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Machining and Coordination Information

Wood Door Technical Manual

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Notes
Machining and Coordination Information
Wood Door Technical Manual

Factory Coordination Information

Machining and Coordination Information

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1. Door Schedule — should include:
 - A. Sizes, type, core, lite/louver placements, veneer, door numbering system which is the same on all schedules, lite/louver moulding requirements, prefinish specifications and sample approval data order is factory finished, prefitting and beveling instructions including undercuts, labeling requirements.
 - B. In order to offer full warranty and label requirement, 5" (127mm) of core material is required between lite and lock cutouts.
2. Hardware Schedule
3. Hardware Templates or Template List
4. Frame Schedule
5. Hardware Location Sheets
 - A. Location Sheets
 - 1) Hinge Locations including hinge backset
 - 2) Strike locations for each type of lock being used - cylindrical, mortise, deadlock, hospital latch, etc.
6. Requested Ship Date
7. Ship to Address

Some of the items that are missed most often are:

- 1) Prefitting/beveling specifications including undercuts.
- 2) Complete hardware location information (frame location sheets/shop drawings).
- 3) Lite-lock conflict affecting full warranty or label authority.
- 4) Prefinish specifications and sample approval.
- 5) Hardware template list or templates.
- 6) Lite moulding requirements

What Can Legally Be Done in the Field?

NFPA-80 1999

1-3.4 Preparation. Preparation of fire door assemblies for locks, latches, hinges, remotely operated or remotely monitored hardware, concealed closers, glass lights, vision panels, louvers, and astragals and the application of plant-ons and laminated overlays shall be performed in accordance with the manufacturer's inspection service procedure and under Label Service.

Exception: *For Job site preparation of surface applied hardware, function holes for mortise locks, holes for labeled viewers, a maximum 3/4 in. (19-mm) wood and composite door undercutting, and protection plates (see 2-4.5) shall be permitted.*

Surface applied hardware is applied to the face of a door without removing material from the door other than drilling round holes through the face of the door to accommodate cylinders, spindles, similar operational elements, and through bolts. The holes shall not be permitted to exceed a diameter of 1 in. (25.4 mm) with the exception of cylinders.

NOTE 1: Doors ordered undercut from the factory may not accommodate 3/4" field undercutting. Check with manufacturer before proceeding.

NOTE 2: Effective approximately January 1, 1991, all machining for 20 minute doors must be performed under Label Service, except those procedures listed in Exception No. 1 above.

Fire Door Listings - Single Opening

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Single Door	20 Minute W Neutral	20 Minute A Positive	20 Minute B Positive	45, 60, 90 W Neutral		45, 60, 90 A Positive		45, 60, 90 B Positive	
Max. Width	4'0"	4'0"	4'0"	4'0"		4'0"		4'0"	
Max. Height	10'0"	9'0"	9'0"	10'0"		9'0"		9'0"	
Thickness	1-3/4"	1-3/4"	1-3/4"	1-3/4"		1-3/4"		1-3/4"	
Door/Transom									
Max. Height (opening)	10'0"	9'0"	9'0"	10'0"		9'0"		9'0"	
Transom Width	4'0"	4'0"	4'0"	4'0"		4'0"		4'0"	
Transom Height	3'4"	3'4"	3'4"	3'4"		3'4"		3'4"	
Straight Cut	X	X	X	X		X		X	
Rabbit Cut	X	NA	NA	X		NA		NA	
Dutch Door									
Max. Width	4'0"	NA	NA	* 4'0"		** 4'0"		** 4'0"	
Max. Height	8'0"	NA	NA	* 8'0"		** 8'0"		** 8'0"	
Top Leaf Height	4'0"	NA	NA	4'0"		** 4'0"		** 4'0"	
Bottom Leaf Height	4'0"	NA	NA	4'0"		** 4'0"		** 4'0"	
Shelf	X	NA	NA	X		NA		NA	
Core									
Particleboard	X	X	X						
Eng. Composite LSL	X	X	X						
Mineral Composite				X		X		X	
Agrifiber	X	X	X	45 Min. Only		45 Min. Only		45 Min. Only	
Stiles									
Wood	X	X	X						
Wood/LSL	X	X	X						
Wood/Firestop	OPT	OPT	OPT	X		X		X	
Rails									
Wood	X	X	X						
LSL	X	X	X						
Wood/Firestop						X			
Firestop	OPT	OPT	OPT	X		X		X	
Door Faces									
Wood Veneer	X	X	X	X		X		X	
Hardboard	X	X	X	X		X		X	
MDO	X	X	X	X		X		X	
HPDL	X	X	X	X		X		X	
Thermal Fused (LPDL)	X	X	X	X		X		X	
Options									
Lock Block	X	X	X	X		X		X	
Wide Top Rail	X	X	X	X		X		X	
Wide Bottom Rail	X	X	X	X		X		X	
Intermediate Rail	X	X	X	X		X		X	
Plant-ons	X	X	X	X		X		X	
Raceway 3/8"	X	X	X	X		X		X	
Wide Stile Back	X	X	X	X		X		X	
Added Fire Info.									
Temperature Rise	NA	NA	NA	250°		250°		250°	
Hosestream	X	X	X	X		X		X	
Lites - Standard									
				45 min.	60/90 Min.	45 min.	60/90 Min.	45 min.	60/90 Min.
Max. Width	36"	36"	36"	36"	10"	36"	10"	36"	10"
Max. Height	54"	54"	54"	54"	33"	54"	33"	54"	33"
Max. Area - square inch.	1296"	1296"	1296"	1296"	100"	1296"	100"	1296"	100"
Louvers									
Max. Width	NA	NA	NA	24"		24"		24"	
Max. Height	NA	NA	NA	24"		24"		24"	
Max. Area - square inch.	NA	NA	NA	576"		576"		576"	

