Fire Door Hardware

- Astragal/Edge Sets and Door Edge Protectors.
- Available with custom mullion bars.
- #110 Frame Exclusive: One Man installation saves time and money.
  - 18GA. Steel Frames are 33% more rigid than 20GA.
- Door Light Frames (Stock Program Available)
- Metal Door Edges & Astragals (Machined to your Specifications)
- 5” Channels (For Concealed Vertical Rod Devices)
- All Available in Steel or Stainless Steel
- Quick Ship and Expedited Services Available
- Veneers and Special Colors Available

411 West Spruce Street
PO Box 485
Abbotsford, WI 54405-0485

715.223.6324 phone
715.223.3352 fax

www.AllMetalStamping.com

For Most Current Info: Consult Customer Service or Check our Website

Rev. 030714
This catalog can be downloaded from our website at: www.AllMetalStamping.com. The Pricing Guide can be obtained by email, fax, or mail by contacting us at 715-223-6324. We will send the Pricing Guide to you as soon as possible.

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**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 31-32.

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 and 1/4" Glass and some other applications

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.

STANDARD FINISHES:
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.
- 18 GA. Stainless Steel.
- Custom colors.
- Wood veneer wrapped in various species to match door.
- Maximum Glass pocket is 5/8" less than door thickness
- Available for a variety of glass or door thicknesses (for an upcharge)

MOUNTING HOLES:
- Less than 12", one hole centered.
- 12" or more, three inches maximum from corners when ordering whole sizes.
- 11 5/16" maximum centers.

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.

NO SHARP CORNERS
- 5/32" Radius

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.

WELDER 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
Laminated Glass
NOT recommended
See Glass Note.

Model 110 Low Profile Fire Door Light Frame
For standard 1 3/4" Door and 1/4" Glass and some other applications

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.

STANDARD FINISHES:
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.
- 18 GA. Stainless Steel.
- Custom colors.
- Wood veneer wrapped in various species to match door.
- Maximum Glass pocket is 5/8" less than door thickness
- Available for a variety of glass or door thicknesses (for an upcharge)

MOUNTING HOLES:
- Less than 12", one hole centered.
- 12" or more, three inches maximum from corners when ordering whole sizes.
- 11 5/16" maximum centers.

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.
Model 110B Low Profile
Fire Door Light Frame

For non-standard applications

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.

STANDARD FINISHES:
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.
• 18 GA. Stainless Steel.
• Custom colors.
• Wood veneer wrapped in various species to match door.
• Available for a variety of glass and door thicknesses.
• Maximum Glass pocket is 3/8" less than door thickness.

MOUNTING HOLES:
• Less than 12", one hole centered.
• 12" or more, three inches maximum from corners when ordering whole sizes.
11 3/16" maximum centers.

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.

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
• 3/8" Radius

Glass NOT Included
Laminated Glass NOT recommended
See Glass Note.
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 1/2”
Glass size = Order size + 3/4”

MATERIAL:
18 GA. CRS frame is standard.
• 33% thicker than 20 GA. frames.

STANDARD FINISHES:
Beige, gray or dark bronze polyester powder coating.
• Extremely durable
• Visually appealing

OPTIONS:
• 18 GA. Galvanized.
• 18 GA. Stainless Steel.
• Custom colors.
• Wood veneer wrapped in various species to match door.

MOUNTING HOLES:
• Less than 12”, one hole centered.
• 12” or more, three inches maximum from corners when ordering whole sizes.
11 5/16 ” maximum centers.

GLASS NOTE: For non-fire rated applications we recommend 3/4” tempered glass. If laminated glass is used, glazing tape and light torque on the screws is required to prevent glass breakage.
The UL listings below apply to the following glass types:

- WireLite NT, 7/16” Pyroshield Plus, SuperLite I-W or Protect3 Safety Glass
- 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 in doors that is not safety rated. 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 1/4” Wired Glass, WireLite, 7/16” FireLite, Keralite FR-R, or Pyran S contact us to discuss your options.

### Underwriters Laboratories Listings

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

| GLASS TYPES: 7/16” Pyroshield; Firelite NT; Firelite Plus; Keralite FR-F; Keralite FR-L; Pyran F; and Pyran L |
|---|---|---|---|---|---|

#### GLASS TYPES: 7/16” Pyroshield; Firelite NT; Firelite Plus; Keralite FR-F; Keralite FR-L; Pyran F; and Pyran L

**Temperature Rise Doors**

<table>
<thead>
<tr>
<th>STYLES</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (minutes)</th>
<th>Maximum Exposed Area in Square Inches</th>
<th>Maximum Width of Exposed Area</th>
<th>Maximum Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Glasses Listed Above</td>
<td>20-45</td>
<td>1296</td>
<td>54”</td>
<td>54”</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Glasses Listed Above</td>
<td>20-45</td>
<td>2856</td>
<td>34”</td>
<td>84”</td>
<td>FG3000S45²</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Glasses Listed Above Non-Temperature Rise Doors</td>
<td>60-90</td>
<td>100</td>
<td>12”</td>
<td>33”</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B</td>
<td>Glasses Listed Above Non-Temperature Rise Doors</td>
<td>60-90</td>
<td>300</td>
<td>15”</td>
<td>33”</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Glasses Listed Above Non-Temperature Rise Doors</td>
<td>60</td>
<td>Max: 1920 Single Lite: 960</td>
<td>12”</td>
<td>80”</td>
<td>FG3000S90²</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Using Firelite, Keralite, or Pyran Non-Temperature Rise Doors</td>
<td>60-90</td>
<td>1296</td>
<td>54”</td>
<td>54”</td>
<td>FG3000S90²</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Glasses Listed Above Non-Temperature Rise Doors</td>
<td>90</td>
<td>Max: 2208 Single Lite: 552</td>
<td>12”</td>
<td>46”</td>
<td>FG3000S90²</td>
</tr>
</tbody>
</table>

**Non-Temperature Rise Doors**

| 118, 118M | Using FireLite NT or FireLite Plus | 180 | 100 | 12” | 33” | None |
The UL listings below apply to the following glass types:
WireLite NT, SuperLite I-W, or Protect 3

