FIRE RATED HARDWARE
CATALOG 2018

We provide innovative professional products that meet the highest standards of the commercial fire door industry with great results for all your Fire Door Solutions.

ALL METAL STAMPING, INC.

Numerous Frames models & custom shapes

5" Channels for Concealed Vertical Rod Devices and Metal Door Edges

Catalog Details

- Metal Vision Panel (MVPs) frames available for Wood, Composite, and Metal Doors
- Real wood veneer in numerous species/cuts
- STC sound reduction options
- Custom designs for bullet resistent applications
- Lead Lined options for clinical and X-ray

- Frames for various glass and door thickness.
- UL Fire Ratings up to 180 min
- Standard and Custom created Mullions
- Metal Edges and Astragals
- Fast Lead Times & Quick Ship Programs

Table of Contents

Door Light Frames

Standard, "Quick Ship" & Stock List

Edge & Astragal Sets and 5" Channels

Veneer Wrapped Products

Conditions of Sale

The Pricing Guide can be obtained by email, fax, or mail by contacting us at **715-223-6324.** We will send the guide to you as soon as possible.

Lead-time for standard product is 7-10 business days. Actual ship date will depend on our production schedule.

- Custom made door astragals to suit many hardware configurations.
- Astragal/edges and hinge edge protectors.
- 16GA. Astragal lip standard. More abuse resistant.

- Available with custom mullion bars.

- #110 Frame Exclusive: One Man installation saves time and money.

- 18GA. Steel Frames are 33% more rigid than 20GA.

- UL Rated with NO glazing compound required.

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

Model 110 Low Profile Fire Door Light Frame

For standard 1 3/4" Door & 1/4" Glass and other applications

Meets UL10B requirements for NEUTRAL PRESSURE and UL10C for POSITIVE PRESSURE.

Refer to AMS Listing Specifications. Fire tested WITHOUT glazing compound, tape or intumescent.

ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + 1 1/2"

Glass size = Order size + 3/4" (tolerance (+0/-1/16))

MATERIAL:

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

FINISH:

Beige, gray or dark bronze polyester powder coating.
- Extremely durable
- Visually appealing

NARROW FACE FRAME:

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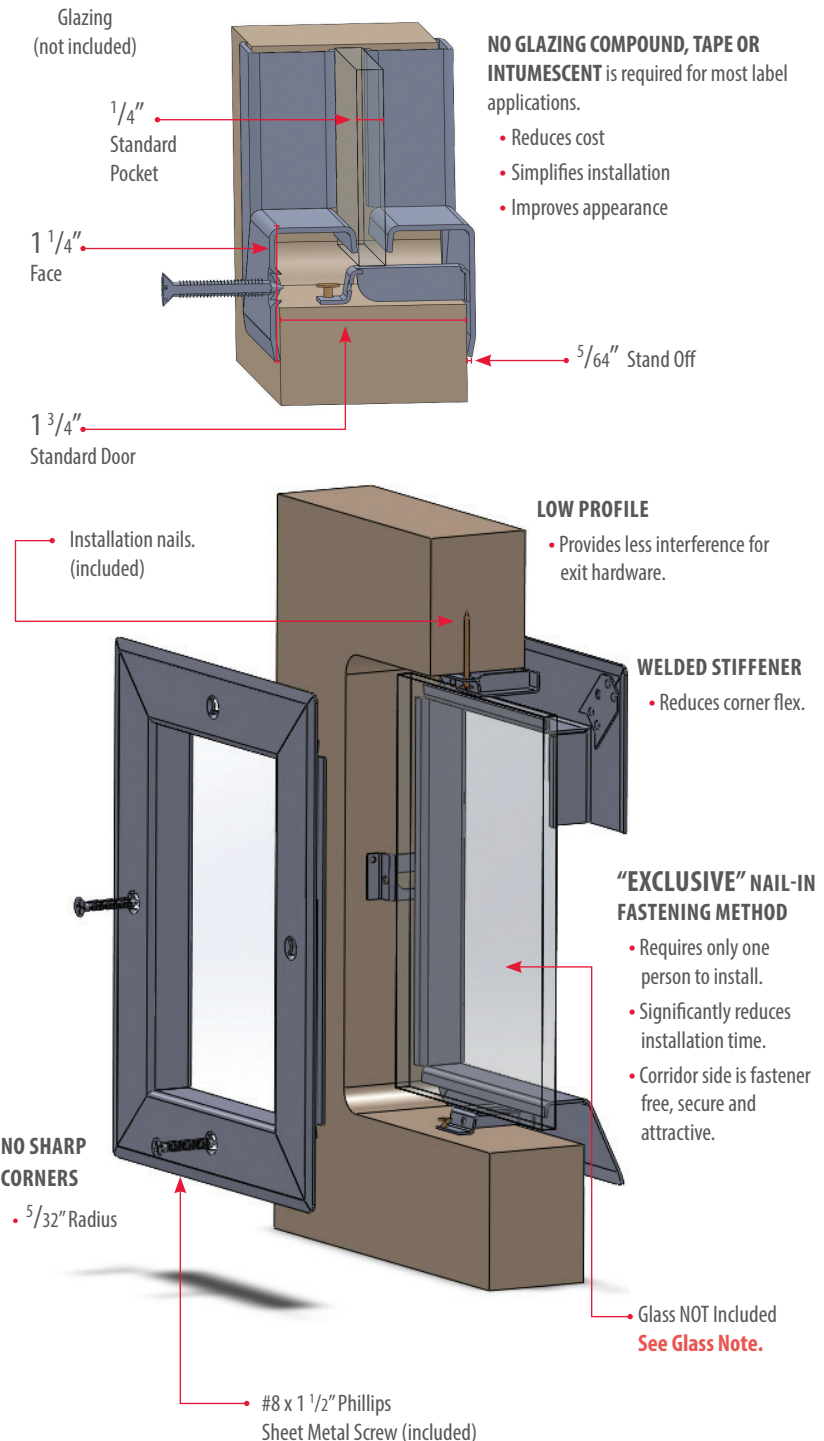- Suitable for wood, metal or mineral core doors.

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.
- Maximum Glass pocket is 5/8" less than door thickness, up to 1 1/8" deep
- Available for a variety of glass or door thicknesses

MOUNTING HOLES:

- Less than 12", one hole centered.
- 12" or more, three inches maximum from corners 11 5/16" maximum centers.

GLASS NOTE: For non-fire rated applications we recommend glazing tape and light torque on the screws to prevent glass breakage.

Glazing (not included)

1/4" Standard Pocket

1 1/4" Face

1 3/4" Standard Door

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

5/64" Stand Off

Installation nails. (included)

LOW PROFILE
- Provides less interference for exit hardware.

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.

NO SHARP CORNERS
- 5/32" Radius

Glass NOT Included **See Glass Note.**

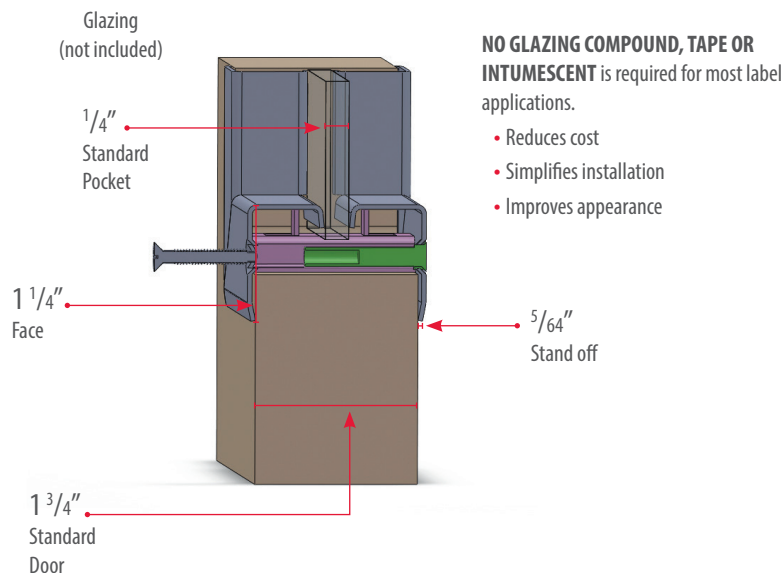#8 x 1 1/2" Phillips Sheet Metal Screw (included)

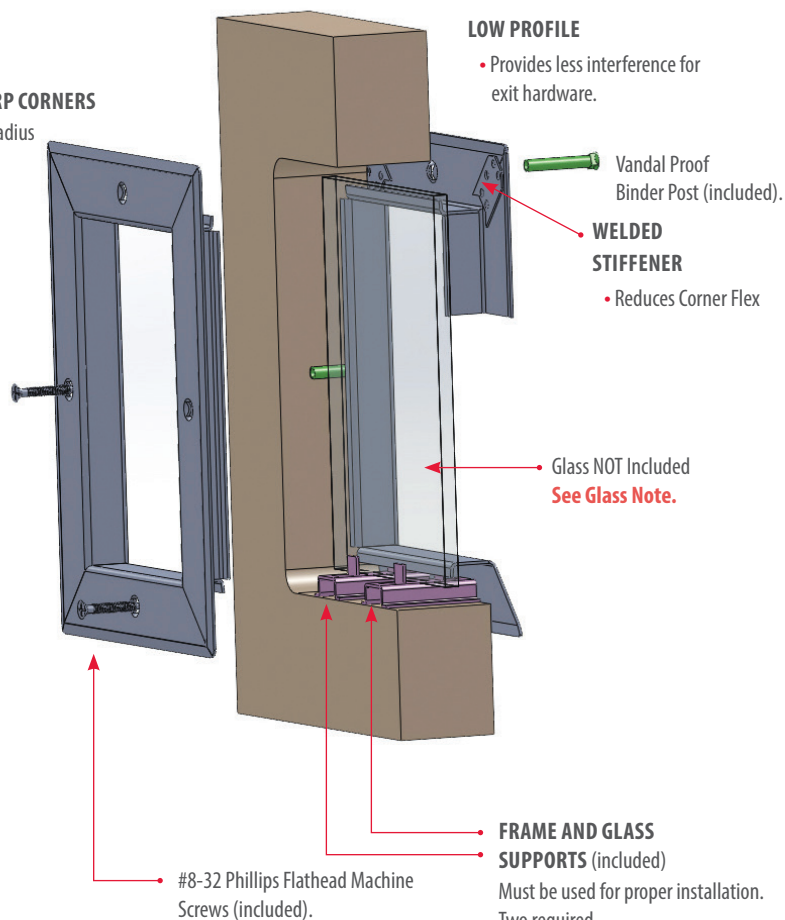# Model 110B Low Profile Fire Door Light Frame

For non-standard applications

Meets UL10B requirements for NEUTRAL PRESSURE and UL10C for POSITIVE PRESSURE.

Refer to AMS Listing Specifications. Fire tested WITHOUT glazing compound, tape or intumescent.

Glazing (not included)

$1/4''$ Standard Pocket

NO GLAZING COMPOUND, TAPE OR INTUMESCENT is required for most label applications.

- Reduces cost
- Simplifies installation
- Improves appearance

$1\,1/4''$ Face

$5/64''$ Stand off

$1\,3/4''$ Standard Door

NO SHARP CORNERS
- $5/32''$ Radius

LOW PROFILE
- Provides less interference for exit hardware.

Vandal Proof Binder Post (included).

WELDED STIFFENER
- Reduces Corner Flex

Glass NOT Included
See Glass Note.

#8-32 Phillips Flathead Machine Screws (included).

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

Order size = Inside dimension of frame, (W+H)
Cutout size = Order size $+1\,1/2''$
Glass size = Order size $+\,3/4''$ (Tolerance $+0/-1/16''$)

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

FINISH:
Beige, gray or dark bronze 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.
- Maximum glass pocket is $5/8''$ less than door thickness, up to $1\,1/8''$ deep.

MOUNTING HOLES:
- Less than 12", one hole centered.
- 12" or more, three inches maximum from corners $11\,5/16''$ maximum centers.

GLASS NOTE: For non-fire rated applications we recommend glazing tape and light torque on the screws to prevent glass breakage.

Underwriters Laboratories Listings

Listings below are for Positive Pressure Rated (UL10C) openings for Styles listed below. Neutral Pressure (UL10 B) listings are available by contacting Customer Service.

Door Types: Hollow Metal type, Composite type, and Wood Core type Fire Doors.