* 45 & 60 Min. Only

** 60 Min. Only

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Fire Door Listings - Single Opening

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Single Door	20 Minute W Neutral	20 Minute A Positive	20 Minute B Positive	45, 60, 90 W Neutral	45, 60, 90 A Positive	45, 60, 90 B Positive
Hanging						
Mortise Hinge	X	X	X	X	X	X
Surface Hinge	X	X	X	X	X	X
Anchor Hinge	X	X	X	X	X	X
Pivot Hinge (offset only)	X	X	X	X	X	X
Continuous Hinge	X	X	X	X	X	X
Securing						
Min. Bolt Throw	1/2"	1/2"	1/2"	1/2"	1/2"	1/2"
Max. Cyl. Backset	5"	5"	5"	5"	5"	5"
Max. Mortise Backset	5"	5"	5"	5"	5"	5"
Max. Deadlock Backset	5"	5"	5"	5"	5"	5"
1 or 2 Point Latch	X	X	X	X	X	X
Surface Rim Exit Device	X	X	X	X	X	X
Mortise Rim Exit Device	X	X	X	X	X	X
Surface Vertical Rod	X	X	X	X	X	X
Conc. Vertical Rod*	X	X	X	X	X	X
Electric Lock	X	X	X	X	X	X
Closing						
Surface Closer	X	X	X	X	X	X
Conc. Arm Only	X	X	X	45, 60 Min. Only	45 Min. Only	45 Min. Only
Spring Hinges	X	X	X	X	X	X
Floor Closer	X	X	X	X	X	X
Electrci	X	X	X	X	X	X
Pneumatic	X	X	X	X	X	X
Protective						
Kick Plates	X	OPT	OPT	X	X	X
Surface Plates	48"	48"	48"	48"	48"	48"
Mortise Edge	X	NA	NA	X	NA	NA
Surface Edge	X	X	X	X	X	X
CVR Metal Edge	OPT	OPT	OPT	5"	5"	5"
Stops						
Overhead Arm Only	X	X	X	45, 60 Min. Only	45 Min. Only	45 Min. Only
Overhead Holder	NA	NA	NA	NA	NA	NA
Elect. Mag. Holder	X	X	X	X	X	X
Miscellaneous						
Viewers 1" max.	X	X	X	X	X	X
Drop Bottom Seal	X	X	X	X	X	X
Smoke Gasket - Surface	X	X	X	X	X	X
EPT	X	X	X	45, 60 Min. Only	45, 60, 90 Min.	45, 60, 90 Min.
Metal Vision Panel	X	X	X	X	X	X
Wood Vision Panel	X	X	X	NA	NA	NA
Fus. Link Louver	NA	NA	NA	X	X	X
Wood Louver	NA	NA	NA	NA	NA	NA

* Some LBR or CTL concealed exit devices are available without "door to floor" thermal bolts. Call factory.

