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

- Door Light Frames
- Metal Door Edges & Astragals (machined to your specifications)
- All Available in Steel or Stainless Steel
This catalog can be downloaded from our website at www.AllMetalStamping.com. The Pricing Pages 14, 15, 16, 21, 24, 25, 27, and 29 can be obtained by email, fax, or mail by contacting us at 715-223-6324. We will send these pages to you as soon as possible.

### Door Light Frames

<table>
<thead>
<tr>
<th>Specification</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>#110/#110B Door Light Frame Specifications -- Our Best Value</td>
<td>1-2</td>
</tr>
<tr>
<td>#115 Door Light Frame Specifications</td>
<td>3</td>
</tr>
<tr>
<td>Door Light Frame Listings</td>
<td>4-13</td>
</tr>
<tr>
<td>Door Light Frame Price Guide &amp; Table</td>
<td>14-15</td>
</tr>
<tr>
<td>Special Door Light Frames (#117M/#118M/#118/#118MSP/#105M/#105)</td>
<td>16-17</td>
</tr>
<tr>
<td>Mullions</td>
<td>18-19</td>
</tr>
<tr>
<td>Frames for Double &amp; Triple Glazing, and Frames for Lead Lining</td>
<td>20-21</td>
</tr>
</tbody>
</table>

### Edge & Astragal Sets and 5″ Channels

<table>
<thead>
<tr>
<th>Specification</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>Door Edge &amp; Astragal Specifications</td>
<td>22-23</td>
</tr>
<tr>
<td>Door Edge &amp; Astragal Pricing</td>
<td>24</td>
</tr>
<tr>
<td>Special Door Edge &amp; Astragal Pricing</td>
<td>25</td>
</tr>
<tr>
<td>Concealed Vertical Rod 5″ Channels</td>
<td>26-27</td>
</tr>
</tbody>
</table>

### Standard & "Quick Ship" Services

<table>
<thead>
<tr>
<th>Specification</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard &amp; &quot;Quick Ship&quot; Services</td>
<td>28</td>
</tr>
<tr>
<td>Stock Size Frame List</td>
<td>29</td>
</tr>
</tbody>
</table>

### Veneer Wrapped Products

<table>
<thead>
<tr>
<th>Specification</th>
<th>Page</th>
</tr>
</thead>
<tbody>
<tr>
<td>Veneer wrapped Frames, Edge &amp; Astragalas, and 5″ Channels</td>
<td>30</td>
</tr>
<tr>
<td>Conditions of Sale</td>
<td>31</td>
</tr>
</tbody>
</table>

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

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

ALL METAL STAMPING, INC.
411 W. Spruce Street
P.O. Box 485
Abbotsford, WI. 54405-0485
Phone: 715-223-6324
[www.AllMetalStamping.com](http://www.AllMetalStamping.com)  
FAX: 715-223-3352
**MODEL 110 LOW PROFILE FIRE DOOR LIGHT FRAME**

**ORDER INFORMATION:**
ORDER SIZE = Inside dimension of frame, (W+H)  
CUTOUT SIZE = Order size + 1½"  
GLASS SIZE = Order size + ½"

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

**FINISH:**
Beige polyester powder coating.  
• Extremely durable  
• Visually appealing

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

**PRODUCT RANGE:**
• Low Profile feature available for 1" to 2½" thick doors.  
• Maximum Glass pocket with Low Profile feature is 8" less than Door Thickness.

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

**MOUNTING HOLES:**
• 11" length or less, one hole centered.  
• Over 11", three inches, maximum from corners.  
• 11½" maximum centers.

---

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

**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.

**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

**Laminated Glass**
**NOT recommended**
See Glass Note.

---

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

Patent Pending
MODEL 110B LOW PROFILE FIRE DOOR LIGHT FRAME

ORDER INFORMATION:
ORDER SIZE = Inside dimension of frame, (W x H)
CUTOUT SIZE = Order size + 1\(\frac{1}{2}\)"
GLASS SIZE = Order size + \(\frac{3}{8}\)"

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

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

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

OPTIONS:
- 18 GA. Galvanized for exterior use.
- 18 GA. Stainless Steel for hospital and food service.
- Custom colors.
- Wood veneer wrapped in various species to match door.
- Available for a variety of glass and door thicknesses.