NOTE: The International Building Codes (IBC) no longer allows use of glass in doors that is not safety rated. The listings below includes glasses that are not safety rated. It is the Purchasers responsibility to make sure the glass you are using is approved in the jurisdiction in which it will be installed. CPSC ratings are included for your information.

We can provide Fire Rated Frames that meet the requirements in UL's Fire Protection Rated Glazing Materials Category (KCMZ), or glazing which has approval for conformance to ANSI/UL 10B, ANSI/UL 10C, NFPA80, NFPA252, OR CAN/ULC S104. Contact us if you have a glass that we do not have listed.

Frame Styles	Glass Type	Rating	Max. Size Sq. Inches	Max. Width	Max. Height	Glass Thickness	Pocket Thickness	Tape Required	CPSC Rating	Other Restrictions
110,110B, 117M,118,118M	FireGlass 20*	20 NH	1296	36	54	1/4*	Same	None	CAT I & II	
	Pyrodur 20-104					5/16	3/8		CAT I	
	Pyran S					3/16	1/4		None	
	FireLite								None	
	FireLite NT								CAT I & II	
	FireLite Plus					5/16	3/8		CAT I & II	
110,110B,115, 117M,118,118M	SuperLite I-W	20 NH	1296	54	54	5/16	3/8	None	CAT I & II	
	SuperLite 20*								CAT I & II	
	New-Wire								None	
	Safe-Wire				1/4	Same		CAT I & II	
	Labeled Wired Glass								None	
	WireLite								None	
	WireLite NT								CAT I & II	
118N ,118MN	Contraflam 30	20 NH	1296	35.8125	54	13/16	Same	None	CAT I & II	
	Pyrodur 20-250,260,280,350,360,380			47.1250	54	15/16			CAT II	
110,110B, 117M,118,118M	Pyrodur 20-200	20 NH	1296	47.1250	54	3/8	Same	None	CAT I	
	PyroSwiss 20*			47.5000	54	1/4			CAT I & II	
110,110B, 117M,118,118M	Pyroguard	20 NH	1404	28	62	5/16	7/16	FG3000S45	CAT I	
	Pyrodur 20-104		1944	36	54					
110,110B, 117M,118,118M	SuperLite 20*	20 NH	2678	109	109					Hollow Metal Door
	SuperLite 20*		2719	77.1250	77.1250					Wood Door
	Safe-Wire		2994	35.7500	92	1/4	3/8	1/16 PVC Tape	CAT I & II	
	FireGlass 20*		3204	36	89					
	PyroSwiss 20*		3419	47.5000	95.5000					
118N ,118MN	Contraflam 30	20 NH	3419	35.8125	95.5000	13/16	15/16	1/16 PVC Tape	CAT I & II	
	Pyrodur 20-250,260,280,350,360,380		4477	47.1250	89.7500	15/16	1-1/16	FG3000S45		
110,110B, 117M,118,118M	Pyran S	20 NH	3204	36	89	3/16	5/16	FG3000S45	None	
	FireLite									
	FireLite NT								CAT I & II	
	FireLite Plus					5/16	7/16			
110,110B, 117M,118,118M	SuperLite I-W	20 NH	3289	35.7500	92	5/16	7/16	1/16 PVC Tape	CAT I & II	Hollow Metal Door
	Labeled Wired Glass									
	New-Wire					1/4	3/8	FG3000S45	None	
	WireLite									
	WireLite NT								CAT I & II	
110,110B, 117M,118,118M	SuperLite XL[1]	20-45 NH	3341	35.1250	96	1/4	3/8	1/16 PVC Tape	CAT I & II	[1]Requires Approval of AHJ
	Fireswiss LAM20	20 NH	4608	48	96	7/16	9/16			
118W,118MW	SuperLite XL IGU[1]	20-45 NH	3341	35.1250	96	1" Std.	1-1/4	1/8 PVC Tape	CAT I & II	[1]Requires Approval of AHJ
118N ,118MN	SuperLite XL IGU[1]					3/4	1			
110,110B,115, 117M,118,118M	Labeled Wired Glass	20-45	1296	54	54	1/4	Same	None	None	
	Protect3 Safety Glass (Wired)								CAT I & II	
	New-Wire								None	
	Safe-Wire								CAT I & II	
	WireLite								None	
	WireLite NT								CAT I & II	
	SuperLite I-W					5/16	3/8		CAT I & II	
110,110B,117M, 118,118M	Labeled Wired Glass	20-45	2856	34	84	1/4	3/8	FG3000S45	None	Hollow Metal Door ONLY
	Protect3 Safety Glass (Wired)								CAT I & II	
	New-Wire								None	
	WireLite								None	
	WireLite NT								CAT I & II	
	SuperLite I-W					5/16	7/16	1/16 PVC Tape	CAT I & II	
110,110B,117M, 118,118M	Safe-Wire	20-45	2856	34	84	1/4	3/8	FG3000S45	CAT I & II	
110,110B,117M, 118,118M	Labeled Wired Glass	20-45	960	12	80	1/4	3/8	FG3000S45	None	Wood Door ONLY
	Protect3 Safety Glass (Wired)								CAT I & II	
	New-Wire								None	
	WireLite								None	
	WireLite NT								CAT I & II	
110,110B,115, 117M,118,118M	Keralite FR-R	20-45	1296	46.500	54	3/16	1/4	None	None	
	Keralite FR-F								CAT I & II	
	Keralite FR-L					5/16	3/8		CAT I & II	

* FireGlass 20, PyroSwiss 20, and SuperLite 20 can vary in thickness from 1/4" to 1/2".

[1]20-45 Minute SuperLite XL requires approval of the AHJ.

NOTE: NO HOSE frames are not recognized in Canada.

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www.AllMetalStamping.com
ALL METAL STAMPING, INC.
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Underwriters Laboratories Listings

NOTE: The International Building Codes (IBC) no longer allows use of glass in doors that is not safety rated. The listings below includes glasses that are not safety rated. It is the Purchasers responsibility to make sure the glass you are using is approved in the jurisdiction in which it will be installed. CPSC ratings are included for your information.

Listings below are for Positive Pressure Rated (UL10C) openings for Styles listed below. Neutral Pressure (UL10 B) listings are available by contacting Customer Service.

Door Types: Hollow Metal type, Composite type, and Wood Core type Fire Doors.

We can provide Fire Rated Frames that meet the requirements in UL's Fire Protection Rated Glazing Materials Category (KCMZ), or glazing which has approval for conformance to ANSI/UL 10B, ANSI/UL 10C, NFPA80, NFPA252, OR CAN/ULC S104. Contact us if you have a glass that we do not have listed.

Frame Styles	Glass Type	Rating	Max. Size Sq. Inches	Max. Width	Max. Height	Glass Thickness	Pocket Thickness	Tape Required	CPSC Rating	Other Restrictions
110,110B,117M, 118,118M	Keralite FR-R	20-45	3627	46.500	78	3/16	5/16	1/16 PVC Tape	None	
	Keralite FR-F								CAT I & II	
	Keralite FR-L					5/16	7/16		CAT I & II	
110,110B,115, 117M,118,118M	Pyran Star S, Crystal S	20-45	1296	36	54	3/16	1/4	None	None	
	Pyran Star F, Crystal F								CAT I & II	
	Pyran Platinum F								CAT I & II	
	Pyran Star L, Crystal L					5/16	3/8		CAT I & II	
	Pyran Platinum L					3/8			CAT I & II	
	FireLite					3/16	1/4		None	
	FireLite NT								CAT I & II	
	FireLite Plus					5/16	3/8		CAT I & II	
110,110B,117M, 118,118M	Pyran Star S, Crystal S	20-45	2736	36	76	3/16	5/16	FG3000S45	None	
	Pyran Star F, Crystal F								CAT I & II	
	Pyran Platinum F								CAT I & II	
	Pyran Star L, Crystal L					5/16	7/16		CAT I & II	
	Pyran Platinum L					3/8	1/2		CAT I & II	
110,110B,117M, 118,118M	FireLite	20-45	3204	36	89	3/16	5/16	FG3000S45	None	
	FireLite NT								CAT I & II	
	FireLite Plus					5/16	7/16		CAT I & II	
118N ,118MN	Keralite FR-F IGU	20-45	3627	46.500	78	11/16	13/16	1/16 PVC Tape	CAT II	
	Keralite FR-L IGU					13/16	15/16			
118N ,118MN	Keralite Ultra	20-45	2736	46.500	76	3/4	7/8	1/16 PVC Tape	CAT II	
118W,118MW	Keralite Ultra IGU	20-45	2736	46.500	76	1-1/4	1-3/8	1/16 PVC Tape	CAT II	
	Keralite Ultra HI IGU					1-1/2	1-5/8			
	FireLite IGU		3204	36	89	1	1-1/4	1/8 PVC Tape	CAT I & II	
110,110B,117M, 118,118M	Pilkington Pyroshield Plus	45	1296	24	54	7/16	9/16	FG3000S45	CAT I	
118N ,118MN	Fireswiss Foam C40	45	2859	34.625	82.5625	7/8	1	1/16 PVC Tape	CAT I & II	
118W,118MW	Fireswiss Foam C44	45	4608	48	96	1-1/16	1-3/16	1/16 PVC Tape	CAT I & II	
118N ,118MN	Contraflam/Swissflam 45	45	3419	35.8125	95.5000	3/4	7/8	1/16 PVC Tape	CAT II	
118W,118MW	Contraflam/Swissflam 45 IGU					1-1/4	1-3/8			
118N ,118MN	Pyrostop 45-200	45	3724	41.625	89.750	3/4	7/8	FG3000S45	CAT I & II	
118N ,118MN	Pyrobel-45	45	2747	58.750	58.750	5/8	7/8	1/8 PVC Tape	CAT I & II	Interior
	Pyrobel-45 Exterior					3/4	1			Exterior
118W,118MW	Pyrobel-45 Exterior Insulated					1-3/8	1-5/8			Exterior Insulated
118N ,118MN	SuperLite II-XL **	45	1296	54	54	1/2	3/4	1/8 PVC Tape	CAT I & II	
			2432	34.500	70.500	3/4" Std.	1			
118W,118MW			4952	116**	116**	1	1-1/4			
110,110B,117M, 118,118M	SuperLite X-45	45	100	10	33	3/4	7/8	1/16 PVC Tape	CAT I & II	
	SuperLite X-60	60								Temp. Rise
	SuperLite X-90	90								
110,110B,117M, 118,118M	Labeled Wired Glass	60-90	100	12	33	1/4	Same	None	None	
	Protect3 Safety Glass (Wired)								CAT I & II	
	New-Wire								None	Temp. Rise
	Safe-Wire								CAT I & II	
	SuperLite I-W					5/16	3/8		CAT I & II	
110,110B,115, 117M,118,118M	WireLite	60-90	100	10	33	1/4	Same	None	None	Temp. Rise
	WireLite NT								CAT I & II	
110,110B,115, 117M,118,118M	Labeled Wired Glass					1/4	Same	None	None	Non-Temp. Rise
	Protect3 Safety Glass (Wired)								CAT I & II	
	New-Wire								None	
	Safe-Wire								CAT I & II	
	SuperLite I-W	60-90	300	15	33	5/16	3/8		CAT I & II	
	WireLite					1/4	Same		None	
	WireLite NT								CAT I & II	
110,110B,117M, 118,118M	Labeled Wired Glass	60	960	12	80	1/4	3/8	FG3000S90	None	Non-Temp. Rise & Wood Door ONLY
	Protect3 Safety Glass (Wired)								CAT I & II	
	New-Wire								None	
	Safe-Wire								CAT I & II	
	WireLite								None	
	WireLite NT								CAT I & II	
	SuperLite I-W					5/16	7/16	1/16 PVC Tape	CAT I & II	

** SuperLite II-XL is limited to a Max. Width or Max. Height of 116" by AMS Tooling.

ALL METAL STAMPING, INC.

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www.AllMetalStamping.com

Underwriters Laboratories Listings

Listings below are for Positive Pressure Rated (UL10C) openings for Styles listed below. Neutral Pressure (UL10 B) listings are available by contacting Customer Service.

Door Types: Hollow Metal type, Composite type, and Wood Core type Fire Doors.

We can provide Fire Rated Frames that meet the requirements in UL's Fire Protection Rated Glazing Materials Category (KCMZ), or glazing which has approval for conformance to ANSI/UL 10B, ANSI/UL 10C, NFPA80, NFPA252, OR CAN/ULC S104. Contact us if you have a glass that we do not have listed.