Fire Door Listings - Paired Opening Machining and Coordination Information

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Pair	20 Minute			45, 60, 90		45, 60, 90		45, 60, 90	
	W Neutral	A Positive	B Positive	W Neutral	A Positive	A Positive	B Positive	B Positive	B Positive
Max. Width	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"
Max. Height	10'0"	9'0"	9'0"	9'0"	9'0"	9'0"	9'0"	9'0"	9'0"
Thickness	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"
Door/Transom									
Max. Height (opening)	10'0"	9'0"	9'0"	9'0"	9'0"	9'0"	9'0"	9'0"	9'0"
Transom Width	4'0"	4'0"	4'0"	4'0"	4'0"	4'0"	4'0"	4'0"	4'0"
Transom Height	3'4"	3'4"	3'4"	3'4"	3'4"	3'4"	3'4"	3'4"	3'4"
Straight Cut *	X	X	X	X	X	X	X	X	X
Rabbet Cut	NA	NA	NA	NA	NA	NA	NA	NA	NA
Dutch Door									
Max. Width	8'0"	NA	NA	NA	NA	NA	NA	NA	NA
Max. Height	8'0"	NA	NA	NA	NA	NA	NA	NA	NA
Top Leaf Height	4'0"	NA	NA	NA	NA	NA	NA	NA	NA
Bottom Leaf Height	4'0"	NA	NA	NA	NA	NA	NA	NA	NA
Shelf	X	NA	NA	NA	NA	NA	NA	NA	NA
Core									
Particleboard	X	X	X						
Eng. Composite LSL	X	X	X						
Mineral Composite				X		X		X	
Agrifiber	X	X	X	NA		NA		NA	
Stiles									
Wood	X	X	X						
Wood/LSL	X	X	X						
Wood/Firestop	OPT	X	X	X		X		X	
Rails									
Wood	X	X	X						
LSL	X		X						
Wood/Firestop							X		
Firestop	OPT	X	X	X		X		X	
Door Faces									
Wood Veneer	X	X	X	X		X		X	
Hardboard	X	X	X	X		X		X	
MDO	X	X	X	X		X		X	
HPDL	X	X	X	X		X		X	
Thermal Fused (LPDL)	X	X	X	X		X		X	
Options									
Lock Block	X	X	X	X		X		X	
Wide Top Rail	X	X	X	X		X		X	
Wide Bottom Rail	X	X	X	X		X		X	
Intermediate Rail	X	X	X	X		X		X	
Plant-ons	X	X	X	X		X		X	
Raceway 3/8"	X	X	X	X		X		X	
Wide Stile Back	X	X	X	X		X		X	
Added Fire Info.									
Temperature Rise	NA	NA	NA	250°		250°		250°	
Hosestream	X	X	X	X		X		X	
Lites - Standard									
				45 min.	60/90 Min.	45 min.	60/90 Min.	45 min.	60/90 Min.
Max. Width	36"	36"	36"	36"	10"	36"	10"	36"	10"
Max. Height	54"	54"	54"	54"	33"	54"	33"	54"	33"
Max. Area - square inch.	1296"	1296"	1296"	1296"	100"	1296"	100"	1296"	100"
Louvers									
Max. Width	NA	NA	NA	24"		24"		24"	
Max. Height	NA	NA	NA	24"		24"		24"	
Max. Area - square inch.	NA	NA	NA	576"		576"		576"	

* Requires use of horizontal and vertical transom bars

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Fire Door Listings - Paired Opening Machining and Coordination Information Wood Door Technical Manual