NOTE... Maximum glass pocket is \(\frac{3}{8}\)" less than door thickness.

MOUNTING HOLES:
- 11" length or less, one hole centered.
- Over 11", three inches, maximum from corners.
  11\(\frac{1}{2}\)" 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.

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

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

LOW PROFILE
- Provides less interference for exit hardware.

NO SHARP CORNERS
- 5/32 Radius

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

LAMINATED GLASS NOT RECOMMENDED
SEE GLASS NOTE.

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

PAGE 2 Patent Pending
MODEL 115 FIRE DOOR LIGHT FRAME

ORDER INFORMATION:
ORDER SIZE = Inside dimension of frame, (W+H)
CUTOUT SIZE = Order size + 1½"
GLASS SIZE = Order size + 3⁄4"

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

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

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

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

MOUNTING HOLES:
• 11” length or less, one hole centered.
• Over 11”, three inches maximum from corners. 11½” maximum centers.

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

WELDED STIFFENER
• Reduces corner flex.

Vandal proof binder post (included).

LAMINATED GLASS
NOT RECOMMENDED
SEE GLASS NOTE.

#8–32 Flat head machine screw. (included)

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.

ALL METAL STAMPING, INC.
411 W. Spruce St., P.O. Box 485, Abbotsford, Wisconsin 54405–0485
Phone (715) 223–6324 Fax (715) 223–3352 Patent NO. 4,550,542
www.allmetalstamping.com
Underwriters Laboratories Listings.

The UL Listings below apply to the following Glass Types.

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

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

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

<table>
<thead>
<tr>
<th>Styles</th>
<th>Other Conditions or Restrictions</th>
<th>Glass Types: 7/16&quot; Pyroshield; Firelite NT; Firelite Plus; Keralite FR-F; Keralite FR-L; Pyran F; Pyran L</th>
<th>Rating (Minutes)</th>
<th>Max. Exposed Area Sq. In.</th>
<th>Max. Width of Exposed Area</th>
<th>Max. Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>All Glasses Listed</td>
<td>20-45</td>
<td>1296</td>
<td>54&quot;</td>
<td>54&quot;</td>
<td>None</td>
<td></td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>All Glasses Listed</td>
<td>20-45</td>
<td>2856</td>
<td>34&quot;</td>
<td>84&quot;</td>
<td>FG3000S45²</td>
<td></td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>All Glasses Listed Temperature Rise Doors</td>
<td>60-90</td>
<td>100</td>
<td>12&quot;</td>
<td>33&quot;</td>
<td>None</td>
<td></td>
</tr>
<tr>
<td>110, 110B</td>
<td>All Glasses Listed Non-Temperature Rise Doors</td>
<td>60-90</td>
<td>300</td>
<td>15&quot;</td>
<td>33&quot;</td>
<td>None</td>
<td></td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>All Glasses Listed Non-Temperature Rise Doors</td>
<td>60</td>
<td>Max. 1920 Single Lite 960</td>
<td>12&quot;</td>
<td>24&quot;</td>
<td>36&quot;</td>
<td>FG3000S90² HSS2000¹</td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Using Firelite, Keralite, or Pyran. Non-Temperature Rise Doors</td>
<td>60</td>
<td>1296</td>
<td>54&quot;</td>
<td>54&quot;</td>
<td>FG3000S90²</td>
<td></td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>All Glasses Listed Non-Temperature Rise Doors</td>
<td>90</td>
<td>Max. 2208 Single Lite 552</td>
<td>12&quot;</td>
<td>46&quot;</td>
<td>FG3000S90² HSS2000¹</td>
<td></td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Using Firelite, Keralite, or Pyran. Non-Temperature Rise Doors</td>
<td>90</td>
<td>1296</td>
<td>54&quot;</td>
<td>54&quot;</td>
<td>FG3000S90²</td>
<td></td>
</tr>
</tbody>
</table>

