CONCEALED VERTICAL ROD 5" METAL CHANNELS for WOOD DOORS

MATERIAL: 20 GA. GALVANIZED STEEL POWDER PAINTED BEIGE
SPECIALS: 20 GA. SS w/#4 BRUSHED FINISH
VENEER WRAPPED

AMS Part No.	Device Manufacturer	Series
251	Von Duprin Series	9847/9947
252	Von Duprin Series	5547
253	Von Duprin Series	3347/3547
254	DORMA Device	4100/6100
255	Sargent Device	8600
256	Adams Rite Device	3900/8900
257	Yale Device	2160/7120/7160
258	Monarch/Falcon Devices	(F) 17-24-18-25-XX-C
260	Arrow Device	F3600
261	Corbin Russwin Device	5860
262	Precision Device	FL 1700/1700
263	Sargent Device	PP8600 & PR8600
264	DORMA Device	9100
265	Precision Device	FL 2700/2700
266	DORMA Device	5100
267	Von Duprin Series	3347A/3547A
268	Sargent Device	WD 7000
269	Monarch/Falcon Centerslide Devices	(F) 17-24-18-25-XX-C
270	Black & Decker Series	QED 100
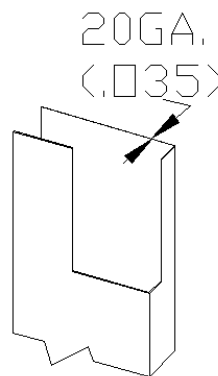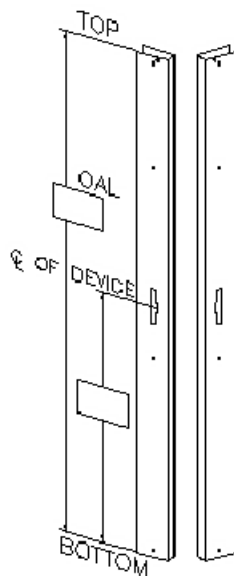
20 GA. Galvanized Channel (.035) Adds an additional 1/32" to the Edge of your door.

A completed AMS Template must accompany your order.
Templates are available on our website (www.AllMetalStamping.com)

ALL METAL STAMPING, INC.
411 W. SPRUCE STREET
P.O. BOX 485, ABBOTSFORD, WI. 54405-0485
Phone 715-223-6324   FAX 715-223-3352

Pricing Page 27 is available by Email or FAX.

STANDARD & "QUICK SHIP" SERVICES
Please specify ship date on each order.

Stock Size Frames ship the next business day with NO upcharge. (See Page 29)

DOOR LIGHT FRAMES - STYLE #110
Frames are manufactured for 1-3/4" Doors with 1/4" glazing pocket.

STANDARD SERVICE Your Order will ship 7-10 business days after the date your order is received with NO upcharges. Veneer product is available on 7-10 day service subject to availability of the veneer. (See Page 30). Call for Quote and availability.

5 DAY SERVICE Orders placed before 1 P.M. CST/CDT will ship 5 business days following that date with a 5% Upcharge per item.
Orders can include fractional and sizes from 3" to 72".

3 DAY SERVICE Orders placed before 1 P.M. CST/CDT will ship 3 business days following that date with a 10% Upcharge per item.
Standard Sizes - 3" THROUGH 60" (fractions OK).

Other expedited services are available upon request, please call for a quotation.

EDGE & ASTRAGAL SETS

All Sets are manufactured for 1-3/4" or 1-13/16" Doors. Machining is as shown on AMS templates. Special service is available at an additional charge for special machining or other non-standard dimensions.

STANDARD SERVICE Your Order will ship 7-10 business days after the date your order is received with NO upcharges. Veneer product is available on 7-10 day service subject to availability of the veneer. (See Page 30). Call for Quote and availability.

5 DAY SERVICE Orders placed before 1 P.M. CST/CDT will ship 5 business days following that date with a 5% Upcharge per item. Machined & Non-Machined - Styles #207, #208, #209, #211, #212, #217, #218, #219, #223, #224, #225, and #226 as shown on Page 22 - Any Length to 120".

3 DAY SERVICE Orders placed before 1 P.M. CST/CDT will ship 3 business days following that date with a 15% Upcharge for Machined and 10% Upcharge for Non-Machined items. Machined & Non-Machined - Styles #207, #208, #209, #211, #212, #217, #218, #219, #223, #224, #225, and #226 as shown on Page 22 - Any Length to 120".

Other expedited services are available upon request, please call for a quotation.

NOTE: An AMS Machining Template must be completed for all machined items. Call for further details. Templates are available on our website at www.AllMetalStamping.com.

VENEER WRAPPED
DOOR LIGHT FRAMES (See Pages 16,18, & 28)
ASTRAGAL & EDGE SETS (See Pages 25 & 28)
5" CHANNELS (See Page 26 & 27)

UL LISTED with the same parameters as our standard products.