### Underwriters Laboratories Listings

#### GLASS TYPES: WireLite NT; SuperLite I-W; or Protect 3

**Unless specified below Door Types are: Wood Core, Wood with Mineral Core, or Steel Doors with Honeycomb, Mineral Core, or Steel Stiffened Cores**

<table>
<thead>
<tr>
<th>GLASS TYPES: WireLite NT, SuperLite I-W, or Protect 3</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (Minutes)</th>
<th>Maximum Exposed Area Square Inches</th>
<th>Maximum Width Of Exposed Area</th>
<th>Maximum Height Of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>WireLite NT, SuperLite I-W Steel Doors ONLY</td>
<td>20</td>
<td>3289</td>
<td>35 1/4&quot;</td>
<td>92&quot;</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>SuperLite I-W</td>
<td>20-60</td>
<td>1296</td>
<td>54&quot;</td>
<td>54&quot;</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Protect 3</td>
<td>20-45</td>
<td>1296</td>
<td>54&quot;</td>
<td>54&quot;</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>WireLite NT Steel Doors ONLY</td>
<td>20-60</td>
<td>1296</td>
<td>54&quot;</td>
<td>54&quot;</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>WireLite NT, SuperLite I-W or Protect 3 Wood Doors ONLY</td>
<td>45</td>
<td>2856</td>
<td>34&quot;</td>
<td>84&quot;</td>
<td>FG300054S</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>WireLite NT, SuperLite I-W or Protect 3 Wood Doors ONLY</td>
<td>60</td>
<td>960</td>
<td>12&quot;</td>
<td>80&quot;</td>
<td>FG300059S</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Steel or Wood Doors WireLite NT Steel Doors ONLY SuperLite I-W, Protect 3</td>
<td>90</td>
<td>552</td>
<td>12&quot;</td>
<td>46&quot;</td>
<td>FG300059S</td>
</tr>
</tbody>
</table>

#### Temperature Rise Doors

<table>
<thead>
<tr>
<th>GLASS TYPES: WireLite NT; SuperLite I-W; or Protect 3</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (Minutes)</th>
<th>Maximum Exposed Area Square Inches</th>
<th>Maximum Width Of Exposed Area</th>
<th>Maximum Height Of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>118M</td>
<td>WireLite NT SuperLite I-W</td>
<td>60-90</td>
<td>100</td>
<td>10&quot;</td>
<td>33&quot;</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Protect 3</td>
<td>60-90</td>
<td>100</td>
<td>12&quot;</td>
<td>33&quot;</td>
<td>None</td>
</tr>
</tbody>
</table>
Note 1: PEMKO HSS2000 must be applied to the perimeter of the Glass as shown on Page 13 when using 7/16” Pyroshield Plus, 1/4” Labeled Wire Glass or Protect3 Safety Glass in Wood Doors.

Note 2: When PEMKO FG3000 Glazing Tape is required it must be applied as shown on Page 13. When using PEMKO FG3000S or FG3000S90 a special glass pocket is required. 7/16” Pyroshield Plus; 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 weighs 2.4 lbs./Sq. Ft.; 7/16” Pyroshield Plus weighs 5.6 lbs./Sq. Ft.; 5/16” Firelite Plus weighs 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 6.
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 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 Pyroshield Plus, Firelite, Keralite, or Pyran.
5. Door Light Frames manufactured for doors 1/8” to 2 1/4” 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 17.
PyroEdge, PyroSwiss, and SuperLite I are each available in thicknesses greater than 1/4” and requires 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 and maximum width and height dimensions allowed.

Note: Model #110 is limited to 85 lbs. (FireGlass 20, PyroEdge 20 & SuperLite I 20 weighs 3.0 lbs/Sq. Ft.; 3/8” PyroEdge 20 weighs 4.5 lbs./Sq. Ft.; PyroSwiss weighs 2.6 lbs./Sq. Ft. Please consider #118, #118M, or 117M for heavier glasses.

The UL listings below apply to the following glass types:
- FireGlass, PyroEdge 20, PyroSwiss, or SuperLite I 20 (Tempered Glass)

### Underwriters Laboratories Listings

**Positive Pressure Listing Specifications (UL10C)**

<table>
<thead>
<tr>
<th>UL LISTED STYLES</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (minutes)</th>
<th>Maximum Exposed Area in Square Inches</th>
<th>Maximum Width of Exposed Area</th>
<th>Maximum Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>FireGlass, PyroEdge or PyroSwiss</td>
<td>20 No Hose</td>
<td>1296</td>
<td>54”</td>
<td>54”</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>FireGlass, PyroEdge or PyroSwiss</td>
<td>20 No Hose</td>
<td>2856</td>
<td>34”</td>
<td>84”</td>
<td>FG3000S451</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Wood Doors SuperLite I 20</td>
<td>20 No Hose</td>
<td>2719</td>
<td>77 1/8”</td>
<td>77 1/8”</td>
<td>FG3000S451</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Steel Doors SuperLite I 20</td>
<td>20 No Hose</td>
<td>2678</td>
<td>109”</td>
<td>109”</td>
<td>FG3000S451</td>
</tr>
</tbody>
</table>

**Negative Pressure Listing Specifications (UL10B)**

<table>
<thead>
<tr>
<th>UL LISTED STYLES</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (minutes)</th>
<th>Maximum Exposed Area in Square Inches</th>
<th>Maximum Width of Exposed Area</th>
<th>Maximum Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>FireGlass, PyroEdge, or PyroSwiss</td>
<td>20 No Hose</td>
<td>1296</td>
<td>30”</td>
<td>54”</td>
<td>None</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>FireGlass, PyroEdge, or PyroSwiss</td>
<td>20 No Hose</td>
<td>2856</td>
<td>34”</td>
<td>84”</td>
<td>FG3000S451</td>
</tr>
</tbody>
</table>

Note 1: Pemko FG3000 Glazing Tape is required it must be applied as shown on page 13. When using Pemko FG3000S45 a special glass pocket is required.
The glasses on this page must be installed using our Style #118N or #118MN ONLY with Setting Blocks.

**Underwriters Laboratories Listings**

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.