Glass Types: WireLite NT

<table>
<thead>
<tr>
<th>Styles</th>
<th>Other Conditions or Restrictions</th>
<th>Glass Types: WireLite NT</th>
<th>Rating (Minutes)</th>
<th>Max. Exposed Area Sq. In.</th>
<th>Max. Width of Exposed Area</th>
<th>Max. Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Using Wirelite NT</td>
<td>20-45</td>
<td>1296</td>
<td>54&quot;</td>
<td>54&quot;</td>
<td>None</td>
<td></td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Using Wirelite NT Steel Doors ONLY</td>
<td>20</td>
<td>3289</td>
<td>35-3/4&quot;</td>
<td>92&quot;</td>
<td>FG3000S45²</td>
<td></td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Using Wirelite NT Steel Doors ONLY</td>
<td>45</td>
<td>2856</td>
<td>34&quot;</td>
<td>84&quot;</td>
<td>FG3000S45²</td>
<td></td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>Using Wirelite NT Temperature Rise Doors</td>
<td>60</td>
<td>100</td>
<td>10&quot;</td>
<td>33&quot;</td>
<td>None</td>
<td></td>
</tr>
</tbody>
</table>

Page 4
<table>
<thead>
<tr>
<th>Glass Types: WireLite NT</th>
<th>Glass Types: Firelite NT or Firelite Plus</th>
</tr>
</thead>
</table>

### Conditions for UL Listings & Approvals

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


3. Custom Shape Frames are UL Listed to 1296 in.\(^2\) for 20-45 Minute with no dimension greater than 54"; and to 100 in.\(^2\) for 60-90 Minute Installations with a maximum dimensions of 12" wide x 33" high. This includes Crosses, Triangles, Hexagons, etc.

   **Temperature Rise restrictions apply to 60 & 90 Minute Positive Pressure Installations**

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

5. Door Light Frames manufactured for doors 1 ¾" to 2 ¼" thick can be labeled and used in appropriately labeled doors.

6. Hollow Metal Doors approved to use a clip system, in lieu of full perimeter channels, can use the AMS Hollow Metal Door Clips. See Page 9.
The UL Listings below apply to the following Glass Types.

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

<table>
<thead>
<tr>
<th>UL Listed Styles</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (Minutes)</th>
<th>Max. Exposed Area Sq. In.</th>
<th>Max. Width of Exposed Area</th>
<th>Max. Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>Positive Pressure Listing Specifications (UL10C/UBC 7-2)</td>
<td>Glass Types: FireGlass 20, PyroEdge 20, or PyroSwiss</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Door Types are: Wood Core, Wood with Mineral Core, or Steel Doors with Honeycomb, Mineral Core, or Steel Stiffened Cores</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>110, 110B, 115, 117M, 118, 118M</td>
<td>All Glasses Listed</td>
<td>20</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>All Glasses Listed</td>
<td>20</td>
<td>2856</td>
<td>34&quot;</td>
<td>84&quot;</td>
<td>FG3000S451</td>
</tr>
</tbody>
</table>

Negative Pressure Listing Specifications (UL10B)

| Door Types are: Wood Core, Wood with Mineral Core, or Hollow Metal Doors. |
|------------------|---------------------------------|------------------|--------------------------|---------------------------|----------------------------|-----------------------|
| 110, 110B, 115, 117M, 118, 118M | All Glasses Listed | 20 | 1296 | 30" | 54" | None |
| 110, 110B, 115, 117M, 118, 118M | All Glasses Listed | 20 | 2856 | 34" | 84" | FG3000S451 |

Note 1: When PEMKO FG3000 Glazing Tape is required it must be applied as shown on Page 7. When using PEMKO FG3000S45 a special glass pocket is required.

PyroEdge and PyroSwiss are both available in thicknesses greater than ¼” and require a special glass pocket. Multiple lites are ONLY allowed in doors approved for multiple lites and the combined total of visible light cannot exceed the maximum square inches or maximum width and height dimensions allowed.

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

**CONDITIONS OF UL LISTINGS & APPROVALS**

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

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

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

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

5. Door Light Frames manufactured for doors 1 ¾” to 2 ¼” thick can be labeled and used in appropriately labeled doors.

6. Hollow Metal Doors approved to use a clip system, in lieu of full perimeter channels, can use the AMS Hollow Metal Door Clips. See Page 9.
UL Large Door Light Frames Installation Requirements
for 20 and 45 Minute Hollow Metal & Wood Doors  (See Pages 4, 5, & 6)

The maximum visible glass area allowed is 34" wide x 84" high or 2856 sq. in. Exception 20 Minute WireLite NT can have a maximum visible glass area of 35-3/4" wide x 92" high or 3689 sq. in. In HM Doors.