Frame Styles	Glass Type	Rating	Max. Size Sq. Inches	Max. Width	Max. Height	Glass Thickness	Pocket Thickness	Tape Required	CPSC Rating	Other Restrictions
110,110B,117M, 118,118M	Labeled Wired Glass					1/4	3/8	FG3000S90	None	Non-Temp. Rise & Wood Door ONLY
	Protect3 Safety Glass (Wired)								CAT I & II	
	New-Wire								None	
	SuperLite I-W	90	552	12	46	5/16	7/16	1/16 PVC Tape	CAT I & II	
	WireLite								None	
	WireLite NT					1/4	3/8	FG3000S90	CAT I & II	
	Safe-Wire								CAT I & II	
110,110B,115, 117M,118,118M	Keralite FR-R	60-90	100	10	33	3/16	1/4	None	None	Temp. Rise
	Keralite FR-F								CAT I & II	
	Keralite FR-L					5/16	3/8		CAT I & II	
110,110B,115, 117M,118,118M	Keralite FR-R	60-90	300	15	33	3/16	1/4	None	None	Non-Temp. Rise
	Keralite FR-F								CAT I & II	
	Keralite FR-L					5/16	3/8		CAT I & II	
110,110B,115, 117M,118,118M	Keralite FR-R	60	3627	46.500	78	3/16	5/16	1/16 PVC Tape	None	Non-Temp. Rise
	Keralite FR-F								CAT I & II	
	Keralite FR-L					5/16	7/16		CAT I & II	
110,110B,115, 117M,118,118M	Keralite FR-R	90	3534	46.500	76	3/16	5/16	1/16 PVC Tape	None	Non-Temp. Rise
	Keralite FR-F								CAT I & II	
	Keralite FR-L					5/16	7/16		CAT I & II	
118N ,118MN	Keralite FR-F IGU	60-90	100	10	33	11/16	13/16	1/16 PVC Tape	CAT II	Temp. Rise
	Keralite FR-L IGU					13/16	15/16			
118N ,118MN	Keralite FR-F IGU	60	3627	46.500	78	11/16	13/16	1/16 PVC Tape	CAT II	Non-Temp. Rise
	Keralite FR-L IGU					13/16	15/16			
118N ,118MN	Keralite FR-F IGU	90	3534	46.500	76	11/16	13/16	1/16 PVC Tape	CAT II	Non-Temp. Rise
	Keralite FR-L IGU					13/16	15/16			
118N ,118MN	Keralite Ultra	60-90	2736	46.500	76	3/4	7/8	1/16 PVC Tape	CAT II	Temp. Rise
118W,118MW	Keralite Ultra IGU	60-90	2736	46.500	76	1-1/4	1-3/8	1/16 PVC Tape	CAT II	Temp. Rise
	Keralite Ultra HI IGU					1-1/2	1-5/8			
110,110B,115, 117M,118,118M	Pyran Star S, Crystal S	60-90	100	12	33	3/16	1/4	None	None	Temp. Rise
	Pyran Star F, Crystal F								CAT I & II	
	Pyran Platinum F									
	Pyran Star L, Crystal L					5/16	3/8			
	Pyran Platinum L					3/8				
	FireLite					3/16	1/4		None	
	FireLite NT								CAT I & II	
	FireLite Plus					5/16	3/8			
110,110B,115, 117M,118,118M	Pyran Star S, Crystal S	60-90	100	15	33	3/16	1/4	None	None	Non-Temp. Rise
	Pyran Star F, Crystal F								CAT I & II	
	Pyran Platinum F									
	Pyran Star L, Crystal L					5/16	3/8			
	Pyran Platinum L					3/8				
	FireLite					3/16	1/4		None	
	FireLite NT								CAT I & II	
	FireLite Plus					5/16	3/8			
110,110B,117M, 118,118M	Pyran Star S, Crystal S	60-90	2736	36	76	3/16	3/8	FG3000S90	None	Non-Temp. Rise
	Pyran Star F, Crystal F								CAT I & II	
	Pyran Platinum F									
	Pyran Star L, Crystal L					5/16	7/16			
	Pyran Platinum L					3/8	1/2			
110,110B,117M, 118,118M	FireLite	60-90	3204	36	89	3/16	3/8	FG3000S90	None	Non-Temp. Rise
	FireLite NT								CAT I & II	
	FireLite Plus					5/16	7/16			
110,110B,115, 117M,118,118M	WireLite	60-90	100	10	33	1/4	Same	None	None	Temp. Rise
	WireLite NT								CAT I & II	
110,110B,117M, 118,118M	Pilkington Pyroshield Plus	60-90	100	20	20	7/16	9/16	FG3000S90	CAT I	Non-Temp. Rise
118N ,118MN	Fireswiss Foam C40	60	1868	22.625	82.5625	7/8	1	1/16 PVC Tape	CAT I & II	Temp. Rise
118W ,118MW	FireLite IGU	60-90	100	12	33	1	1-1/4	1/8 PVC Tape	CAT I & II	Temp. Rise
	FireLite IGU		3204	36	89					Non-Temp. Rise
118N ,118MN 118W,118MW	Contraflam/Swissflam 60	60	2685	30	89.500	3/4	7/8	1/16 PVC Tape	CAT II	Temp. Rise
	Contraflam/Swissflam 60 IGU					1-1/2	1-5/8			
	Contraflam/Swissflam 60 IGU-HI					1-5/16	1-7/16			

Underwriters Laboratories Listings

Listings below are for Positive Pressure Rated (UL10C) openings for Styles listed below. Neutral Pressure (UL10 B) listings are available by contacting Customer Service.

Door Types: Hollow Metal type, Composite type, and Wood Core type Fire Doors.

We can provide Fire Rated Frames that meet the requirements in UL's Fire Protection Rated Glazing Materials Category (KCMZ), or glazing which has approval for conformance to ANSI/UL 10B, ANSI/UL 10C, NFPA80, NFPA252, OR CAN/ULC S104. Contact us if you have a glass that we do not have listed.

Frame Styles	Glass Type	Rating	Max. Size Sq. Inches	Max. Width	Max. Height	Glass Thickness	Pocket Thickness	Tape Required	CPSC Rating	Other Restrictions
118W,118MW	Contraflam/Swissflam 90	90	3174	35.750	88.5625	1-7/16	1-9/16	1/16 PVC Tape	CAT II	Temp. Rise
118N ,118MN	Pyrostop 60-101	60	3724	41.625	89.750	3/4	15/16	FG3000S90	CAT I & II	Temp. Rise
118W ,118MW	Pyrostop 90-102	90				1-7/16	1-9/16			
118N ,118MN	SuperLite II-XL	60	1296	54	54	7/8	1-1/8	1/8 PVC Tape	CAT I & II	Non-Temp. Rise
118W,118MW	SuperLite II-XL**	60	4952	116**	116**	1-1/8	1-3/8	1/8 PVC Tape	CAT I & II	Non-Temp. Rise
	SuperLite II-XL**	90	4990	116**	116**	1-1/2	1-3/4			
118W,118MW	Pyrobel-60	60	3855	44	87.625	1	1-1/4	1/8 PVC Tape	CAT I & II	Interior Temp. Rise
	Pyrobel-60 Exterior					1-1/4	1-1/2	1/8 PVC Tape	CAT I & II	Exterior
118W,118MW	Pyrobel-90	90	2916	36	61	1-3/8	1-5/8	1/8 PVC Tape	CAT I & II	Interior Temp. Rise
110,110B,115, 117M,118,118M	Keralite FR-R	180	100	10	33	3/16	1/4	None	None	Temp. Rise
	Keralite FR-F								CAT I & II	
	Keralite FR-L					5/16	3/8			
118N ,118MN	Keralite FR-F IGU	180	100	10	33	11/16	13/16	1/16 PVC Tape	CAT I & II	Temp. Rise
	Keralite FR-L IGU					13/16	15/16			
118N ,118MN	Keralite Ultra	180	100	10	33	3/4	7/8	1/16 PVC Tape	CAT II	Temp. Rise
118W,118MW	Keralite Ultra IGU	180	100	10	33	1-1/4	1-3/8	1/16 PVC Tape	CAT II	Temp. Rise
	Keralite Ultra HI IGU					1-1/2	1-5/8			
110,110B,115, 117M,118,118M	Pyran Star S, Crystal S	180	100	12	33	3/16	1/4	None	None	Temp. Rise
	Pyran Star F, Crystal F								CAT I & II	
	Pyran Platinum F									
	Pyran Star L, Crystal L					5/16	3/8			
	Pyran Platinum L					3/8				
	FireLite					3/16	1/4		None	
	FireLite NT								CAT I & II	
	FireLite Plus					5/16	3/8			
118W ,118MW	FireLite IGU	180	100	12	33	1	1-1/4	1/8 PVC Tape	CAT II	Temp. Rise

** SuperLite II-XL is limited to a Max. Width or Max. Height of 116" by AMS Tooling.

Conditions of UL Listings

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 material.
3. Custom Shape Frames are UL Listed to 1296 in.[2] for 20-45 Minute Installations with no dimension greater than 54"; and to 100 in.[2] for 60-90 Minute Installations with maximum dimensions of 12" wide X 33" high. This includes Crosses, Triangles, Hexagons, etc.
4. Temperature Rise restrictions apply to 60, 90, and 180 Minute installations.
5. Veneer wrapped frames follow the same guidelines as non-veneered frames.
6. Door Light Frames manufactured for 1-3/8" to 2-1/4" thick doors can be labeled and used in appropriately labeled doors.
7. 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.

Conditions of UL Approvals

- Use of Glazing Tape when installing Door Light Frames requires the Frame to have a special glass pocket.
- All units listed on Page 5 with a rating of 20 Minute No Hose are not approved under the Canadian Standard.
- FireGlass 20, PyroSwiss 20, and SuperLite 20 are each available in thicknesses greater than 1/4" and require a special glass pocket.
- Multiple lites are ONLY allowed in doors approved for multiple lites and the combined total of visible glass light cannot exceed the maximum square inches or maximum width and height dimensions specified in those approvals.
- The Model #110 and Model #117M are limited to a maximum glass weight of 85 lbs. Please consider our Model #110B, #118, or #118M for heavier glass.

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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.

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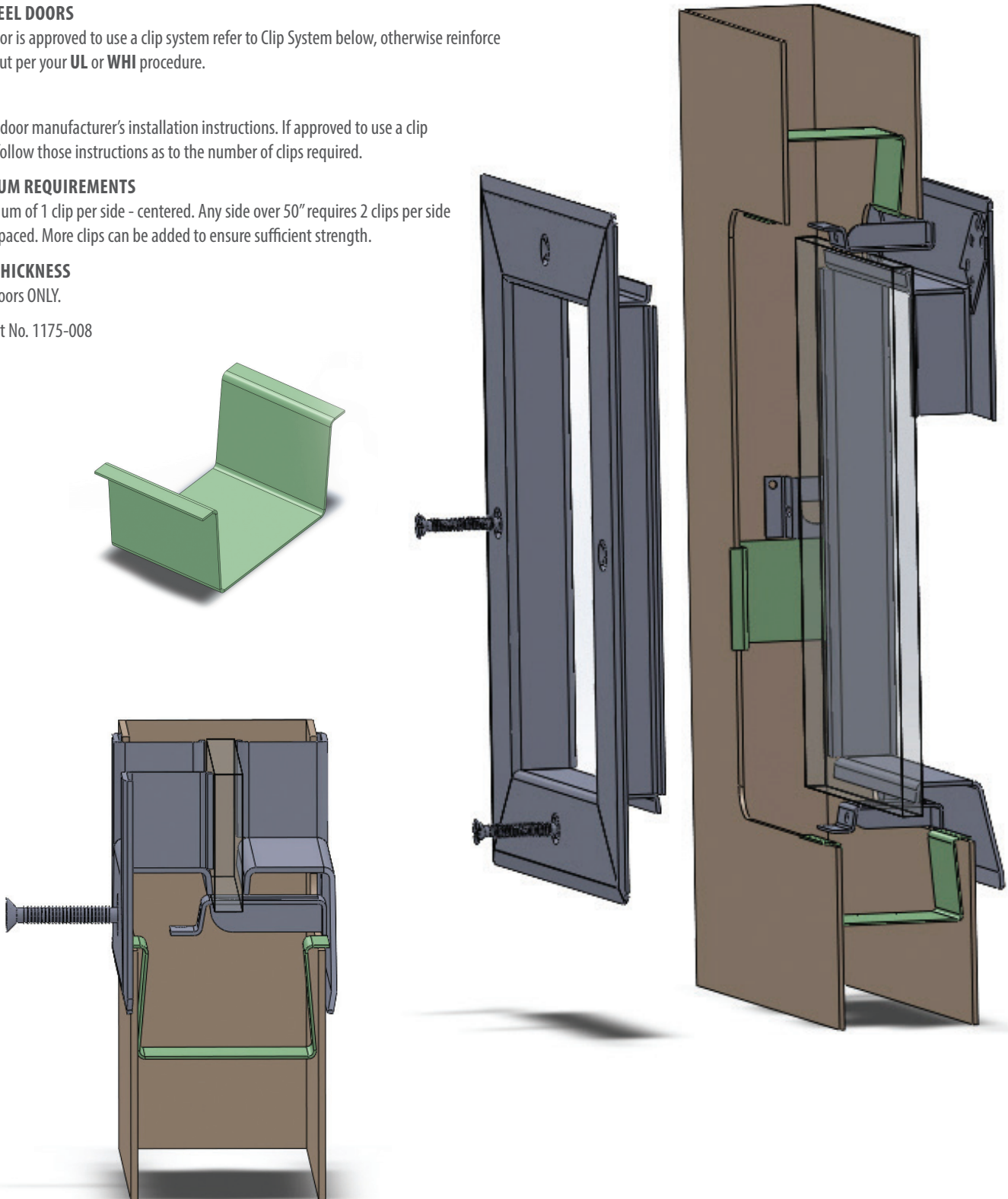
MINIMUM REQUIREMENTS