<table>
<thead>
<tr>
<th>GLAZING TYPE</th>
<th>Positive Pressure Ratings ONLY</th>
<th>Maximum Visible Light</th>
<th>Maximum Width</th>
<th>Maximum Height</th>
<th>Glass Thickness</th>
<th>Tape Thickness: 3/8&quot; wide PVC with Adhesive both sides</th>
<th>Number of AMS Preformed Setting Blocks Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pilkington Pyrostop</td>
<td>45 Minute</td>
<td>3724 in.²</td>
<td>41 1/2&quot;</td>
<td>89 1/4&quot;</td>
<td>3/4&quot;</td>
<td>1/16&quot; and Silicone wet seal</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Pilkington Pyrostop²</td>
<td>60 Minute</td>
<td>3724 in.²</td>
<td>41 1/2&quot;</td>
<td>89 1/4&quot;</td>
<td>7/16&quot; and 1&quot;</td>
<td>1/16&quot; and Silicone wet seal</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>SwissFlam 45-N2 ContraFlam 45-2</td>
<td>45 Minute</td>
<td>Steel = 2635 in.² Wood = 2397 in.²</td>
<td>36&quot;</td>
<td>77 1/2&quot;</td>
<td>89 3/4&quot;</td>
<td>3/4&quot;</td>
<td>1/16&quot; and Silicone sealant³</td>
</tr>
<tr>
<td>SwissFlam 60-N2² ContraFlam N2²</td>
<td>60 Minute</td>
<td>3325 in.²</td>
<td>36&quot;</td>
<td>95&quot;</td>
<td>1&quot;</td>
<td>1/16&quot; and Silicone sealant³</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Keralite FR-Ultra⁴ Non-Temperature Rise</td>
<td>20-90 Minute</td>
<td>2736 in.²</td>
<td>46 1/2&quot;</td>
<td>76&quot;</td>
<td>25/32&quot;</td>
<td>1/16&quot; and silicone sealant³</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Keralite FR-Ultra⁴ Temperature Rise</td>
<td>60-90 Minute</td>
<td>100 in.²</td>
<td>12&quot;</td>
<td>33&quot;</td>
<td>25/32&quot;</td>
<td>1/16&quot; and silicone sealant³</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>SuperLite II-XL³</td>
<td>45 Minute</td>
<td>4952 in.²</td>
<td>118&quot;</td>
<td>118&quot;</td>
<td>Standard - 3/16&quot; Thin Profile - 1/2&quot;</td>
<td>1/8&quot; x 1/16&quot; PVC Glazing Tape Both Faces</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
</tbody>
</table>
Underwriters Laboratories Listings

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.

<table>
<thead>
<tr>
<th>GLAZING TYPE</th>
<th>Positive Pressure Ratings ONLY</th>
<th>Maximum Visible Light</th>
<th>Maximum Width</th>
<th>Maximum Height</th>
<th>Glass Thickness</th>
<th>Tape Thickness: 3/8” wide PVC with Adhesive both sides</th>
<th>Number of AMS Preformed Setting Blocks Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>FireLite IGU¹</td>
<td>20-45 and 60 Minute Non-Temperature Rise</td>
<td>3204 in.²</td>
<td>36”</td>
<td>89”</td>
<td>1”</td>
<td>1/8”</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>FireLite IGU¹</td>
<td>90 Minute Non-Temperature Rise</td>
<td>2034 in.²</td>
<td>36”</td>
<td>56 1/2”</td>
<td>1”</td>
<td>1 1/6”</td>
<td>1/8” or TGP Supplied Tape¹</td>
</tr>
<tr>
<td>FireLite IGU¹</td>
<td>60-90 Minute Non-Temperature Rise</td>
<td>100 in.²</td>
<td>12”</td>
<td>33”</td>
<td>1”</td>
<td>1/8”</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Pilkington² Pyrostop 90-102 (Interior)</td>
<td>90 Minute</td>
<td>3724 in.²</td>
<td>41 1/6”</td>
<td>89 1/4”</td>
<td>1 1/16”</td>
<td>1/16” and silicone wet seal</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Pilkington Pyrostop² Pyrostop 120-202 (Exterior)</td>
<td>90 Minute</td>
<td>3724 in.²</td>
<td>41 1/6”</td>
<td>89 1/4”</td>
<td>1 1/16”</td>
<td>1/16” and silicone sealant³</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Swiss Flam 90² ContraFlam 90²</td>
<td>90 Minute</td>
<td>3174 in.²</td>
<td>37 1/4”</td>
<td>88 1/16”</td>
<td>1 1/16”</td>
<td>1/16” and silicone sealant³</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Keralite FR-Ultra⁴ IGU Non-Temperature Rise</td>
<td>20-90 Minute</td>
<td>2736 in.²</td>
<td>46 1/2”</td>
<td>76”</td>
<td>1 2/32”</td>
<td>1/16” and silicone sealant³</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Keralite FR-Ultra⁴ IGU Temperature Rise</td>
<td>60-90 Minute</td>
<td>100 in.²</td>
<td>12”</td>
<td>33”</td>
<td>1 2/32”</td>
<td>1/16” and silicone sealant³</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>SuperLite II-XL⁵</td>
<td>60 Minute</td>
<td>4952 in.²</td>
<td>118”</td>
<td>118”</td>
<td>Standard - 1 1/6”</td>
<td>1/8” x 3/8” PVC Glazing Tape Both Faces and Silicone Sealant³</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>SuperLite II-XL⁵</td>
<td>90 Minute</td>
<td>4876 in.²</td>
<td>118”</td>
<td>118”</td>
<td>1 1/2”</td>
<td>1/8” x 3/8” PVC Glazing Tape Both Faces</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Pyrobel 60⁶ Pyrobel 90⁶ (Interior)</td>
<td>60 Minute</td>
<td>3855 in.²</td>
<td>44”</td>
<td>87 1/8”</td>
<td>1”</td>
<td>1/8” x 3/8” PVC Glazing Tape Both Faces and Silicone Sealant³</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
</tbody>
</table>

¹ Available in other sizes and configurations.
² Available in other colors and finishes.
³ Silicone sealant must be applied to the edges of the glass.
⁴ Preformed setting blocks are available in a variety of thicknesses.
⁵ Glazing tape is available in both standard and thin profile.
⁶ Available in other thicknesses and configurations.

The glasses on this page must be installed using our Style #118W or #118MW ONLY with 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. Use of FireLite IGU 90 minute in sizes that exceed 1393 in.² shall be glazed with fire-rated glazing tape as supplied by Technical Glass Products.