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

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

In 20 & 45 Min. Doors multiple Vision Lites are allowed, but the combined total visible glass area allowed is 2656 sq. in. per door. Veneered Frames In 45 Min. Doors are limited to 2695 sq. in. with 35" x 77" max. dimensions. Exception: WireLite NT is approved for HM Doors ONLY.

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

Listed Glazing Products
Wired Glass:
- 7/16" Pyroshield Plus
- WireLite NT

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

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

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

When using 7/16" Pyroshield Plus, or WireLite NT the guidelines below apply.

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

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

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

WireLite NT in 90 Minute HM Doors is limited to a maximum visible glass area of 552 sq. in. with maximum dimensions of 12" wide x 46" high.

For other approved glasses see size limitations on Pages 4 & 5.

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

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

Page 7
### Underwriters Laboratories Listings

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

<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: ¾” wide PVC w/Adhesive both sides</th>
<th>Number of AMS Preformed Setting Blocks required</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 Firelite IGU</td>
<td>20 – 45 &amp; 60 Minute Non-Temperature Rise</td>
<td>3204 in.²</td>
<td>36”</td>
<td>89”</td>
<td>20 Min. = ¼”</td>
<td>¾”</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>45 Min. = ¾”</td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>60 Min. = 1”</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1 Firelite IGU</td>
<td>60 Minute Temperature Rise</td>
<td>100 in.²</td>
<td>12”</td>
<td>33”</td>
<td>1”</td>
<td>¾”</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>Pilkington Pyrostop</td>
<td>45 Minute</td>
<td>3724 in.²</td>
<td>41 5/8”</td>
<td>89 ¾”</td>
<td>¾”</td>
<td>1/16” and silicone wet seal</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>7/8” And 1”</td>
<td></td>
<td></td>
</tr>
<tr>
<td>2 Pilkington Pyrostop</td>
<td>60 Minute</td>
<td>3724 in.²</td>
<td>41 5/8”</td>
<td>89 ¾”</td>
<td>¾”</td>
<td>1/16” and silicone wet seal</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>SwissFlam 45-N2</td>
<td>45 Minute</td>
<td>Steel 2635 in.²</td>
<td>36”</td>
<td>77 ½”</td>
<td>¾”</td>
<td>1/16” and 3 silicone sealant</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Wood 2397 in.²</td>
<td>36”</td>
<td>70 ½”</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2 SwissFlam 60-N2 ContraFlam N2</td>
<td>60 Minute</td>
<td>3325 in.²</td>
<td>36”</td>
<td>95”</td>
<td>¾”</td>
<td>1/16” and 3 silicone sealant</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4 Keralite FR-Ultra Non-Temperature Rise</td>
<td>20-90 Minute</td>
<td>1222 in.²</td>
<td>23”</td>
<td>53”</td>
<td>¾”</td>
<td>1/16” and 3 silicone sealant</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>4 Keralite FR-Ultra Temperature Rise</td>
<td>60-90 Minute</td>
<td>100 in.²</td>
<td>12”</td>
<td>33”</td>
<td>¾”</td>
<td>1/16” and 3 silicone sealant</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
</tbody>
</table>

**UL Footnotes:**

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

2 These glasses maintain a temperature rise of no more that 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 Minute Fire Rated Openings requires prior approval of the Authority Having Jurisdiction (AHJ). Ensure glazing is approved before installing.

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

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

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

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 1/2" Doors ONLY.

AMS Part No.: 1175-008

Installation Instructions
Hollow Metal Door Perimeter Channels (18 Ga. CRS)

1. Cut top, bottom, and side channels the same length as the cutout dimensions.

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

3. Tack weld into place.
Warnock Hersey Listings.

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 that is not safety rated in doors. Therefore we have removed all non-safety rated glass from these listings. If you have an approved use for a non-safety rated glass such as ¼“ Wired Glass, WireLite, or 3/16“ FireLite contact us to discuss your options.