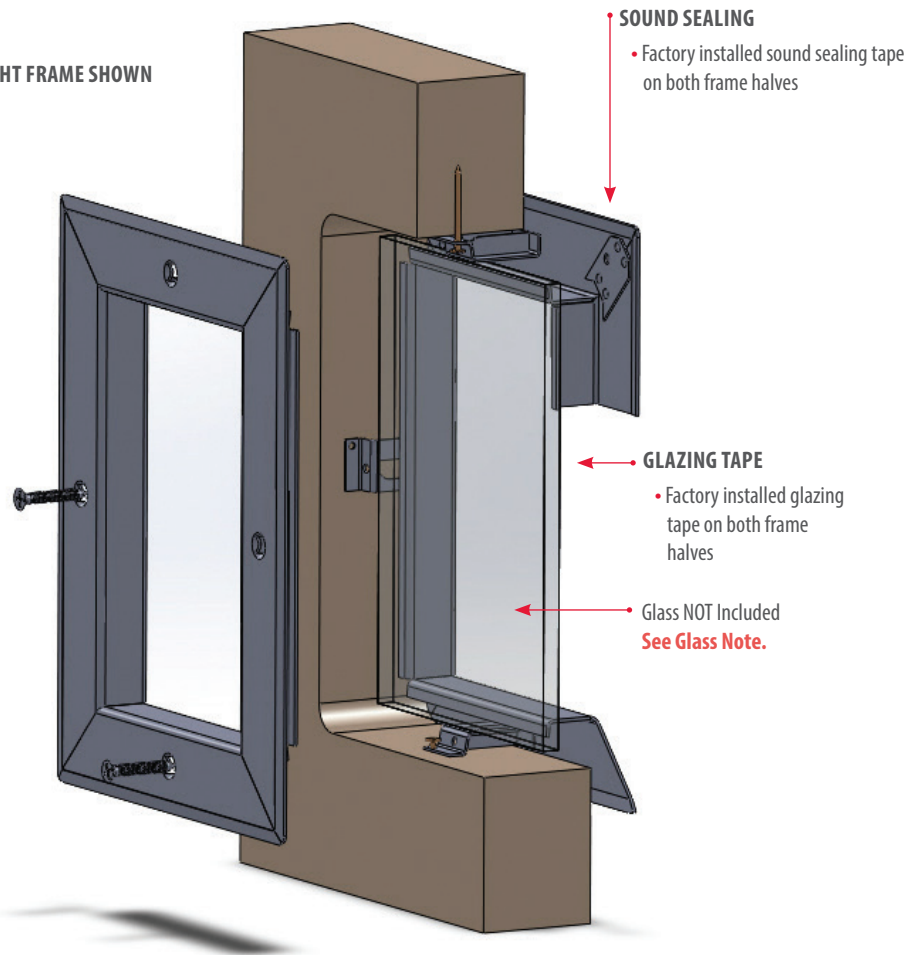A minimum of 1 clip per side - centered. Any side over 50" requires 2 clips per side evenly spaced. More clips can be added to ensure sufficient strength.

DOOR THICKNESS

1 3/4" Doors ONLY.

AMS Part No. 1175-008

MODEL 110 LOW PROFILE DOOR LIGHT FRAME SHOWN

SOUND SEALING
- Factory installed sound sealing tape on both frame halves

GLAZING TAPE
- Factory installed glazing tape on both frame halves

Glass NOT Included
See Glass Note.

Sound Sealing Option for Door Light Frames

Many door products are evaluated for their ability to reduce the transmission of sound from one side to the other. A Sound Transmission Class (STC) rating is a method to quantify this sound reduction. A higher rating offers more sound reduction.

For doors with glass, this rating is based on the ability of the entire assembly to reduce sound transmission. An assembly includes the door, light frame, glass, door frame and gasket system. Variables in this assembly include door type and thickness along with glass size and thickness. Assemblies are often required to be fire rated, as well.

All Metal Stamping offers a factory installed sound sealing option for many of its door light frames. If a frame is required in an STC rated door assembly, the sound sealing option can improve the overall performance of the assembly.

Independent lab testing has shown that for STC rating in the 30s, the AMS sound sealing option can improve the rating by 3 points. Testing performed using a light frame with a 22"x 34" visible light.

Please refer to our website or catalog pages to select AMS door light frame that is appropriate for you application.

SOUND TRANSMISSION TEST PERFORMED AT ELEMENT MATERIAL TECHNOLOGY, ST. PAUL, MN ACCORDING TO ASTM E90(09) & E413(10)

Labeling Policy

All Metal Stamping, Inc. labels frames which meet our UL Listings and Approvals. It is the End User's responsibility to ensure all components used in the openings meet or exceed the fire ratings required.

Use of glazing for which All Metal Stamping, Inc. does not have approval, 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. The International Building Codes (IBC) no longer allows non-safety rated glazing to be used in doors. It is the Purchasers responsibility to make sure the glass you are using is approved in the jurisdiction in which it will be installed.

Installation Notes:

1. Any unit used in an exterior application 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.
   All Metal Stamping, Inc. will only stand behind frames used in exterior applications:

   a. If the product is NOT directly exposed to sunlight, corrosive environments, or direct precipitation. The product can be manufactured from Galvanized material.

   b. If the product is exposed to sunlight, precipitation, or coastal environments the product must be manufactured from Stainless Steel.

   c. Our frames are NOT approved for corrosive environments.

2. Listed glasses that maintain a temperature rise of no more that 250^0 F above ambient are acceptable for Temperature Rise rated Fire Doors. Use of these glasses in sizes exceeding 100 in.[2] in 60 or 90 Minute Fire Rated Openings require prior approval of the Authority Having Jurisdiction (AHJ). Ensure glazing is approved before installing.

Non-Fire Rated Glazing Recommendations

We 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 + ¼" glass = 3/8" glass pocket.
Always evenly tighten screws around the perimeter of the frame to prevent glass breakage.

SEALED INSULATED GLASS: Insulated glass sometimes has a seal up to ½" wide.
Use our Style #118 or #118M to ensure this sealer is hidden from view upon installation.

Top Coating Instructions for Fire Door Hardware

STANDARD FINISH: Beige, Gray, or Dark Bronze polyester powder coating. 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.

Limted 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 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.

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For Styles other than the #110 or #110B

For all Styles Pocket Size must include glazing allowance
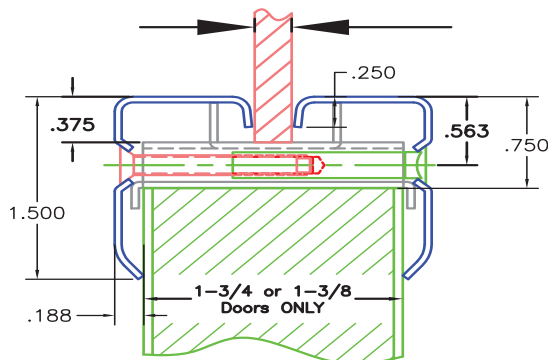
STYLE #115
ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

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

Glass size = Order size + $\frac{3}{4}$" (Tolerance +0/-$\frac{1}{16}$")
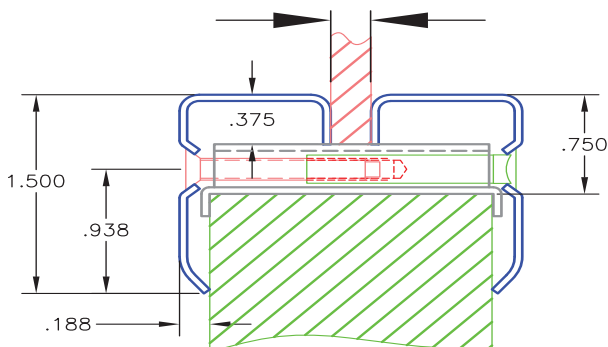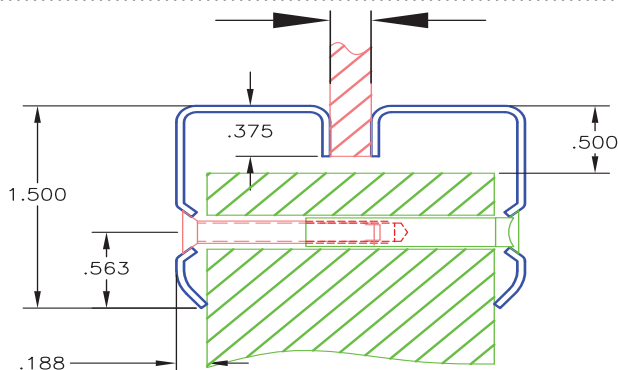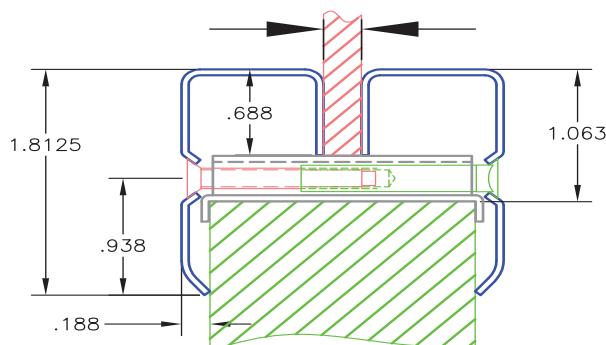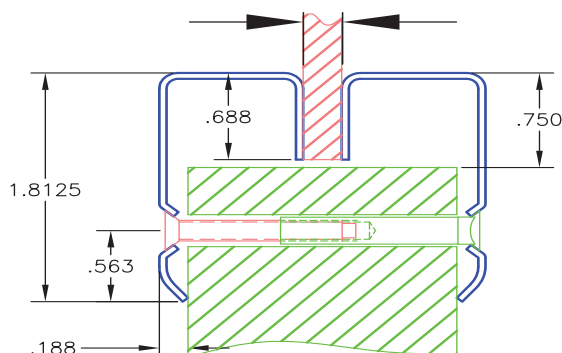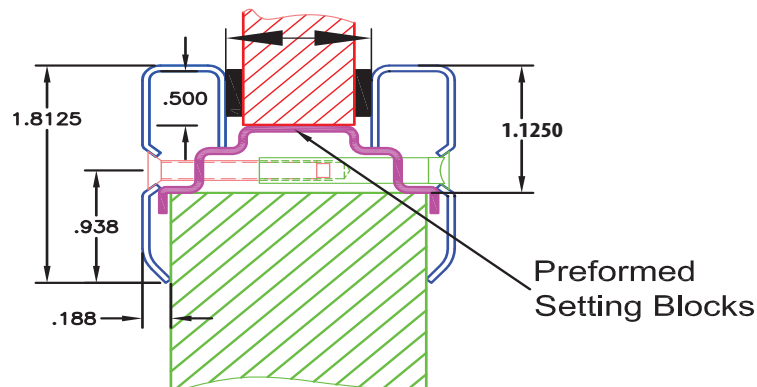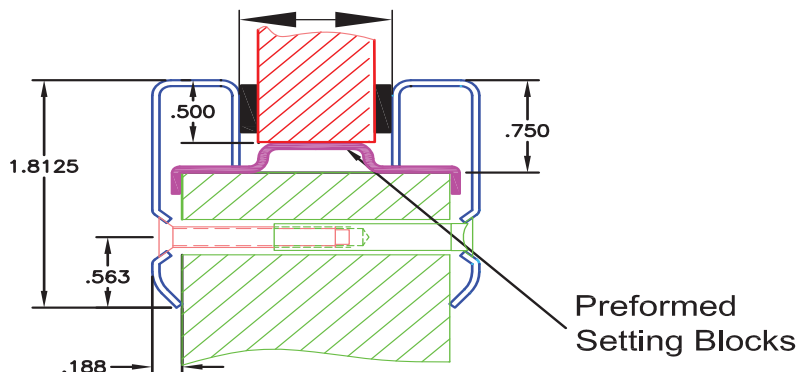
Frame includes 2 Frame & Glass Supports
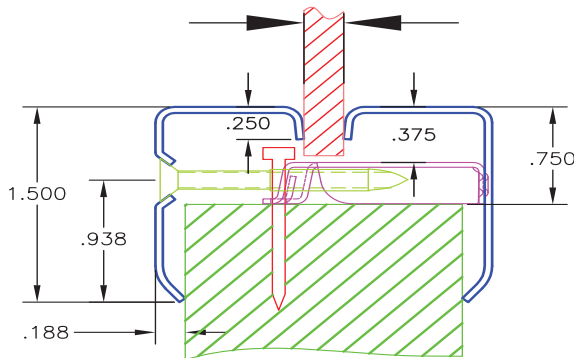
STYLE #117M
ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size +$1\frac{1}{2}$"
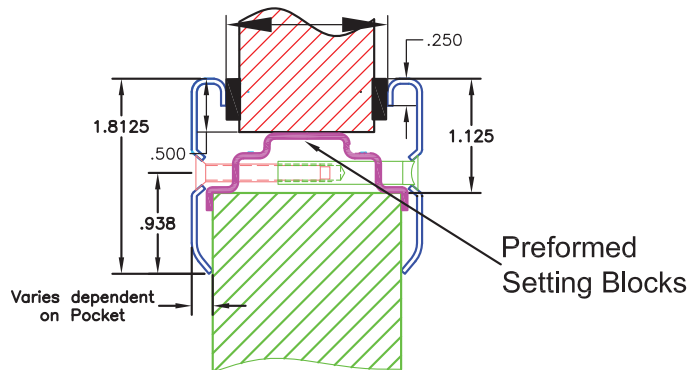
Glass size = Order size + $\frac{3}{4}$" (Tolerance +0/-$\frac{1}{16}$")