2 Pilkington Pyrostop maintains a temperature rise of no more than 250° F above ambient and 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 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.

5 SuperLite II XL-45, 60 or 90 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 1/8” PVC Glazing Tape. SuperLite II-XL 45 weighs 8.0 lbs/Sq. FT. SuperLite II XL 60 1/8” weighs 9.0 lbs/Sq. FT. SuperLite II XL 90 weighs 12.0 lbs/Sq. FT. 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.

6 Pyrobel 60 or 90 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 #3). If used in an exterior application, the Door Light Frame must be sealed around the outer perimeter of the frame to protect from water infiltration. Pyrobel-60 Interior weighs 12.3 lbs/Sq. Ft. Pyrobel-90 Interior weighs 16.4 lbs/Sq. Ft. 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.
UL Large Door Light Frame Installation Requirements

The maximum visible glass area allowed is 34” wide x 84” high or 2856 sq. in. **Exception:** 20 Minute WireLite NT and SuperLite I-W can have a maximum visible glass area of 35 1/4” wide x 92” high or 3289 sq. in. in HM Doors.

Maximum visible glass for Veneered Frames with 45 Minute rating is 2695 sq. in. with maximum dimensions of 35” x 77” **Exception:** WireLite NT, SuperLite I-W, and Protect 3 are approved for HM Doors ONLY.

Multiple lites are ONLY allowed in doors approved for multiple lites.

**Listed Glazing Products - Wired Glass:**
- 7/16” Pyroshield Plus
- WireLite NT
- Protect3 Safety Glass
- SuperLite I-W

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

**20 Minute Tempered Glass:**
- FireGlass 20
- PyroEdge 20
- PyroSwiss
- SuperLite I-W

Temperature Rise Doors are limited to 100 sq. in. Non Temperature Rise Doors are limited as below.

When using 7/16” Pyroshield Plus, WireLite NT, SuperLite I-W or Protect3 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 and SuperLite I-W can have a maximum of 1296 sq. in. of visible light in 60 minute wood doors with no dimension over 34”. FG3000S90 must be used with the installation as shown below.

WireLite NT, SuperLite I-W, or Protect3 is limited to 960 sq. in. with maximum dimensions of 12” wide x 80” high. Apply tape as shown below.

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.

Protect3 or SuperLite I-W, in 90 Minute HM Doors, and WireLite NT in Steel or Wood 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 6 and 7.

Apply FG3000S54S to frame lip as shown.

For 20 and 45 Minute Hollow Metal and Wood Doors (see pages 6, 7, and 9)

In 20 and 45 Minute Doors multiple Vision Lites are allowed, but the combined total visible glass area allowed is 2856 sq. in. per door.

For 60 and 90 Minute Hollow Metal and Wood Doors (see pages 6 and 7)

Apply FG3000S90 to frame lip as shown.
The WHI Listings below apply to the following Glass Types:

**SuperLite I-W & WireLite NT**  
(Wired Fire Rated Safety Glasses)

**SuperLite I-XL & SuperLite X-90**  
(Non-Wired Fire Rated Safety Glasses)

**NOTE:** The International Building Codes (IBC) no longer allows use of glass in doors that is not safety rated. 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 1/4" Wired Glass, WireLite, or 3/16" FireLite contact us to discuss your options.

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**Warnock Hersey Listings**

Listings below are for Positive Pressure Rated (UL10C) openings for Styles listed below. Negative Pressure Listings are not available for the glasses listed.

### 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 doors 1 3/8" to 2 1/4" thick 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 17).

---

#### Warnock Hersey Listings

<table>
<thead>
<tr>
<th>Styles</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (minutes)</th>
<th>Maximum Exposed Area in Square Inches</th>
<th>Maximum Width of Exposed Area</th>
<th>Maximum Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110, 115, 118 and 118M</td>
<td>SuperLite I-W</td>
<td>20-45</td>
<td>1296</td>
<td>36&quot;</td>
<td>54&quot;</td>
<td>None</td>
</tr>
<tr>
<td>118 and 118M</td>
<td>SuperLite I-W</td>
<td>20-45</td>
<td>1200</td>
<td>36&quot;</td>
<td>54&quot;</td>
<td>None</td>
</tr>
<tr>
<td>110, 115, 118 and 118M</td>
<td>WireLite NT <strong>Steel Doors Only</strong></td>
<td>60-90</td>
<td>100</td>
<td>10&quot;</td>
<td>33&quot;</td>
<td>FG3000S901</td>
</tr>
<tr>
<td>110 and 115</td>
<td>WireLite NT <strong>Steel Doors Only</strong></td>
<td>20</td>
<td>1296</td>
<td>36&quot;</td>
<td>54&quot;</td>
<td>None</td>
</tr>
<tr>
<td>110 and 115</td>
<td>WireLite NT</td>
<td>45</td>
<td>1296</td>
<td>36&quot;</td>
<td>54&quot;</td>
<td>FG3000S451</td>
</tr>
<tr>
<td>110 and 115</td>
<td>WireLite NT</td>
<td>45</td>
<td>1200</td>
<td>36&quot;</td>
<td>54&quot;</td>
<td>FG3000S451</td>
</tr>
<tr>
<td>110, 115, 118 and 118M</td>
<td>WireLite NT</td>
<td>60-90</td>
<td>100</td>
<td>10&quot;</td>
<td>33&quot;</td>
<td>FG3000S451</td>
</tr>
<tr>
<td>110 and 115</td>
<td>SuperLite I-XL</td>
<td>20 No Hose</td>
<td>1296</td>
<td>36&quot;</td>
<td>54&quot;</td>
<td>FG3000S451</td>
</tr>
<tr>
<td>118 and 118M</td>
<td>SuperLite I-XL</td>
<td>20 No Hose</td>
<td>1200</td>
<td>36&quot;</td>
<td>54&quot;</td>
<td>FG3000S451</td>
</tr>
<tr>
<td>110 and 115</td>
<td>SuperLite I-XL</td>
<td>45 No Hose</td>
<td>1296</td>
<td>36&quot;</td>
<td>54&quot;</td>
<td>FG3000S451</td>
</tr>
<tr>
<td>110 and 115</td>
<td>SuperLite I-XL</td>
<td>45 No Hose</td>
<td>1200</td>
<td>36&quot;</td>
<td>54&quot;</td>
<td>FG3000S451</td>
</tr>
<tr>
<td>110, 115, 118 and 118M</td>
<td>SuperLite I-XL <strong>Steel Doors Only</strong></td>
<td>60-90 No Hose</td>
<td>100</td>
<td>10&quot;</td>
<td>33&quot;</td>
<td>FG3000S901</td>
</tr>
<tr>
<td>118 and 118M</td>
<td>SuperLite X-90</td>
<td>90</td>
<td>100</td>
<td>10&quot;</td>
<td>33&quot;</td>
<td>None</td>
</tr>
</tbody>
</table>