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

<table>
<thead>
<tr>
<th>Styles</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (Minutes)</th>
<th>Max. Exposed Area Sq. In.</th>
<th>Max. Width of Exposed Area</th>
<th>Max. Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110 &amp; 115</td>
<td>SuperLite I-W³</td>
<td>20-45</td>
<td>1296</td>
<td>36”</td>
<td>54”</td>
<td>None</td>
</tr>
<tr>
<td>118 &amp; 118M</td>
<td>SuperLite I-W³</td>
<td>20-45</td>
<td>1200</td>
<td>36”</td>
<td>54”</td>
<td>None</td>
</tr>
<tr>
<td>110, 115,</td>
<td>SuperLite I-W</td>
<td>60-90</td>
<td>100</td>
<td>10”</td>
<td>33”</td>
<td>FG3000S90¹</td>
</tr>
<tr>
<td>118 &amp; 118M</td>
<td>WireLite NT Steel Doors ONLY</td>
<td>20</td>
<td>1296</td>
<td>36”</td>
<td>54”</td>
<td>None</td>
</tr>
<tr>
<td>110 &amp; 115</td>
<td>WireLite NT Steel Doors ONLY</td>
<td>45</td>
<td>1296</td>
<td>36”</td>
<td>54”</td>
<td>FG3000S45¹</td>
</tr>
<tr>
<td>118 &amp; 118M</td>
<td>WireLite NT Steel Doors ONLY</td>
<td>45</td>
<td>1200</td>
<td>36”</td>
<td>54”</td>
<td>FG3000S45¹</td>
</tr>
<tr>
<td>110, 115,</td>
<td>WireLite NT</td>
<td>60-90</td>
<td>100</td>
<td>10”</td>
<td>33”</td>
<td>FG3000S90¹</td>
</tr>
<tr>
<td>118 &amp; 118M</td>
<td>SuperLite I-XL 20 No Hose</td>
<td>1296</td>
<td>36”</td>
<td>54”</td>
<td>FG3000S45¹</td>
<td></td>
</tr>
<tr>
<td>110 &amp; 115</td>
<td>SuperLite I-XL 45 No Hose²</td>
<td>1296</td>
<td>36”</td>
<td>54”</td>
<td>FG3000S45¹</td>
<td></td>
</tr>
<tr>
<td>118 &amp; 118M</td>
<td>SuperLite I-XL 45 No Hose²</td>
<td>1200</td>
<td>36”</td>
<td>54”</td>
<td>FG3000S45¹</td>
<td></td>
</tr>
<tr>
<td>110, 115,</td>
<td>SuperLite I-XL Steel Doors ONLY</td>
<td>60-90</td>
<td>100</td>
<td>10”</td>
<td>33”</td>
<td>FG3000S90¹</td>
</tr>
<tr>
<td>118 &amp; 118M</td>
<td>SuperLite X-90</td>
<td>90</td>
<td>100</td>
<td>10”</td>
<td>33”</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 FG3000S45 or FG3000S90 a special glass pocket is required.

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

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

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

Note: Model #110 is limited to a glass weight of 85 lbs. (WireLite NT weights 2.4 lbs./Sq. Ft.; SuperLite I-W weights 3.0 lbs./Sq. Ft.; SuperLite I-XL weights 3.0 lbs./Sq. Ft.) Please consider #118, or #118M for heavier glass. SuperLite X-90 weights 9.0 lbs./Sq. Ft. and can only use our Style #118 or #118M.

Multiple lites are ONLY allowed in doors approved for multiple lites and the combined total of visible light cannot exceed the maximum square inches or maximum width and height dimensions allowed.
The glasses on this page must be installed using our Style #118 or #118M ONLY with Setting Blocks. Special Installation Instructions are provided to ensure the glass is installed in the door correctly. Be sure to indicate exactly what glass will be used on your installation when you place your order. Multiple lites are ONLY allowed in doors approved for multiple lites.