STYLE #105M
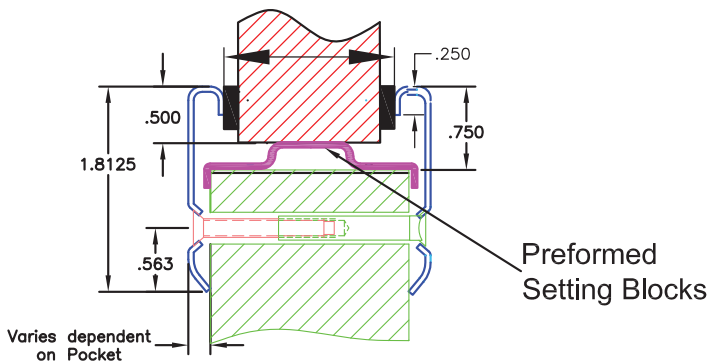**ORDER INFORMATION:**

Order size = Inside dimension of frame, (W+H)

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

Glass size = Order size + $\frac{3}{4}$" (Tolerance +0/-$\frac{1}{16}$")

Frame includes 2 Frame & Glass Supports

STYLE #105
ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + 1"

Glass size = Order size + $\frac{3}{4}$" (Tolerance +0/-$\frac{1}{16}$")

For all Styles Pocket Size must include glazing allowance

STYLE #118M

ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + $2^{1}/_{8}$"

Glass size = Order size + $1^{5}/_{16}$"

Frame includes 2 Frame & Glass Supports

STYLE #118

ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + $1^{1}/_{2}$"

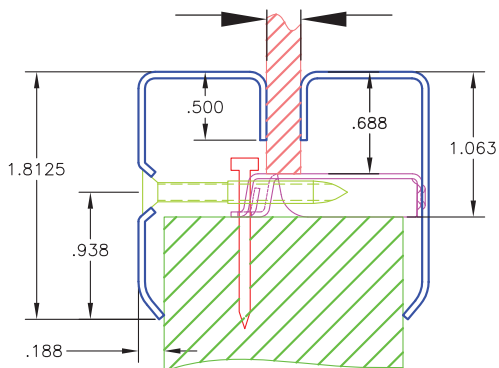Glass size = Order size + $1^{3}/_{8}$"

STYLE #118MN

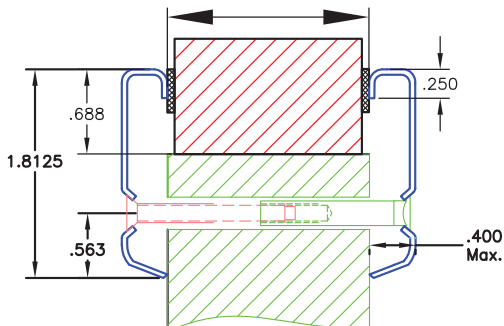**ORDER INFORMATION:**

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + $2^{1}/_{4}$"

Glass size = Order size + 1"

This Unit requires Setting Blocks for Proper Installation

Preformed Setting Blocks

STYLE #118N

ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + $1^{1}/_{2}$"

Glass size = Order size + 1"

This Unit requires Setting Blocks for Proper Installation

Preformed Setting Blocks

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For all Styles Pocket Size must include glazing allowance

STYLE #118MW

ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + $2\frac{1}{4}''$

Glass size = Order size + 1"

This Unit requires setting blocks for proper installation.

.250

1.8125

.500

.938

1.125

Varies dependent
on Pocket

Preformed
Setting Blocks

STYLE #118W

ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + $1\frac{1}{2}''$

Glass size = Order size + 1"

This Unit requires setting blocks for proper installation.

.250

.500

1.8125

.750

.563

Varies dependent
on Pocket

Preformed
Setting Blocks

STYLE #118MSP (PATENT PENDING)

ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + $2\frac{1}{8}''$

Glass size = Order size + $1\frac{5}{16}''$

NO FIRE RATING

.500

.688

1.063

1.8125

.938

.188

STYLE #118D

ORDER INFORMATION:

Order size = Inside dimension of frame, (W+H)

Cutout size = Order size + $1\frac{1}{2}''$

Glass size = Order size + $1\frac{3}{8}''$

NO FIRE RATING

.688

.250

1.8125

.563

.400
Max.

Option Available for Sheet Metal Screws

3/4" Painted Aluminum Tape On Mullions

1. DESCRIPTION

- ¾" 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, (see page 17).

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 but carry NO Fire Rating. Call for Quote.

3. LIMITATIONS FOR MULLIONS:

- All Styles ¼" maximum glass pocket for a 1-¾" Door. For a 2-¼" Door the maximum glass pocket is ¾" Minimum Door thickness is 1-¾".

5/8" Painted Steel Welded Mullions

1. DESCRIPTION

- Door Light Frame with wire welded mullions to give a divided light appearance.
- Mullions - 18 GA.- ⅝" 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 ¾" Tube SURROUND. Call for Quote.

3. LIMITATIONS FOR MULLIONS: Cross mullions have ¹⁄₁₆" offset to conceal tube edge radii, (see page 18).

- #110/#110B w/Cross Mullions: ¼" maximum glass pocket for a 1-¾" Door. For a 2-¼" Door the maximum glass pocket is ¾". Minimum Door thickness is 1-¾".
- #110/#110B w/One Way Mullions: ⅜" maximum glass pocket for a 1-¾" Door. For a 2-¼" Door the maximum glass pocket is ⅞".
- Welded mullions cannot be veneer wrapped.

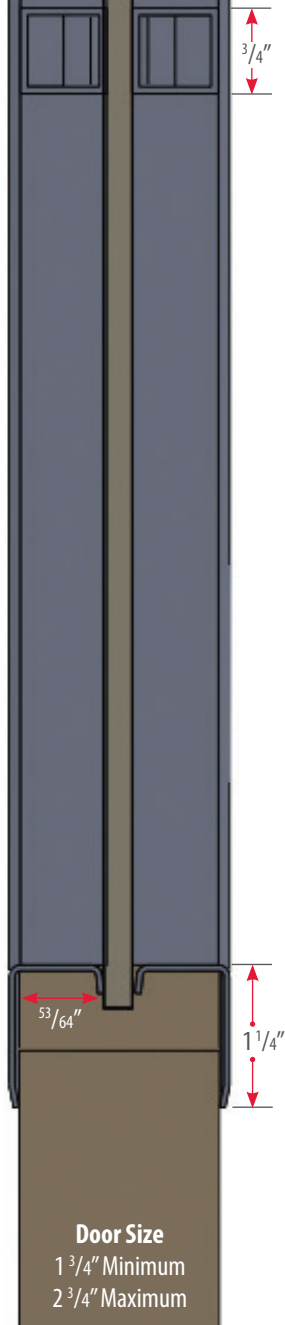# 1" to 3" Steel Formed Mullions

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, (see page 19).
- 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 1-¾" door is ¾" for styles 110/110B.
- Maximum glass pocket for other styles is 1" for 1-¾"door.
- Welded mullions cannot be veneer wrapped.

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 27) but carry **NO** Fire Rating. Steel mullions cannot be veneered.
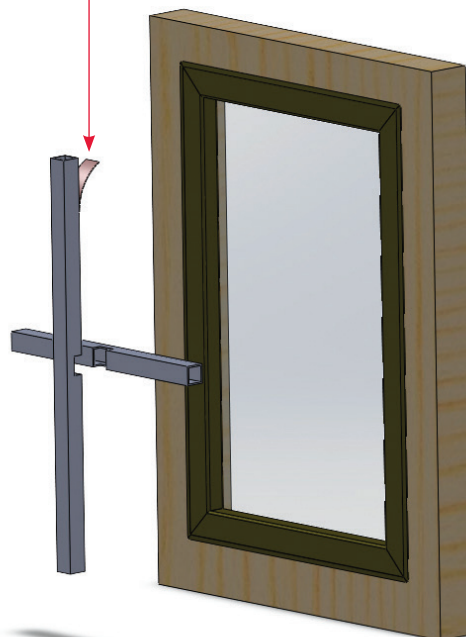
3/4" Painted Aluminum Tape on Mullions

CAUTION: Mullions cannot be adjusted after tape makes contact with glass

Mullions are attached to the glass with $^1/_2$" x $^1/_{32}$" double sided foam tape.