**Note 1:** When PEMKO FG3000 Glazing Tape is required it must be applied as shown below. When using PEMKO FG3000 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 3/4” thick and requires a special glass pocket.
The glasses on this page must be installed using our Style #118N or #118MN ONLY with Setting Blocks.

### Warnock Hersey Listings

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 Listings](image_url)

#### Glass Type

<table>
<thead>
<tr>
<th>Glass Type</th>
<th>Positive Pressure Ratings ONLY</th>
<th>Maximum Visible Light</th>
<th>Maximum Width</th>
<th>Maximum Height</th>
<th>Glass Thickness</th>
<th>Tape Required</th>
<th>Number of AMS Preformed Setting Blocks Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>SuperLite I-XL IGU¹</td>
<td>20-45 Minute No Hose</td>
<td>1200 in.²</td>
<td>36”</td>
<td>54”</td>
<td>3/4”</td>
<td>Pemko FG3000545 and Seal Perimeters</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>SuperLite I-XL IGU¹</td>
<td>60 Minute No Hose</td>
<td>100 in.²</td>
<td>10”</td>
<td>33”</td>
<td>3/4”</td>
<td>Pemko FG3000590 and Seal Perimeters</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Pyrobel-45²</td>
<td>45 Minute</td>
<td>1200 in.²</td>
<td>36”</td>
<td>54”</td>
<td>Single Interior = ½”</td>
<td>PVC Tape applied to both faces with Adhesive on one side and Silicone Sealant⁴</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Pyrobel-60²</td>
<td>60 Minute</td>
<td>100 in.²</td>
<td>10”</td>
<td>33”</td>
<td>Single Interior = 1”</td>
<td>PVC Tape applied to both faces with Adhesive on one side and Silicone Sealant⁴</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Superlite II-XL 45³</td>
<td>45 Minute</td>
<td>1200 in.²</td>
<td>36”</td>
<td>54”</td>
<td>Standard = 1/4”</td>
<td>PVC Glazing Tape Both Faces</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Superlite II-XL 60³</td>
<td>60 Minute</td>
<td>100 in.²</td>
<td>10”</td>
<td>33”</td>
<td>Standard = 1/6”</td>
<td>PVC Glazing Tape Both Faces</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
</tbody>
</table>

#### WHI Footnotes:

1. SuperLite I-XL IGU 20-60 Minutes: This glass 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 FG3000545 or FG3000590 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 #118N or #118MN Door Light Frame with Setting Blocks. Weighs 6.0 lbs./Sq. Ft.

2. Pyrobel 45 & 60 Minutes: This glass 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 #118N or #118MN Door Light Frame with Setting Blocks. Pyrobel-45 Interior weighs 8.2 lbs./Sq. Ft.; Pyrobel-45 Exterior weighs 9.8 lbs./Sq. Ft.; Pyrobel-60 Interior weighs 12.3 lbs./Sq. Ft.

3. SuperLite II-XL 45-60 Minutes: This glass 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 #118N or #118MN Door Light Frame with Setting Blocks. SuperLite II-XL standard weighs 8.0 lbs./Sq. Ft.; SuperLite II-XL 60 1-1/8” standard weighs 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.
The WHI Listings below apply to the following Glass Type:

**SuperLite I 20**

<table>
<thead>
<tr>
<th>Styles</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (minutes)</th>
<th>Maximum Exposed Area in Square Inches</th>
<th>Maximum Width of Exposed Area</th>
<th>Maximum Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110 and 115</td>
<td>SuperLite I 20</td>
<td>20 No Hose</td>
<td>1296</td>
<td>36”</td>
<td>54”</td>
<td>None</td>
</tr>
<tr>
<td>118 and 118M</td>
<td>SuperLite I 20</td>
<td>20 No Hose</td>
<td>1200</td>
<td>36”</td>
<td>54”</td>
<td>None</td>
</tr>
</tbody>
</table>

**WHI Note:**

Positive Pressure 20 Minute No Hose installations. **SuperLite I 20** is approved without hose stream and is approved for use in Steel or Wood Doors. The glass thickness for SuperLite I 20 can be between \( \frac{1}{4} \)” and \( \frac{1}{2} \)” 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 \( \frac{1}{4} \)”.

**Note:** Model #110 is limited to a glass weight of 85 lbs. (\( \frac{1}{4} \)” SuperLite I 20 weighs 3.0 lbs./Sq. Ft.)

**Conditions of WHI Listings and 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 \( \frac{3}{8} \)” to 2 \( \frac{3}{4} \)” 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 17).
Installation Instructions Hollow Metal Door Clip

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.

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-A08

Installation Instructions Hollow Metal Door Perimeter Channels

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.

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

18 Gauge CRS
AMS Part No. 247
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 6 through 14. 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 in doors that is not safety rated. 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, 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.