<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 Required</th>
<th>Number of AMS Preformed Setting Blocks required</th>
</tr>
</thead>
<tbody>
<tr>
<td>1SuperLite I-XL IGU</td>
<td>20 – 45 Minute Without Hose Stream</td>
<td>1200 in.²</td>
<td>36”</td>
<td>54”</td>
<td>3/4”</td>
<td>Pemko FG3000S45 &amp; Seal perimeters</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>1SuperLite I-XL IGU</td>
<td>60 Minute Without Hose Stream</td>
<td>100 in.²</td>
<td>10”</td>
<td>33”</td>
<td>3/4”</td>
<td>Pemko FG3000S90 &amp; Seal perimeters</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>2Pyrobel-45</td>
<td>45 Minute</td>
<td>1200 in.²</td>
<td>36”</td>
<td>54”</td>
<td>Single Interior 5/8”</td>
<td>1/6” x 1/2” PVC Tape w/Adhesive one side And 4Silicone Sealant</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>2Pyrobel-60</td>
<td>60 Minute</td>
<td>100 in.²</td>
<td>10”</td>
<td>33”</td>
<td>Single Interior 1”</td>
<td>1/6” x 1/2” PVC Tape w/Adhesive one side And 4Silicone Sealant</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>3SuperLite II-XL 45</td>
<td>45 Minute</td>
<td>1200 in.²</td>
<td>36”</td>
<td>54”</td>
<td>Thin Profile 1/2”</td>
<td>Standard 3/4” PVC Glazing Tape both faces</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
<tr>
<td>3SuperLite II-XL 60</td>
<td>60 Minute</td>
<td>100 in.²</td>
<td>10”</td>
<td>33”</td>
<td>Thin Profile 1/6”</td>
<td>Standard 1-1/8” PVC Glazing Tape both faces</td>
<td>2 AMS Preformed Setting Blocks</td>
</tr>
</tbody>
</table>

**WHI Footnotes:**

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

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

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

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

Warnock Hersey Listings

<table>
<thead>
<tr>
<th>Styles</th>
<th>Other Conditions or Restrictions</th>
<th>Rating (Minutes)</th>
<th>Max. Exposed Area Sq. In.</th>
<th>Max. Width of Exposed Area</th>
<th>Max. Height of Exposed Area</th>
<th>Glazing Tape Required</th>
</tr>
</thead>
<tbody>
<tr>
<td>110 &amp; 115</td>
<td>SuperLite 20</td>
<td>20 No Hose</td>
<td>1296</td>
<td>36”</td>
<td>54”</td>
<td>None</td>
</tr>
<tr>
<td>118 &amp; 118M</td>
<td>SuperLite 20</td>
<td>20 No Hose</td>
<td>1200</td>
<td>36”</td>
<td>54”</td>
<td>None</td>
</tr>
</tbody>
</table>

**Positive Pressure Listing Specifications (UL10C/UBC 7-2)**

WHI NOTE:

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

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

**CONDITIONS OF WHI LISTINGS & APPROVALS**

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

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

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

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

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

Non-Fire Rated Glazing Recommendations

We highly recommend tempered glass over laminated glass in non-fire rated applications to prevent glass breakage. We also recommend glazing tape be used with all non-fire rated installations. Add allowance for glazing tape to the glass thickness to determine proper glass pocket.

Example: 1/16” glazing tape both sides + 1/4” glass = 3/8” glass pocket.
If laminated glass is used we recommend you install with glazing tape and light torque on the screws to prevent glass breakage.

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

Top Coating Instructions for Fire Door Hardware

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

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

LIMITED WARRANTY: ALL METAL STAMPING, INC. WARRANTS ALL DOOR HARDWARE TO BE FREE FROM DEFECTS IN MATERIALS AND WORKMANSHP. Purchaser assumes responsibility to verify and determine that color, finish, and quality of materials will meet required specifications. No claim shall be allowed unless the Purchaser gives notice to manufacturer within 30 days from the date materials are received. If color match, finish quality, or glass and cutout fit are not satisfactory, DO NOT INSTALL. UPON INSTALLATION THIS WARRANTY ENDS. Manufacturer’s only obligation shall be replacement, refinishing, or refund of the original purchase price, at our option. THESE ARE THE EXCLUSIVE REMEDIES PROVIDED, AND ALL METAL STAMPING, INC. SHALL NOT BE LIABLE FOR ANY OTHER DAMAGES, INCLUDING, ANY OTHER DIRECT, INDIRECT, INCIDENTAL, OR CONSEQUENTIAL DAMAGES. This warranty does not apply to door hardware which has been abused, altered, improperly installed, used with incompatible or inappropriate components (EX. Oversized Glass), exposed to corrosive environments, or environments for which the product is not intended. No material shall be returned without prior authorization. This warranty extends only to the original Purchaser who is buying the hardware from All Metal Stamping, Inc. for purposes of resale or use in the ordinary course of their business.
ODD THICKNESS DOOR or GLASS
For Styles other than the #110 or #110B

CROSS SECTION VIEWS

**Style #117M (Patent Pending)**
Order Information:
Order Size = Inside Dimension of Frame (W x H)
Cutout Size = Order Size + 1 1/2"
Glass Size = Order Size + 3/4"