$^3/_4$"

ORDER INFORMATION:

Order size = Frame inside dimension

Door Cutout size = Order size + $1 ^1/_2$"

Glass size = Order size + $^3/_4$"

MATERIAL:

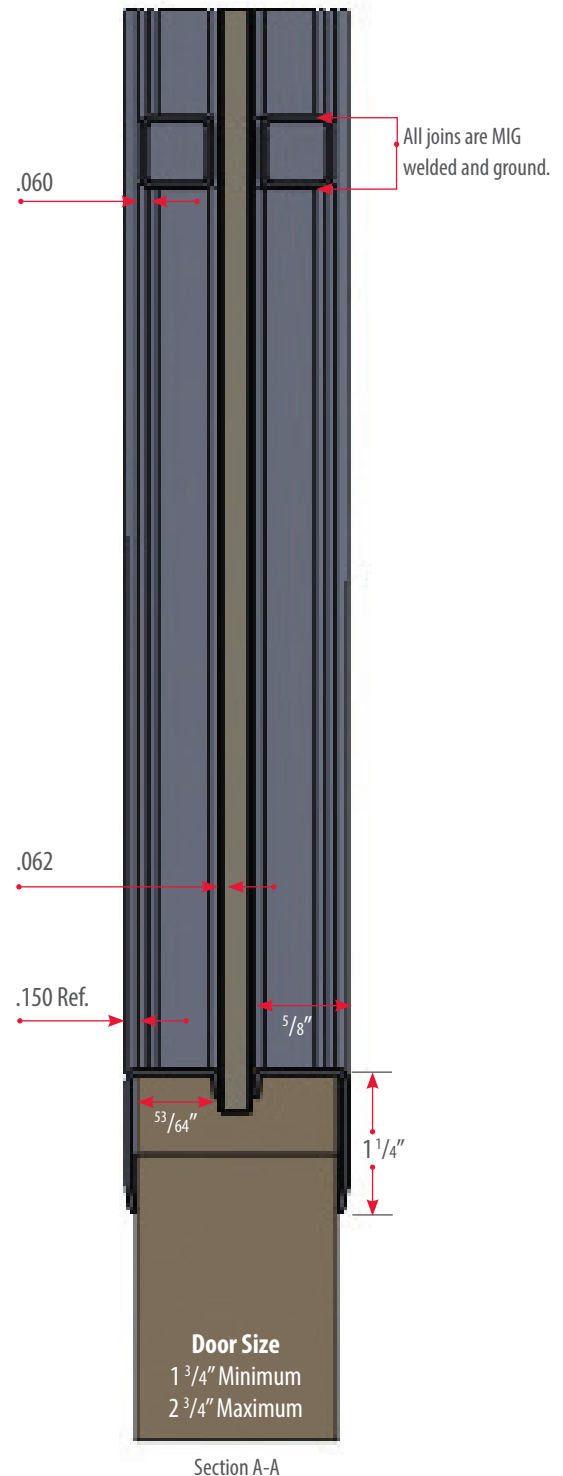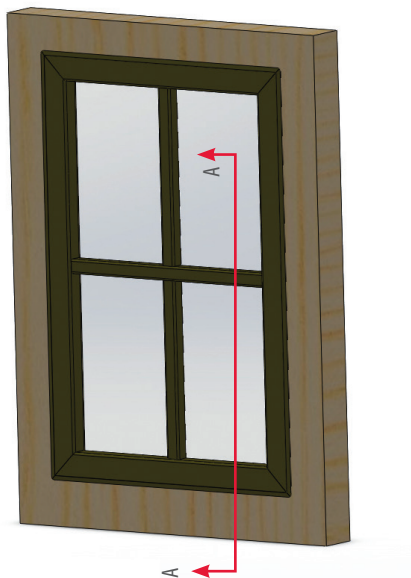Extruded Aluminum $^3/_4$" square

FOR 1 $^3/_4$" DOOR:

One-way mullion - glass maximum $^3/_8$"

Cross mullions - glass maximum $^1/_4$"
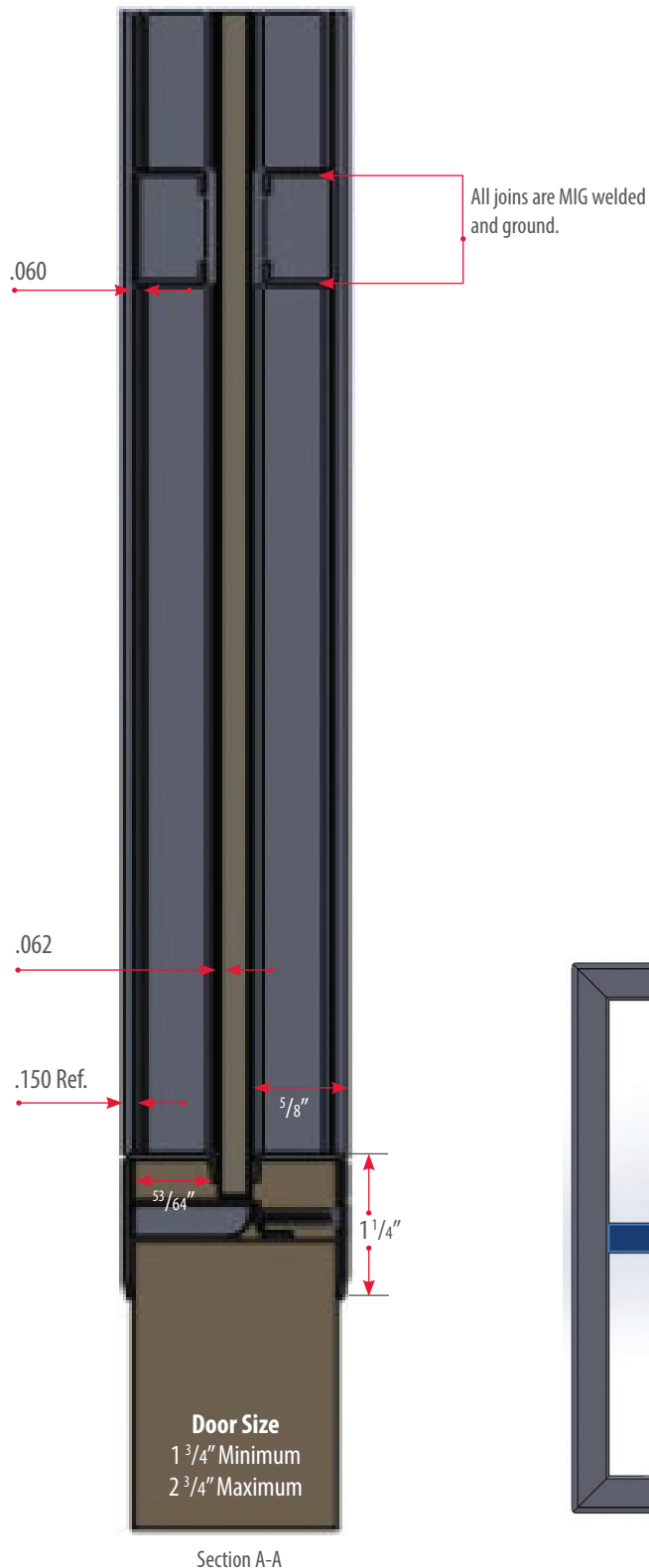
GLASS NOTE:

Glass must be single sheet of Listed Glazing Material to maintain fire rating.

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

$^{53}/_{64}$"

$1 ^1/_4$"

Door Size

1 $^3/_4$" Minimum

2 $^3/_4$" Maximum

Section A-A

A

A
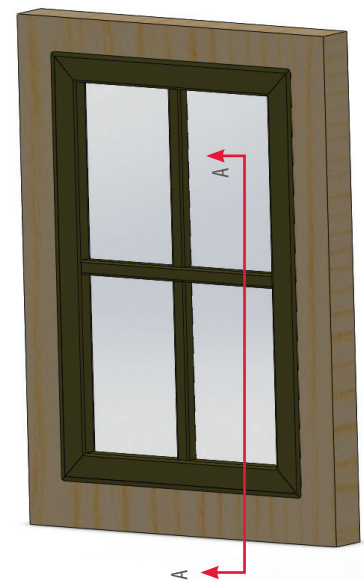
5/8" Painted Steel
Welded Mullions

ORDER INFORMATION:

Order size = Frame inside dimension

Door Cutout size = Order size + $1\frac{1}{2}''$

Glass size = Order size + $\frac{3}{4}''$

MATERIAL:

18 GA. (.045) x $\frac{5}{8}''$ square steel tubing.

FOR 1 $\frac{3}{4}''$ DOOR:

One-way mullion - glass maximum $\frac{3}{8}''$

Cross mullions - glass maximum $\frac{1}{4}''$

GLASS NOTE:

Glass must be single sheet of Listed Glazing Material to maintain fire rating.

.060

All joins are MIG welded and ground.

.062

.150 Ref.

$\frac{5}{8}''$

$\frac{53}{64}''$

$1\frac{1}{4}''$

Door Size
$1\frac{3}{4}''$ Minimum
$2\frac{3}{4}''$ Maximum

Section A-A

Frame Style #110 Shown

All joins are MIG welded and ground.

.060

.062

.150 Ref.

$^{53}/_{64}$"

$^5/_8$"

$1^1/_4$"

Door Size
1 $^3/_4$" Minimum
2 $^3/_4$" Maximum

Section A-A

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.
- MIG welded to frame from inside mullions to provide a clean appearance.
- Maximum glass pocket in 1-¾" door is ¾" for styles 110/110B. Consider 117M for thicker glass.
- Maximum glass pocket for other styles is 1" for 1-¾"door.
- Welded mullions cannot be veneer wrapped.
- Mullions are priced on a multiplier basis depending on size and complexity of the grid.
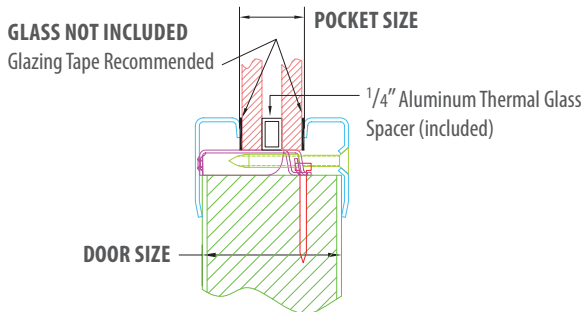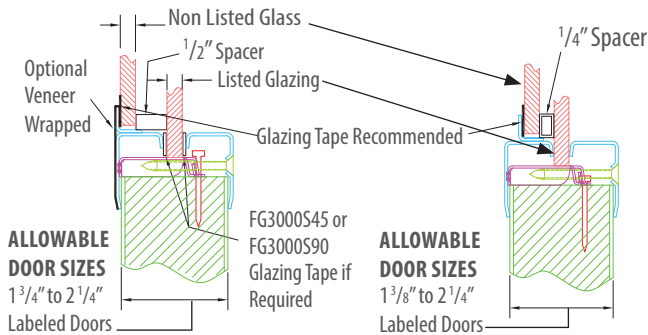- Please call 715-223-6324 for additional information or a Quote.

A
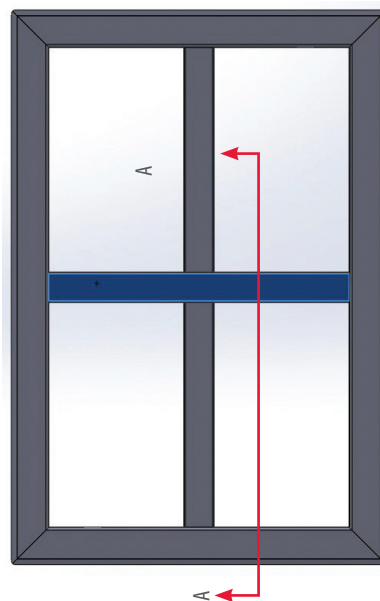
Double or Triple Glazed Frames

GLASS NOTE: See "Non-Fire Rated Glazing Recommendations" on page 11.

Pricing is available by Email or Fax

Cross Section Views

Non Listed Glass
1/2" Spacer
Listed Glazing
1/4" Spacer
Optional Veneer Wrapped
Glazing Tape Recommended

ALLOWABLE DOOR SIZES 1 3/4" to 2 1/4" Labeled Doors

FG3000S45 or FG3000S90 Glazing Tape if Required

ALLOWABLE DOOR SIZES 1 3/8" to 2 1/4" Labeled Doors

STYLE #110-D2 SHOWN (PATENT NO. 8,156,699 B2) Double Glazed
STYLE #110/#110B-T-D2 (PATENT NO. 8,156,699 B2) Triple Glazed
ORDER INFORMATION:

Order size = Visible Dimensions of Center Pane, (W+H)

Glass size = Center Pane Order size + 3/4" | Outer Pane(s) Order size - 1/4"

Cutout size = Order size + 1 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.