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.
For Styles other than the #110 or #110B

Odd Thickness Door or Glass

**GLASS NOTE:** Laminated Glass NOT recommended. See “Non-Fire Rated Glazing Recommendations” on page 18.

**Door Size:**
- **Minimum:** 1 3/8"
- **Maximum:** 2 3/4"

**Cross Section Views**

**STYLE #117M (PATENT PENDING)**

**ORDER INFORMATION:**
- Order size = Inside dimension of frame (W+H)
- Cutout size = Order size + 1 1/2"
- Glass size = Order size + 1/4"

**STYLE #105M**

**ORDER INFORMATION:**
- Order size = Inside dimension of frame (W+H)
- Cutout size = Order size + 1"
- Glass size = Order size + 1/4"

**STYLE #105**

**ORDER INFORMATION:**
- Order size = Inside dimension of frame (W+H)
- Cutout size = Order size + 1"
- Glass size = Order size + 1/4"

**GLASS NOTE:**
Laminated Glass NOT recommended. See “Non-Fire Rated Glazing Recommendations” on page 18.

**Pocket Size must include glazing allowance**

**Pocket Size must include glazing allowance**
For Styles other than the #110 or #110B

**Odd Thickness Door or Glass**

**GLASS NOTE:** Laminated Glass NOT recommended. See “Non-Fire Rated Glazing Recommendations” on page 18.

**Cross Section Views**

---

**STYLE #118M**

ORDER INFORMATION:

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

Cutout size = Order size + 2 1/4”

Glass size = Order size + 1 5/16”

Frame includes 2 Frame & Glass Supports (See Page 5)

---

**STYLE #118**

ORDER INFORMATION:

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

Cutout size = Order size + 1 3/8”

Glass size = Order size + 1 3/16”

---

**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 a proper installation.

*(ONLY) For Fire Rated glasses listed on pages 10 and 15*

Do Not Use With Any Other Glasses

---

**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 a proper installation.

*(ONLY) For Fire Rated glasses listed on pages 10 and 15*

Do Not Use With Any Other Glasses
Odd Thickness Door or Glass

Cross Section Views

**STYLE #118W**

**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 a proper installation.

*(ONLY For Fire Rated glasses listed on page 11)*

Do Not Use With Any Other Glasses

**STYLE #118MW**

**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 a proper installation.

*(ONLY For Fire Rated glasses listed on page 11)*

Do Not Use With Any Other Glasses
Frames with Mullions use a Single Sheet of Glass and provide a Divided Light Appearance

3/4” Painted Aluminum
Our Lowest Cost Option

Tape On Mullions

1. DESCRIPTION
   - 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. “See Page 23”

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

3. LIMITATIONS:
   - 1/4” maximum glass pocket for a 1-1/4” 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: Cross mullions have 1/16” offset to conceal tube edge radii (see page 24).
   - #110/#110B w/Cross Mullions: 1/4” maximum glass pocket for a 1-1/4” 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”.
   - Welded mullions cannot be veneer wrapped.

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. “See Page 25.”
   - 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 3/4” for styles 110/110B.
   - Maximum glass pocket for 105/105M/117M/118/118M is 1” for 1-3/4” 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 but carry NO Fire Rating. Steel mullions cannot be veneered.

www.AllMetalStamping.com
**3/4" Painted Aluminum Tape on Mullions**

Mullions are attached to the glass with 1/2" x 1/32" double sided foam tape.

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

**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:**
- Glass maximum 1/4"

**GLASS NOTE:**
Glass must be single sheet of Listed Glazing Material to maintain fire rating.

**Section A-A**
- Door Size
  - 1 1/4" Minimum
  - 2 1/4" Maximum

Patent No. 8,156,699B2
Frame Style #110 Shown
CAUTION: MULLIONS CANNOT BE ADJUSTED AFTER TAPE MAKES CONTACT WITH GLASS
**ORDER INFORMATION:**
Order size = Frame inside dimension
Door Cutout size = Order size + 1 1/2”
Glass size = Order size + 3/4”

**MATERIAL:**
18 GA. (.048) x 5/8” square steel tubing.

**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.
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.

- 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 grid.

Please call for information and a Quote.

- Maximum glass pocket in 1 3/4" door is 3/4".

Section A-A
Double or Triple Glazed Frames

**GLASS NOTE:** Laminated Glass NOT recommended.
See “Non-Fire Rated Glazing Recommendations” on page 18.

**STYLE #110-D2** shown Double Glazed (PATENT PENDING)

**STYLE #110/#110B-T** Triple Glazed (PATENT PENDING)

**ORDER INFORMATION:**

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

Glass size = Center Pane Order size + $\frac{3}{4}$" | Outer Pane(s) Order size - $\frac{1}{4}$"

Cutout size = Order size + 1 1/2"

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

20/45 Minute (Limited to 1296 sq. in. with no dimension greater than 54")

60 Minute (Limited to 100 sq. in. with max dimensions of 12" Width and 33" Height)

The outer pane can be listed or non-listed glazing material.

**STYLE #110-D1** shown DOUBLE GLAZED (PATENT PENDING)

**ORDER INFORMATION:**

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

Glass size = Order size + $\frac{1}{4}$"  

Cutout size = Order size + 1 1/2"

**NO Fire Rating**

**Frames for Lead Lined Doors**

**GLASS NOTE:** Laminated Glass NOT recommended.
See “Non-Fire Rated Glazing Recommendations” on page 18.

**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)

Glass size = Center Pane Order size + $\frac{3}{4}$" | Outer Pane(s) Order size - $\frac{3}{16}$"

Cutout size = Order size + 5 5/8"

UL Listed 20, 45, and 60 Minutes when seated pane is leaded glass and the outer pane is Lead Glass

20/45 Minute (Limited to 1096 sq. in. with no dimension greater than 33")

60 Minute (Limited to 100 sq. in. with max dimensions of 12" Width and 33" Height)

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

**ORDER INFORMATION:**

Order size = Visible Dimensions (W+H)

Glass size = Order size + $\frac{1}{4}$"  

Cutout size = Order size + 5 5/8"

**NO Fire Rating**

**STYLE #115-L3** OR **#105-L3** for doors leaded down the center  (PATENT NO. 4,550,542)

**ORDER INFORMATION:**

Order size = Visible Dimensions (W+H)

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

Cutout size = Order size + 7/8"

**NO Fire Rating**

**POCKET SIZE**

9/16”

ALLOWABLE DOOR SIZES
1 1/2” to 2 1/4”

Labeled Doors

**GLASS NOT INCLUDED**

Non Listed Glass

1/2” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

**DOOR SIZE**

1/4” Spacer

Non Listed Glass

1/2” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

MINIMUM WIDTH = 2 1/2”

MAXIMUM WIDTH OR HEIGHT = 33”

9/16”, 1/2” or 1/4” Aluminum Thermal Glass Spacer (included) use additional glazing tape to eliminate looseness or rattling.

Staple lead to cutout at installation.