Pair	20 Minute W Neutral	20 Minute A Positive	20 Minute B Positive	45, 60, 90 W Neutral	45, 60, 90 A Positive	45, 60, 90 B Positive
Hanging						
Mortise Hinge	X	X	X	X	X	X
Surface Hinge	X	X	X	X	X	X
Anchor Hinge	X	X	X	X	X	X
Pivot Hinge (offset only)	X	X	X	X	X	X
Continuous Hinge	X	X	X	X	X	X
Securing						
Min. Bolt Throw	1/2"	1/2"	1/2"	1/2"	1/2"	1/2"
Max. Cyl. Backset	5"	5"	5"	5"	5"	5"
Max. Mortise Backset	5"	5"	5"	5"	5"	5"
Max. Deadlock Backset	5"	5"	5"	5"	5"	5"
1 or 2 Point Latch	X	X	X	X	X	X
Surface Rim Exit Device	X	X	X	X	X	X
Mortise Rim Exit Device	X	X	X	X	X	X
Surface Vertical Rod	X	X	X	X	X	X
Conc. Vertical Rod*	X	X	X	X	X	X
Electric Lock	X	X	X	X	X	X
Electric Strike	X	X	X	X	X	X
Closing						
Surface Closer	X	X	X	X	X	X
Conc. Arm Only	X	X	X	45, 60 Only	45 Only	45 Only
Spring Hinges	X	X	X	X	X	X
Floor Closer	X	X	X	X	X	X
Electrci	X	X	X	X	X	X
Pneumatic	X	X	X	X	X	X
Protective						
Kick Plates	X	OPT	OPT	X	X	X
Surface Plates	48"	48"	48"	48"	48"	48"
Mortise Edge	X	NA	NA	X	NA	NA
Surface Edge	X	X	X	X	X	X
CVR Metal Edge	OPT	OPT	OPT	5"	5"	5"
Stops						
Overhead Arm Only	X	X	X	45, 60 Only	45 Only	45 Only
Overhead Holder	NA	NA	NA	NA	NA	NA
Elect. Mag. Holder	X	X	X	X	X	X
Miscellaneous						
Viewers 1" max.	X	X	X	X	X	X
Drop Bottom Seal	X	X	X	X	X	X
Smoke Gasket - Surface	X	X	X	X	X	X
EPT	X	X	X	45, 60 Only	45, 60, 90	45, 60, 90
Metal Vision Panel	X	X	X	X	X	X
Wood Vision Panel	X	X	X	NA	NA	NA
Fus. Link Louver	NA	NA	NA	X	X	X
Wood Louver	NA	NA	NA	NA	NA	NA

* All SVR-LBR and CVR-LBR are going to require thermal pin preps as such.

20 & 45 min. panel - thermal pin going door to door.

60 & 90 min. panel - thermal pin going door to floor.

Additional thermal pins will be supplied by customer.

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Fire Door Listings - Double Egress Pair

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Double Egress Pair	20 Minute W Neutral	20 Minute A Positive	20 Minute B Positive	45, 60, 90 W Neutral		45, 60, 90 A Positive		45, 60, 90 B Positive	
Max. Width	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"
Max. Height	10'0"	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"	8'0"
Thickness	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"	1-3/4"
Door/Transom									
Max. Height (opening)	10'0"	9'0"	9'0"	9'0"	9'0"	9'0"	9'0"	9'0"	9'0"
Transom Width	4'0"	4'0"	4'0"	4'0"	4'0"	4'0"	4'0"	4'0"	4'0"
Transom Height	3'4"	3'4"	3'4"	3'4"	3'4"	3'4"	3'4"	3'4"	3'4"
Straight Cut *	X	X	X	X	X	X	X	X	X
Rabbet Cut	NA	NA	NA	NA	NA	NA	NA	NA	NA
Dutch Door									
Max. Width	8'0"	NA	NA	NA	NA	NA	NA	NA	NA
Max. Height	8'0"	NA	NA	NA	NA	NA	NA	NA	NA
Top Leaf Height	4'0"	NA	NA	NA	NA	NA	NA	NA	NA
Bottom Leaf Height	4'0"	NA	NA	NA	NA	NA	NA	NA	NA
Shelf	X	NA	NA	NA	NA	NA	NA	NA	NA
Core									
Particleboard	X	X	X						
Eng. Composite LSL	X	X	X						
Mineral Composite					X	X	X	X	X
Agrifiber	X	X	X	NA	NA	NA	NA	NA	NA
Stiles									
Wood	X	X	X						
Wood/LSL	X	X	X						
Wood/Firestop	OPT	X	X	X	X	X	X	X	X
Rails									
Wood	X	X							
LSL	X								
Wood/Firestop						X	X	X	X
Firestop	OPT	X	X	X	X	X	X	X	X
Door Faces									
Wood Veneer	X	X	X	X	X	X	X	X	X
Hardboard	X	X	X	X	X	X	X	X	X
MDO	X	X	X	X	X	X	X	X	X
HPDL	X	X	X	X	X	X	X	X	X
Thermal Fused (LPDL)	X	X	X	X	X	X	X	X	X
Options									
Lock Block	X	X	X	X	X	X	X	X	X
Wide Top Rail	X	X	X	X	X	X	X	X	X
Wide Bottom Rail	X	X	X	X	X	X	X	X	X
Intermediate Rail	X	X	X	X	X	X	X	X	X
Plant-ons	X	X	X	X	X	X	X	X	X
Raceway 3/8"	X	X	X	X	X	X	X	X	X
Wide Stile Back	X	X	X	X	X	X	X	X	X
Added Fire Info.									
Temperature Rise	X	X	X	250°		250°		250°	
Hosestream	X	X	X	X		X		X	
Lites - Standard									
				45 min.	60/90 Min.	45 min.	60/90 Min.	45 min.	60/90 Min.
Max. Width	36"	36"	36"	36"	10"	36"	10"	36"	10"
Max. Height	54"	54"	54"	54"	33"	54"	33"	54"	33"
Max. Area - square inch.	1296"	1296"	1296"	1296"	100"	1296"	100"	1296"	100"
Louvers									
Max. Width	NA	NA	NA	24"		24"		24"	
Max. Height	NA	NA	NA	24"		24"		24"	
Max. Area - square inch.	NA	NA	NA	576"		576"		576"	