GLASS NOT INCLUDED Glazing Tape Recommended
POCKET SIZE
1/4" Aluminum Thermal Glass Spacer (included)
DOOR SIZE

STYLE #110-D1 DOUBLE GLAZED SHOWN (PATENT NO. 8,156,699 B2)
ORDER INFORMATION:
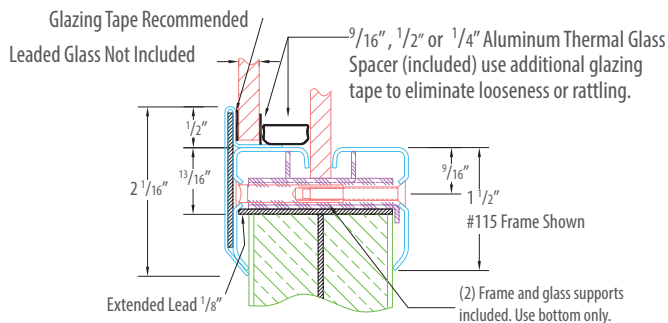
Order size = Visible Dimensions of Center Pane, (W+H)

Cutout size = Order size + 3/4"

Glass size = Order size + 1 1/2"

NO Fire Rating

Frames for Lead Lined Doors

GLASS NOTE: See "Non-Fire Rated Glazing Recommendations" on page 11.

Glazing Tape Recommended
Leaded Glass Not Included
9/16", 1/2" or 1/4" Aluminum Thermal Glass Spacer (included) use additional glazing tape to eliminate looseness or rattling.
1/2"
2 1/16"
13/16"
9/16"
1 1/2"
#115 Frame Shown
Extended Lead 1/8"
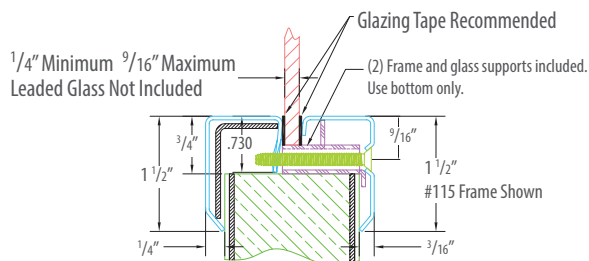**(2) Frame and glass supports included. Use bottom only.**

STYLE #115-L1 for doors leaded under the skins or down the center (PATENT NO. 4,550,542)
ORDER INFORMATION:

Order size = Visible Dimensions of Center Pane, (W+H)

MINIMUM WIDTH = 2 1/2"
MAXIMUM WIDTH OR HEIGHT = 33"

Glass size = Center Pane Order size + 3/4" | Outer Pane(s) Order size - 3/16"

Cutout size = Order size + 1 5/8"

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

Glazing Tape Recommended
1/4" Minimum 9/16" Maximum Leaded Glass Not Included
(2) Frame and glass supports included. Use bottom only.
3/4"
.730
9/16"
1 1/2"
1 1/2"
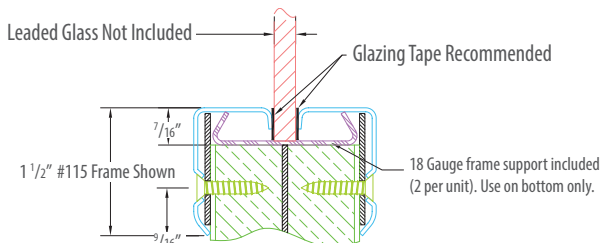1/4"
3/16"
#115 Frame Shown

STYLE #115-L2 or #105M-L2 for doors leaded under the skins (PATENT NO. 4,550,542)
ORDER INFORMATION:

Order size = Visible Dimensions of Center Pane, (W+H)

Cutout size = Order size + 1 5/8"

Glass size = Order size + 3/4"

NO Fire Rating

Leaded Glass Not Included
Glazing Tape Recommended
7/16"
1 1/2" **#115 Frame Shown**
3/16"
18 Gauge frame support included (2 per unit). Use on bottom only.

STYLE #115-L3 for doors leaded down the center (PATENT NO. 4,550,542)
ORDER INFORMATION:

Order size = Visible Dimensions of Center Pane, (W+H)

Cutout size = Order size + 7/8"

Glass size = Order size + 3/4"

NO Fire Rating

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Stock Size Frames ship the next business day with NO up charge.
Subject to management approval.

Standard and "Quick Ship" Services

Please specify shipdate on each order.

Orders are accepted for Quick Ship Service based on our Production Schedule and regular business hours listed on page 28. This is **NOT** a guaranteed service.

DOOR LIGHT FRAMES - STYLE #110

#110/#110B Style Frames manufactured for 1-3/4" Doors with ¼" glass pocket. Beige, Gray, or Dark Bronze polyester powder coating.

STANDARD SERVICE: Your order will ship 7-10 business days after the date your order is received with NO up charges. Veneer product is available on 7-10 day service subject to our Production Schedule and availability of the veneer. See our website www.AllMetalStamping.com for Veneer Species available. Call for Quote.

5 DAY SERVICE: Orders received before 1 P.M. CST/CDT will ship 5 business days following that date with a 5% Up Charge per Standard Item. Orders can include fractional and sizes from 3" to 72".

3 DAY SERVICE: Orders received before 1 P.M. CST/CDT will ship 3 business days following that date with a 10% Up Charge per Standard Item. Orders can include fractional and sizes from 3" to 60".

Special Service for All Frame Styles manufactured for Odd Thickness applications is available at an additional charge dependent on our Production Schedule. If your order is accepted for 5 DAY QUICK SHIP SERVICE there will be a 15% Up Charge per Item. If your order is accepted for 3 DAY QUICK SHIP SERVICE there will be a 20% Up Charge per item.

EDGE & ASTRAGAL SETS

Items are manufactured for 1-3/4" & 1-13/16" doors with standard leg dimensions and standard material requirements. Machining is as shown on AMS templates.

STANDARD SERVICE: Your order will ship 7-10 business days after the date your order is received with NO up charges. Veneer product is available on 7-10 day service subject to our Production Schedule and availability of the veneer. See our website www.AllMetalStamping.com for for Veneer Species available. Call for Quote.

5 DAY SERVICE: Orders received before 1 P.M. CST/CDT will ship 5 business days following that date with a 5% Up Charge per Item. Machined and Non-Machined – includes Channels and Sets shown on Page 23 & 24. Any length to 120".

3 DAY SERVICE: Orders received before 1 P.M. CST/CDT will ship 3 business days following that date with a 15% Up Charge for Machined items and 10% Up Charge for Non-Machined items. Includes Channels and Sets shown on Page 23 & 24. Any length to 120".

Special Service is available for special machining, non-standard dimensions and for "T", "Z", and Flat Astragals; and includes "L" channels and Hinge Edge & Lock Edge Protectors. Availability of Special Service is dependent on our Production Schedule. If your order is accepted for 5 DAY QUICK SHIP SERVICE there will be a 15% Up Charge per Item. If your order is accepted for 3 DAY QUICK SHIP SERVICE there will be a 20% Up Charge per Item.

Channels with Electric Strikes will require 12 business days to manufacture and are not available for Quick Ship Service.

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

Stock Service Must be Requested. If Accepted, Orders Ship the Next Business Day at NO Up Charge.

Orders are accepted for Quick Ship Service based on our Production Schedule and regular business hours listed on page 28. This is **NOT** a guaranteed service.

ORDER SIZE Width X Height	EXPOSED GLASS Sq. Inches	CUTOUT SIZE Width X Height
3 X 33	99	4-1/2 X 34-1/2
4 X 24	96	5-1/2 X 25-1/2
4 X 25	100	5-1/2 X 26-1/2
5 X 20	100	6-1/2 X 21-1/2
6 X 30	180	7-1/2 X 31-1/2
10 X 10	100	11-1/2 X 11-1/2
22 X 28	616	23-1/2 X 29-1/2
22 X 30	660	23-1/2 X 31-1/2
24 X 30	720	25-1/2 X 31-1/2

PROVISIONS

1. All Stock Orders are pending approval of the General Manager based upon current orders in process.

2. Stock Orders received before 1 P.M. CST/CDT will ship the next business day at NO up charge if all other conditions are met.

3. Stock Orders are limited to 50 Units, orders over 50 Units will require additional manufacturing time.

4. Please DO NOT MIX stock items and longer delivery items on the same order. You must request Stock Service or we will assume your order can be processed under our Regular Service.

5. Stock Door Light Frames are manufactured for 1-3/4" Doors with ¼" Glazing Pocket and are painted with Beige polyester powder coating ONLY.

Stock Orders no longer need to be ordered in Box Quantity. You can order 1 to 50 Units per Order. If you have a larger order please contact us and we will provide you with a Ship Date.

Pricing is the same as shown on Price Table in the Price Guide. Please request a Price Guide which we can provide to you by email.

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Edge and Astragal sets are Listed to 90 Minute UL.

Double Edge sets are Listed to 90 Minute UL.

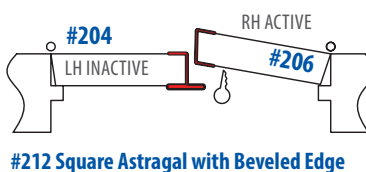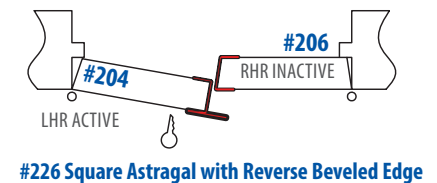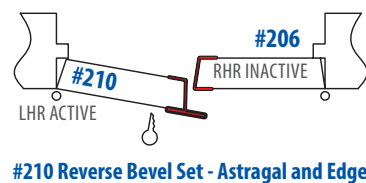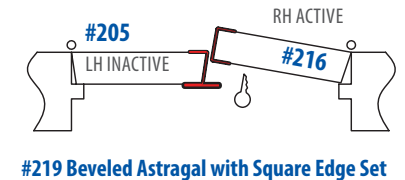**Listed under both Neutral and Positive Pressure Standards.**
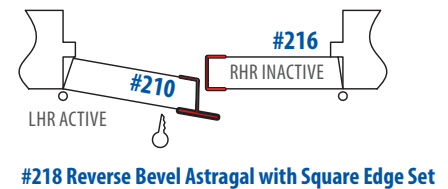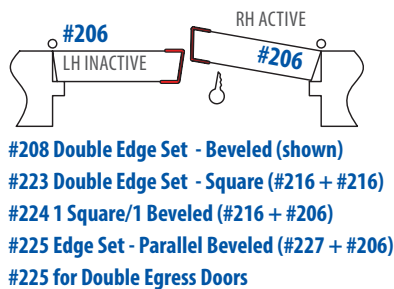
UL Listed in Steel and Stainless Steel.

Ul Listed with Veneer Wrapping - Neutral and Positive Pressure.

Astragal

Edge

#205
LH INACTIVE
RH ACTIVE
#206

#207 Standard Bevel Set - Astragal and Edge

#204
LH INACTIVE
RH ACTIVE
#216

#217 Square Astragal and Square Edge Set

#206
LH INACTIVE
RH ACTIVE
#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

#216
RHR INACTIVE
#210
LHR ACTIVE

#218 Reverse Bevel Astragal with Square Edge Set

#210
LH INACTIVE
RH ACTIVE
#206

#209 Parallel Bevel Set - Astragal and Edge for Double Egress Doors

#205
LH INACTIVE
RH ACTIVE
#216

#219 Beveled Astragal with Square Edge Set

#210
LHR ACTIVE
#206
RHR INACTIVE

#210 Reverse Bevel Set - Astragal and Edge

#204
LHR ACTIVE
#206
RHR INACTIVE

#226 Square Astragal with Reverse Beveled Edge

#204
LH INACTIVE
RH ACTIVE
#206

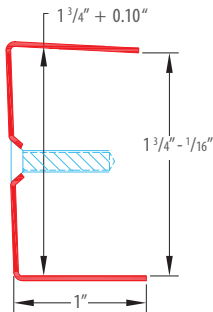**#212 Square Astragal with Beveled Edge**

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, Gray or Dark Bronze Powder Paint
- All Bevels are $^1/_8$" in 2"
- Punched and coined for #8 x $^3/_4$ Phillips Flat Head Screws (included)
- Hole Centers 12" or less, 3 1/2" Maximum from Ends and Machined Openings
- AMS Machining Templates must be competed for each Machined Item (forms available on website)
- All Items Available in Stainless Steel
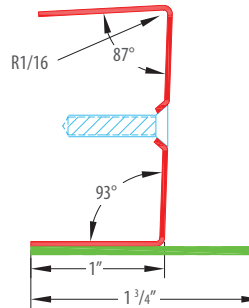- Veneer Wrapping Available
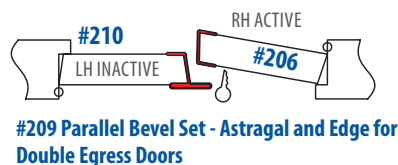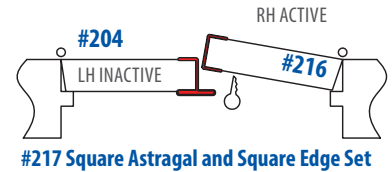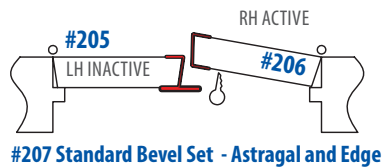
Standard Edges are 20 GA. (.035) CRS   Astragal Flanges are 16 GA. (.062) CRS