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

Extend Lead 1/4”

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

1/16”, 1/8” or 1/4” Aluminum Thermal Glass Spacer (included) use additional glazing tape to eliminate looseness or rattling.

LISTED GLAZING not included

FG1000S45 or FG1000S50

Glazing Tape if Required

POCKET SIZE

1/4” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

GLASS NOT INCLUDED

Glazing Tape Recommended

1/4” Spacer

Non Listed Glass

1/2” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

MINIMUM WIDTH = 2 1/2”

MAXIMUM WIDTH OR HEIGHT = 33”

1/16”, 1/8” or 1/4” Aluminum Thermal Glass Spacer (included) use additional glazing tape to eliminate looseness or rattling.

Staple lead to cutout at installation.

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

Extend Lead 1/4”

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

1/16” Minimum 1/16” Maximum

Leaded Glass Not Included

Leaded Glass Not Included

1/2” #115 Frame Shown

FG3000S45 or FG3000S50

Glazing Tape if Required

POCKET SIZE

1/4” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

GLASS NOT INCLUDED

Glazing Tape Recommended

1/4” Spacer

Non Listed Glass

1/2” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

MINIMUM WIDTH = 2 1/2”

MAXIMUM WIDTH OR HEIGHT = 33”

1/16”, 1/8” or 1/4” Aluminum Thermal Glass Spacer (included) use additional glazing tape to eliminate looseness or rattling.

Staple lead to cutout at installation.

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

Extend Lead 1/4”

GLASS NOT INCLUDED

Glazing Tape Recommended

1/4” Spacer

Non Listed Glass

1/2” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

MINIMUM WIDTH = 2 1/2”

MAXIMUM WIDTH OR HEIGHT = 33”

1/16”, 1/8” or 1/4” Aluminum Thermal Glass Spacer (included) use additional glazing tape to eliminate looseness or rattling.

Staple lead to cutout at installation.

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

Extend Lead 1/4”

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

1/16” Minimum 1/16” Maximum

Leaded Glass Not Included

Leaded Glass Not Included

1/2” #115 Frame Shown

FG3000S45 or FG3000S50

Glazing Tape if Required

POCKET SIZE

1/4” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

GLASS NOT INCLUDED

Glazing Tape Recommended

1/4” Spacer

Non Listed Glass

1/2” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

MINIMUM WIDTH = 2 1/2”

MAXIMUM WIDTH OR HEIGHT = 33”

1/16”, 1/8” or 1/4” Aluminum Thermal Glass Spacer (included) use additional glazing tape to eliminate looseness or rattling.

Staple lead to cutout at installation.

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

Extend Lead 1/4”

GLASS NOT INCLUDED

Glazing Tape Recommended

1/4” Spacer

Non Listed Glass

1/2” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

MINIMUM WIDTH = 2 1/2”

MAXIMUM WIDTH OR HEIGHT = 33”

1/16”, 1/8” or 1/4” Aluminum Thermal Glass Spacer (included) use additional glazing tape to eliminate looseness or rattling.

Staple lead to cutout at installation.

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

Extend Lead 1/4”

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

1/16” Minimum 1/16” Maximum

Leaded Glass Not Included

Leaded Glass Not Included

1/2” #115 Frame Shown

FG3000S45 or FG3000S50

Glazing Tape if Required

POCKET SIZE

1/4” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

GLASS NOT INCLUDED

Glazing Tape Recommended

1/4” Spacer

Non Listed Glass

1/2” Aluminum Thermal Glass Spacer (included)

Glazing Tape Recommended

MINIMUM WIDTH = 2 1/2”

MAXIMUM WIDTH OR HEIGHT = 33”

1/16”, 1/8” or 1/4” Aluminum Thermal Glass Spacer (included) use additional glazing tape to eliminate looseness or rattling.

Staple lead to cutout at installation.

Glazing Tape Recommended

(2) Frame and glass supports included. Use on bottom only.

Extend Lead 1/4”

GLASS NOT INCLUDED

Glazing Tape Recommended

1/4” Spacer

Non Listed Glass

1/2” Aluminum Thermal Glass Spacer (included)
UL and WHI Listed Edge and Astragal Sets

OTHER ITEMS
- Lead Lined Astragals
- Dutch Door and Transom Channels - #222
- “T”, “Z”, and Flat Astragals
- Hinge Edge and Lock Edge Protectors
- Aluminum Door Flashings
- Dutch Door Shelves
- Standard Finish is Beige, Gray or Dark Bronze Polyester Powder Coating
- All Bevels are 1/8” in 2”
- Punched and coined for #8 x 1/4 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
UL Ratings

FOR USE ON WOOD OR PLASTIC FACED DOORS RATED UP TO 90 MINUTE AND HOLLOW METAL, STEEL COVERED COMPOSITE DOORS RATED UP TO 3 HOURS.
- ALL STYLES EXCEPT #236 (STEEL DOORS ONLY UP TO 3 HOURS)

MATERIAL: 20, 18, OR 16 GAUGE STEEL, GALVANIZED STEEL OR STAINLESS STEEL.
- ALL STYLES EXCEPT #215 (14 OR 12 GAUGE ONLY), #236 (20 GAUGE ONLY), AND #237, 238, 239 (14 OR 16 GAUGE ONLY)

ASTRAL OVERLAP LENGTHS: 1/2” - 3 1/2” MAXIMUM
- ALL STYLES WITH ASTRARAL LIP

LEG LENGTHS: CAN VARY BETWEEN 1/2” TO 3 1/2”
- ALL STYLES EXCEPT THE FOLLOWING: 231,232,233,235,213,214,229,237,238,239 (1/2” TO 2” ONLY)

DOOR THICKNESS: 1 3/8” TO 2 1/4” THICK DOORS UP TO 120” LENGTH
- ALL STYLES

LEAD LINED: PER SPECS ABOVE

VENNER - 90 MINUTE - NEGATIVE AND POSITIVE PRESSURE

WHI Ratings

EDGE AND ASTRAL SETS ONLY ARE LISTED TO 90 MINUTE.

DOUBLE EDGE SETS ONLY ARE LISTED TO 90 MINUTE.