SPECIES: Red Oak, White Birch, and Cherry standard. Other species are available upon request. Price and lead time are dependent on species, length, and cut requested. Request Quote.

FINISH: Ready to stain and seal.

LEAD TIME: 7-10 Business Days from the date the Order is received. (See Page 28).

NOTE: Product for interior use ONLY.

Our Veneer Supplier offers these tips to ensure your product is finished correctly:
* Always test finish your product for compatibility.
* This veneer is pre-sanded - a clean sanding is all that is needed.
* Apply sealer and allow to dry.
* Use finishes with a high percent of solids.
* Do not rush the finishing.
* Lacquer, varnish, epoxy, urethane, polyesters have all been used successfully.

TYPICAL
INSTALLATION
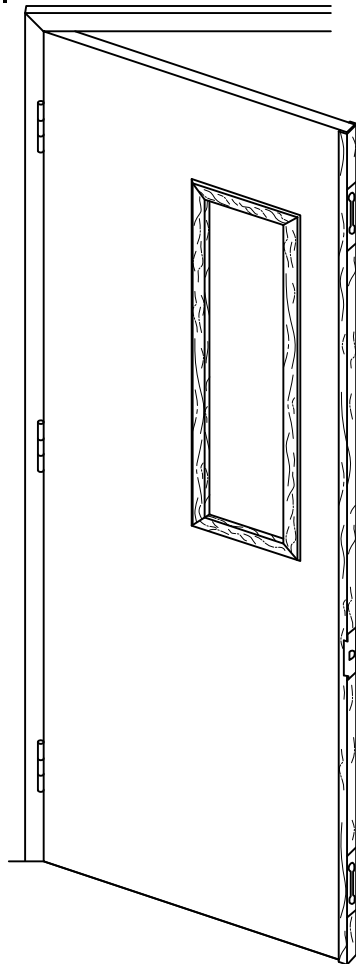
ALL METAL STAMPING, INC.
411 W. Spruce St.
P.O. Box 485
715-223-6324   Abbotsford, WI. 54405-0485   FAX: 715-223-3352

ALL METAL STAMPING, INC.
FIRE DOOR PRODUCTS

CONDITIONS OF SALE

PRICES :   Subject to change without notice.

TERMS OF SALE: 1% 10 Net 30 days with pre-approved credit.
All other shipments will be C.O.D. or Prepaid. Interest of 1-1/2% per month will be charged on all past due balances.

RECEIPT OF ORDERS: We are not responsible for orders lost in transit. We cannot guarantee we received your faxed order. If your Order is urgently needed request an Order Confirmation. Our daily cutoff time is 1 P.M. CST/CDT for Quick Ship Orders. Orders can be placed 24/7.

SHIPPING: All Orders are shipped FOB Abbotsford, Wisconsin. Parcel shipments will be shipped prepaid with freight charges added to the invoice amount. Truck shipments will be freight collect unless prior arrangements are made to ship prepaid. We will attempt to honor shipping instructions but reserve the right to use our best judgment to determine method of shipment. Seller assumes no liability for loss or damage of product in transit.

CANCELLATIONS AND CHANGES: Orders for special made or non-stock size products are not subject to cancellation by the customer once production has started. Changes to orders in process but before production has begun will receive a $10.00 charge per order.

RETURNED MERCHANDISE: No merchandise may be returned without prior permission.
On items which are accepted for return a charge will be assessed to cover the cost of handling and any rework that may be required. The restocking charge will be based on the condition of the material and its purchase price. All returns must be shipped to us PREPAID.

SURCHARGES: Due to steadily increasing stainless steel surcharges pointed out in our letter of March 5, 2010 a Stainless Steel Surcharge will be effective beginning for Orders shipped on or after 3/15/10. The Surcharge percentages will be updated monthly based on the surcharges reported on the Allegheny-Ludlum website.

LIMITATION OF LIABILITY: Manufacturer's liability for damages shall not exceed the purchase price of the material claimed to be defective. Buyer assumes responsibility to verify and determine that color, finish, and quality of materials meet specifications of the Order. No claim shall be allowed unless the original Purchaser gives notice to manufacturer within 30 days from date materials are received. If color match, finish quality, or glass and cutout fit are not satisfactory, DO NOT INSTALL. UPON INSTALLATION OUR LIABILITY ENDS. **Manufacturer's only obligation shall be replacement, refinishing, or refund of the original purchase price, at our option**. This warranty does not apply to door hardware which has been abused, altered, improperly installed, used with incompatible or inappropriate components (EX. Oversized Glass), exposed to corrosive environments, or environments for which the product is not intended. No material shall be returned without prior authorization. This warranty extends only to the original Purchaser who is buying the hardware from All Metal Stamping, Inc. for purposes of resale or use in the ordinary course of their business.