**Style #105M**
Order Information:
Order Size = Inside Dimension of Frame (W x H)
Cutout Size = Order Size + 1 1/2"
Glass Size = Order Size + 3/4"
Frame includes 2 Frame & Glass Supports (See Page 3)

**Style #105**
Order Information:
Order Size = Inside Dimension of Frame (W x H)
Cutout Size = Order Size + 1"
Glass Size = Order Size + 3/4"

**Style #118M**
Order Information:
Order Size = Inside Dimension of Frame (W x H)
Cutout Size = Order Size + 2 1/8" (2 1/4" for glasses listed on Pg.8 & 11)*
Glass Size = Order Size + 1 5/16" (1" for glasses listed on Pg.8 & 11)*
Frame includes 2 Frame & Glass Supports (See Page 3)
*Frames on Pg. 8 & 11 include Setting Blocks.

**Style #118MSP (Patent Pending)**
Order Information:
Order Size = Inside Dimension of Frame (W x H)
Cutout Size = Order Size + 2 1/8"
Glass Size = Order Size + 1 5/16"

**Style #118**
Order Information:
Order Size = Inside Dimension of Frame (W x H)
Cutout Size = Order Size + 1 1/2" (1 1/2" for glasses listed on Pg.8 & 11)*
Glass Size = Order Size + 1 3/8" (1" for glasses listed on Pg.8 & 11)*
*Frames on Pg. 8 & 11 include Setting Blocks.

Glass Note: Laminated Glass NOT recommended.
3/4" PAINTED ALUMINUM-TAPE ON MULLIONS

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

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

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

5/8" PAINTED STEEL WELDED MULLIONS

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

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

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

1" TO 3" STEEL FORMED MULLIONS

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

UL LISTING
Door Light Frames with Aluminum or Steel Mullions carry the same UL Fire Rating as our Standard Frames when installed using a single sheet of listed glazing material. Aluminum mullions can be veneer wrapped (See Page 30) but carry NO Fire Rating. Steel mullions cannot be veneered.
3/4” Painted Aluminum Tape on Mullions

Mullions are attached to the glass with 1/2" x 1/32" Double sided Foam Tape

Material: Extruded Aluminum 3/4" square

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

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

Glass Max.

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

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

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

5/8” Painted Steel Welded Mullions

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

All joints wire welded and ground.

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

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

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

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

DOUBLE or TRIPLE GLAZED FRAMES

PATENT PENDING

STYLE #110-D2 Double Glazed (shown)
STYLE #110/#110B-T Triple Glazed

Order Size: Visible Dimensions of Center Pane (W x H)

Glass Size:
- Center Pane: Order Size \(+3/4\) in
- Outer Pane(s): Order Size \(-1/4\) in

Cutout Size: Order Size \(+1\) in

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

PATENT PENDING

STYLE #110-D1 Double Glazed (shown)

Order Size: Visible Dimensions of Frame (W x H)

Glass Size: Order Size \(+3/4\) in

Cutout Size: Order Size \(+1\) in

NO Fire Rating.

Glass Note: Laminated Glass NOT recommended.

FRAMES for LEAD LINED DOORS

STYLE #115-L1 for doors leaded under the skins or down the center. Patent #4,550,542

Order Size: Visible Dimensions of Center Pane (W x H)

Glass Size:
- Center Pane: Order Size \(+3/4\)
- Outer Pane(s): Order Size \(-3/8\)

Cutout Size: Order Size \(+5\) in

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

STYLE #115-L2 or #105M-L2 for doors leaded under the skins. Patent #4,550,542

Order Size: Visible Dimensions of Frame (W x H)

Glass Size: Order Size \(+3/4\)

Cutout Size: Order Size \(+1\) in

NO Fire Rating.

STYLE #115-L3 or #105-L3 for doors leaded down the center. Patent #4,550,542

Order Size: Visible Dimensions of Frame (W x H)

Glass Size: Order Size \(+3/4\)

Cutout Size: Order Size \(+7\) in

NO Fire Rating.

Glass Note: Laminated Glass NOT recommended.