VENNER - 90 MINUTE - NEGATIVE PRESSURE ONLY

LEAD LINED - 20 MINUTE - ASTRARAL AND EDGE SETS ONLY
Edge and Astragal Specifications

**Standard Edges are 20 GA. (.035) CRS**  
**Astragal Flanges are 16 GA. (.062) CRS**

![Diagram of edge and astragal specifications](image)

- #205  Standard Beveled Astragal
- #206  Beveled Edge (shown)
- #210  Reverse Beveled Astragal
- #211  Square Astragal (no bevel)
- #215  Flat Astragal
- #216  Square Edge (no bevel)
- #217  Beveled Edge Machined w/Strike open to low side of bevel
- #221  "L" Shaped Lock Edge Protector - Beveled
- #222  "L" Shaped Lock Edge Protector - Square
- #223  "Z" Astragal - Beveled
- #224  "Z" Astragal - Reverse Bevel
- #225  "Z" Astragal - Square
- #226  "L" Shaped Lock Edge Protector - Beveled
- #227  "L" Shaped Lock Edge Protector - Square
- #228  "U" Shaped - Beveled
- #229  "U" Shaped - Square
- #230  "T" Shaped - Beveled
- #231  "T" Shaped - Square
- #232  "T" Shaped - Beveled
- #233  "T" Shaped - Square
- #234  "T" Shaped - Beveled

**“T” (18 Ga.), “Z” (16 Ga.) and Flat Astragals (14 Ga.)**

![Diagram of "T", "Z", and flat astragals](image)

- 18 GA. (.048) CRS Edge / 16 GA. (.062) Astragal
- #229  "T" Astragal - Reversed Bevel (shown)
- #230  "T" Astragal - Beveled
- #231  "T" Astragal - Square
- 14 GA. (.074) CRS
- #225  "Z" Astragal - Beveled
- #230  "Z" Astragal - Reverse Bevel
- #231  "Z" Astragal - Square
- 16 GA. (.062) CRS Standard
- #232  "U" Shaped - Beveled
- #233  "U" Shaped - Square

**Lead Lined Astragals**

![Diagram of lead lined astragals](image)

- 18 GA (.048) CRS Std.
- #236 Lead Lined Flat Astragal
- 1/8" Approx.
- 3/16" Approx.
- 1 1/8"

**Hinge Edge Protectors**

![Diagram of hinge edge protectors](image)

- Punchouts for 4 1/2" or 5" Hinge Standard
- Available in: 20 GA. CRS painted 20 GA. or 18 GA. SS
- #223  "L" Shaped - Beveled
- #224  "L" Shaped - Square
- #225  "L" Shaped - Beveled
- #226  "L" Shaped - Square
- #227  "L" Shaped - Beveled
- #228  "L" Shaped - Square
- #229  "L" Shaped - Beveled
- #230  "L" Shaped - Square

Pricing is available by Email or Fax
Concealed Vertical Rod 5”
Metal Channels for Wood
Doors

A completed AMS Template must accompany your order. Templates are available on our website at www.allmetalstamping.com

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<thead>
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<th>AMS PART NO.</th>
<th>DEVICE MANUFACTURER</th>
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<td>251A</td>
<td>Von Duprin CVC Series</td>
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<td>3900/8900</td>
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<td>Yale Device</td>
<td>2160/7120/7160</td>
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<td>Monarch/Falcon Devices</td>
<td>(F) 17-24-18-25-XX-C</td>
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<td>Precision Device</td>
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<td>Sargent Device</td>
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<td>DORMA Device</td>
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<td>Von Duprin Series</td>
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<td>Sargent Device</td>
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<td>Monarch/Falcon Centerslide Devices</td>
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<td>Hager Series</td>
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<td>273</td>
<td>Cal-Royal Series</td>
<td>W77CVR/W98CVR</td>
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<tr>
<td>274</td>
<td>Lawrence Series</td>
<td>LH8850/8650</td>
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</table>

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

MATERIAL: 20 GA. Galvanized Steel
Beige, Gray or Dark Bronze
Polyester Powder Coating

SPECIALS:
20 GA. SS w/ #4 Brushed Finish
Veneer Wrapped

www.AllMetalStamping.com
Standard and “Quick Ship” Services
Please specify ship date on each order.

DOOR LIGHT FRAMES - STYLE #110

Frames are manufactured for 1-3/4” Doors with 1/4” 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 upcharges. Veneer product is available on 7-10 day service subject to availability of the veneer. See our website for veneer species available. 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 - From 3” to 60” (fractions OK).

EDGE & ASTRAGAL SETS

All Sets are manufactured for 1-1/4” 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 our website for veneer species available. 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 and Non-Machined - Styles #207, #208, #209, #211, #212, #217, #218, #219,#222, #223, #224, #225, and #226 as shown on Page 27 - 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 10% Upcharge for Machined and 10% Upcharge for Non-Machined items. Machined & Non-Machined - Styles #207, #208, #209, #211, #212, #217, #218, #219, #222,#223, #224, #225, and #226 as shown on Page 27 - Any Length to 120”.

Channels with an Electric Strike will require 12 business days to manufacture, and are NOT available on our Quick Ship programs.

**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](http://www.AllMetalStamping.com)

Other expedited services are available upon request, please call for a quotation.
Style #110 Low Profile Door Light Frames
(Stock Orders Ship the Next Business Day at No Upcharge)

Stock Size List

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

**PROVISIONS:**

1. Stock Orders placed before 1 P.M. CST/CDT will ship the next business day at no upcharge.

2. Stock Orders over 50 units may require an additional day.

3. 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.

4. Stock Door Light Frames are manufactured for 1 3/4” doors with 1/4” 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. Pricing is the same as shown on Price Table in the Price Guide. You may request this page with pricing by Email or FAX.
Veneer Wrapped
Door Light Frames
See pages 3-5, 19-21, and 26

Astragal and Edge Sets
See pages 27 and 29

5” Channels
See page 30

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.
See website for species available.
Please call for a quotation.

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.

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, or 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 of the veneer will be required so we can compare to our stock or send on to our sup-
plier. Please note this will add considerable time to our ability to deliver product and may affect price if a special order is required.
Conditions of Sale

PRICES
Subject to change without notice.

STANDARD TERMS OF SALE
1% 10 Net 30 days with pre-approved credit. All other shipments will be C.O.D., Credit Card 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. 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. 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.