1 3/4" + 0.10"
1 3/4" - 1/16"
1"

R1/16
87°
93°
1"
1 3/4"

All Edges 20 GA. (0.035)
93°
87°
All Astragals 16 GA. (0.062)

#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
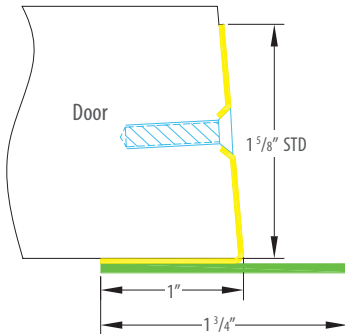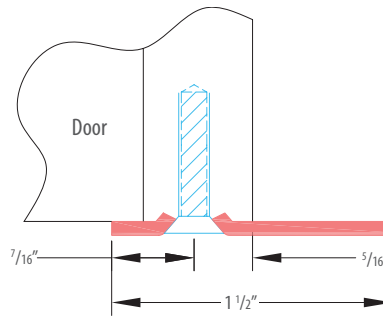#233 "L" Shaped Lock Edge Protector - Square

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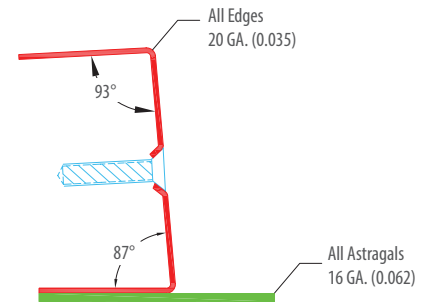
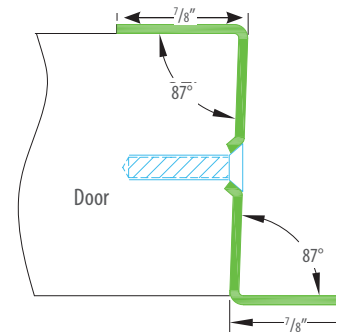#210 Reverse Beveled Astragal
#204 Square Astragal (No Bevel)

"T" (18 Ga.), "Z" (16 Ga.) and Flat Astragals (14 Ga.)

Door
1 5/8" STD
1"
1 3/4"

Door
7/16"
5/16"
1 1/2"

7/8"
87°
Door
87°
7/8"

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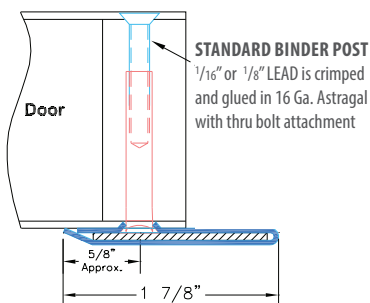#213 "T" Astragal - Beveled
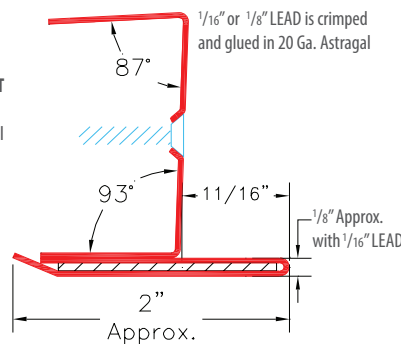#214 "T" Astragal - Square

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

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

Lead Lined Astragals

Door
STANDARD BINDER POST
1/16" or 1/8" LEAD is crimped and glued in 16 Ga. Astragal with thru bolt attachment
5/8" Approx.
1 7/8"

1/16" or 1/8" LEAD is crimped and glued in 20 Ga. Astragal
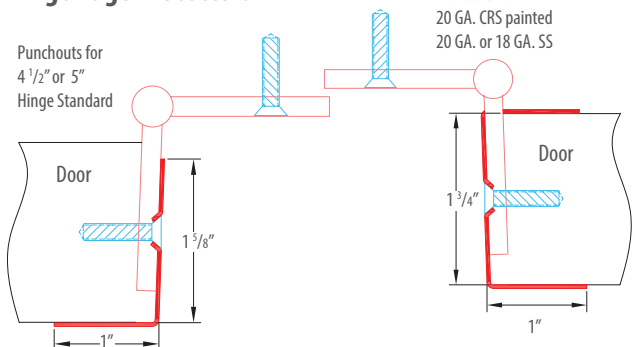87°
93°
11/16"
1/8" Approx. with 1/16" LEAD
2" Approx.

18 GA. (.048) CRS Edge Standard
#236 Lead Lined Flat Astragal
(no fire ratings)
UL Listed for Steel Doors ONLY

#205L Lead Lined Astragal Standard Bevel (shown)
#204L Lead Lined Astragal Square (no bevel)
#210L Lead Lined Astragal Reverse Bevel
UL Listed to 90 minutes

Hinge Edge Protectors

Punchouts for 4 1/2" or 5" Hinge Standard
Door
1 5/8"
1"

Available in: 20 GA. CRS painted 20 GA. or 18 GA. SS
Door
1 3/4"
1"

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

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

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C UL US LISTED

Astragal & Edges on pages 23 & 24, are approved for use on Wood or Plastic faced doors rated up to 90 Minutes and Hollow Metal, Steel covered composite doors rated up to 3 hours.

Exception: Style #236 Lead Lined Flat Astragals for use on Steel Doors up to 3 hours.

Material: 20, 18, or 16 GA. Steel, Galvanized Steel, or Stainless Steel.
Exceptions: 1. Style #215 Flat Astragal 14 GA. Standard.
                  2. Style #236 Lead Lined Flat Astragal 18 GA. ONLY.
                  3. Styles #237, #238, and #239 "Z" Astragals 16 GA. Standard.
                  4. Styles #213, #214, and #229 "T" Astragals 18 GA. Standard.

Astragal Overlap Lengths: ½" to 3½" Maximum.

Leg Lengths: Can vary between ½" to 3½".
Exceptions: Styles 231, 232, 233, 235, 213, 214, 229, 237, 238, 239 - ½" to 2" Maximum.

Door Thicknesses: $1\,^{3}/_{8}$" to $2\,^{1}/_{4}$" thick doors up to 120" in length.

Lead Lined: Lead thickness can vary from 1/16" to 3/8".

Veneer wrapped: All Styles approved to be veneer wrapped up to 90 Minute Neutral and Positive Pressure.

Concealed Vertical Rod
5" Metal Channels

For Wood Doors

AMS PART NO.	DEVICE MANUFACTURER	SERIES
251	Von Duprin Series	9847/9947
251A	Von Duprin CVC Series	9849/9949
251B	Von Duprin CVC Series	9850/9950
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	7100
258	Monarch/Falcon Device	(F) 17-24-18-25-XX-C
260	Arrow Device	F3600
261	Corbin Russwin Device	5800
262	Precision Device	FL 1700/1700
263	Sargent Device	PP8600 & PR8600
264	DORMA Device	9100
264A	DORMA Device	9600
265	Precision Device	FL 2700/2700
266	DORMA Device	5100
267	Von Duprin Series	3347A/3547A
267A	Von Duprin CVC Series	3350A/3550A
268	Sargent Vertical Lock Devices	WD 7000
269	Monarch/Falcon Centerslide Devices	(F) 17-24-18-25-XX-C
270	Stanley Series (Black & Decker)	QED 100
271	Hager CVR Series	4500
272	Detex CVR Series	7000
273	Cal-Royal Series	W77CVR/W98CVR
274	Lawrence Series	LH8850/8650
275	Schlage Series	LM9200
276	PDQ Series	6200CV(F)
277.5	Corbin Russwin Series	FE6800 MPL

A completed AMS Template must accompany your order.

Templates are available on our website **www.AllMetalStamping.com**

20 GA. (.035)

20 GA. GALVANIZED CHANNEL (.035)
Adds an additional ¹/₃₂" to the Edge of your door.

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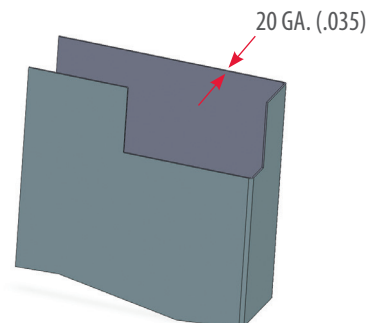
UL Listed with the same parameters as our standard products.

Door Light Frames

See page 3-4, 13-15 & 20.

Astragal and Edge Sets

See page 23 & 24.

5" Channels

See page 26.

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. Subject to availability of veneer.

**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, and polyesters have all been used successfully.

TYPICAL INSTALLATION

DISCLAIMER:
Wood veneer owes its inherent beauty to variations in grain, color, texture and pattern occurring as a result of nature. Veneers from different regions of the country or world can have different variations IN grain, color, texture and pattern. All Metal Stamping, Inc., does not guarantee the grain, color, texture or pattern of any veneer products sold. Please contact us if you require a close match to your doors. A sample veneer will be required so we can compare to our stock, or send onto our supplier.

PLEASE NOTE: This will add considerable time to our ability to deliver product and may affect price if a special order is required.

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ams@allmetalstamping.com
www.AllMetalStamping.com
27 Page
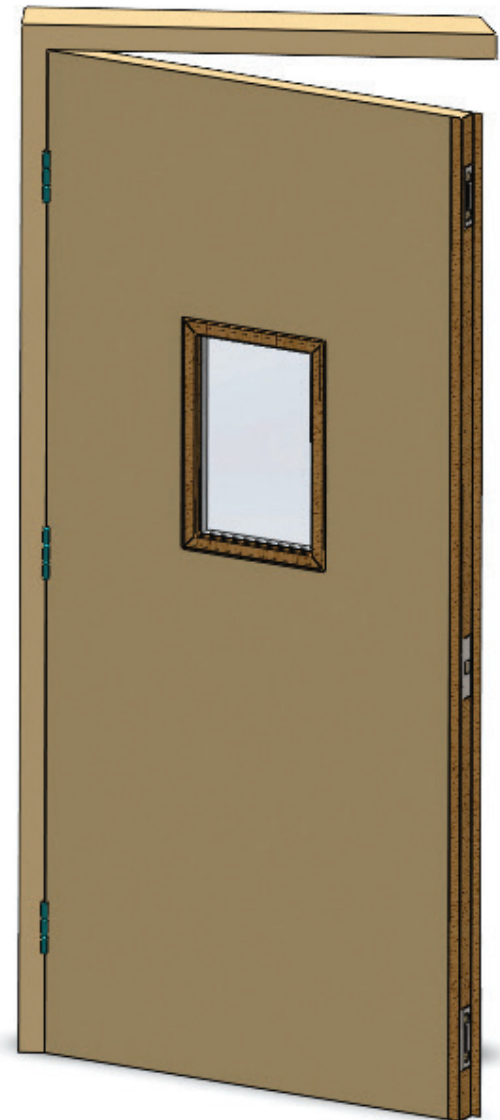
PRICES

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 1.5% 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 all Orders. Orders can be placed 24/7.

BUSINESS HOURS

Normal Production Hours are Monday through Thursday, 7:00 AM to 3:30 PM excluding Holidays or periods when we are shutdown. We normally do not have production or shipping on Fridays. The Office is open Monday through Friday, 7:00 AM to 4:30 PM. Quick Ship and Standard Lead times are based on our Production Hours.

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. The costs of special packaging such as Crates, or boxes reinforced with OSB Board, regular skids and custom built skids will be added to the Shipping charges on all Invoices.

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 that have been entered into the system will receive a $10.00 Order Change Charge; changes to orders in process but before production has begun will receive a $20.00 Order Change Charge.

RETURNED MERCHANDISE

No merchandise may be returned without prior permission. Machined Astragal & Edges, 5" Metal Channels, and Door Light Frames other than standard units cannot be returned. 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 the ever changing market for Stainless Steel we have added a Stainless Steel Surcharge, which took effect 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.

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