Page 20 --- Pricing Page 21 is available by Email or FAX.
UL & WHI LISTED EDGE & ASTRAGAL SETS

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

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

* Standard finish is beige powder paint.
* All bevels are 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" Max. from ends and machined openings.
* AMS Machining Templates must be completed for each machined item (forms available on website).
* All items available in Stainless Steel.
Standard Edges are 20 GA. (.035) CRS
Astral Flanges are 16 GA. (.062) CRS

- #206 Beveled Edge (shown)
- #216 Square Edge (No Bevel)
- #227 Beveled Edge Machined w/Strike open to low side of bevel.
- #231 "L" Shaped Lock Edge Protector - Beveled
- #233 "L" Shaped Lock Edge Protector - Square

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

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

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

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

- Lead Lined Astragals
  #205L Std. Bevel (shown)
  Lead Lined Astragal #204L Square (No Bevel)
  Lead Lined Astragal #210L Reverse Bevel
  UL Listed to 60 Minutes
  WHI Listed to 20 Minutes

Listings apply to Astragal & Edge Sets ONLY

- Punchouts For 4½" or 5" Hinge Standard
- Hinge Edge Protectors
  Available in:
  20 GA. CRS Painted
  20 GA. or 18 GA. SS

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

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

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

Page 23

Pricing Pages 24 & 25 are available by Email or FAX
CONCEALED VERTICAL ROD 5\" METAL CHANNELS for WOOD DOORS

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

<table>
<thead>
<tr>
<th>AMS Part No.</th>
<th>Device Manufacturer</th>
<th>Series</th>
</tr>
</thead>
<tbody>
<tr>
<td>251</td>
<td>Von Duprin Series</td>
<td>9847/9947</td>
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<tr>
<td>252</td>
<td>Von Duprin Series</td>
<td>5547</td>
</tr>
<tr>
<td>253</td>
<td>Von Duprin Series</td>
<td>3347/3547</td>
</tr>
<tr>
<td>254</td>
<td>DORMA Device</td>
<td>4100/6100</td>
</tr>
<tr>
<td>255</td>
<td>Sargent Device</td>
<td>8600</td>
</tr>
<tr>
<td>256</td>
<td>Adams Rite Device</td>
<td>3900/8900</td>
</tr>
<tr>
<td>257</td>
<td>Yale Device</td>
<td>2160/7120/7160</td>
</tr>
<tr>
<td>258</td>
<td>Monarch/Falcon Devices</td>
<td>(F) 17-24-18-25-XX-C</td>
</tr>
<tr>
<td>260</td>
<td>Arrow Device</td>
<td>F3600</td>
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<tr>
<td>261</td>
<td>Corbin Russwin Device</td>
<td>5860</td>
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<tr>
<td>262</td>
<td>Precision Device</td>
<td>FL 1700/1700</td>
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<tr>
<td>263</td>
<td>Sargent Device</td>
<td>PP8600 &amp; PR8600</td>
</tr>
<tr>
<td>264</td>
<td>DORMA Device</td>
<td>9100</td>
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<td>265</td>
<td>Precision Device</td>
<td>FL 2700/2700</td>
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<td>266</td>
<td>DORMA Device</td>
<td>5100</td>
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<tr>
<td>267</td>
<td>Von Duprin Series</td>
<td>3347A/3547A</td>
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<tr>
<td>268</td>
<td>Sargent Device</td>
<td>WD 7000</td>
</tr>
<tr>
<td>269</td>
<td>Monarch/Falcon Centerslide Devices</td>
<td>(F) 17-24-18-25-XX-C</td>
</tr>
<tr>
<td>270</td>
<td>Black &amp; Decker Series</td>
<td>QED 100</td>
</tr>
</tbody>
</table>

20 GA. Galvanized Channel (.035) Adds an additional 1/32\" to the Edge of your door.

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

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

Page 26

Pricing Page 27 is available by Email or FAX.
STANDARD & "QUICK SHIP" SERVICES
Please specify ship date on each order.

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

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

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

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

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

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

EDGE & ASTRAGAL SETS

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

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

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

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

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

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

PHONE: 715-223-6324  FAX: 715-223-3352
UL LISTED with the same parameters as our standard products.

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

FINISH: Ready to stain and seal.

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

NOTE: Product for interior use ONLY.

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

TYPICAL INSTALLATION

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

CONDITIONS OF SALE

PRICES: Subject to change without notice.

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

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

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

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

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

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

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