* Required use of horizontal and vertical transom bars

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Fire Door Listings - Double Egress Pair

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Double Egress Pair	20 Minute W Neutral	20 Minute A Positive	20 Minute B Positive	45, 60, 90 W Neutral	45, 60, 90 A Positive	45, 60, 90 B Positive
Hanging						
Mortise Hinge	X	X	X	X	X	X
Surface Hinge	X	X	X	X	X	X
Anchor Hinge	X	X	X	X	X	X
Pivot Hinge (offset only)	X	X	X	X	X	X
Continuous Hinge	X	X	X	X	X	X
Securing						
Min. Bolt Throw	1/2"	1/2"	1/2"	1/2"	1/2"	1/2"
Max. Cyl. Backset	5"	5"	5"	5"	5"	5"
Max. Mortise Backset	5"	5"	5"	5"	5"	5"
Max. Deadlock Backset	5"	5"	5"	5"	5"	5"
1 or 2 Point Latch	X	X	X	X	X	X
Surface Rim Exit Device	X	X	X	X	X	X
Mortise Rim Exit Device	X	X	X	X	X	X
Surface Vertical Rod	X	X	X	X	X	X
Conc. Vertical Rod*	X	X	X	X	X	X
Electric Lock	X	X	X	X	X	X
Electric Strike	X	X	X	X	X	X
Closing						
Surface Closer	X	X	X	X	X	X
Conc. Arm Only	X	X	X	45, 60 Only	45 Only	45 Only
Spring Hinges	X	X	X	X	X	X
Floor Closer	X	X	X	X	X	X
Electric	X	X	X	X	X	X
Pneumatic	X	X	X	X	X	X
Protective						
Kick Plates	X	X	X	X	X	X
Surface Plates	48"	48"	48"	48"	48"	48"
Mortise Edge	X	NA	NA	X	NA	NA
Surface Edge	X	X	X	X	X	X
CVR Metal Edge	OPT	OPT	OPT	5"	5"	5"
Stops						
Overhead Arm Only	X	X	X	45, 60 Only	45 Only	45 Only
Overhead Holder	NA	NA	NA	NA	NA	NA
Elect. Mag. Holder	X	X	X	X	X	X
Miscellaneous						
Viewers 1" max.	X	X	X	X	X	X
Drop Bottom Seal	X	X	X	X	X	X
Smoke Gasket - Surface	X	X	X	X	X	X
EPT	X	X	X	45, 60 Only	45, 60, 90	45, 60, 90
Metal Vision Panel	X	X	X	X	X	X
Wood Vision Panel	X	X	X	NA	NA	NA
Fus. Link Louver	NA	NA	NA	X	X	X
Wood Louver	NA	NA	NA	NA	NA	NA

* All SVR-LBR and CVR-LBR are going to require thermal pin preps as such.

20 & 45 min. panel - thermal pin going door to door.

60 & 90 min. panel - thermal pin going door to floor.

Additional thermal pins will be supplied by customer.

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Obtaining Machining Authority

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ASSA ABLOY Wood Doors manufactures and machines doors utilizing authorities established by Warnock Hersey International. Warnock Hersey International is a certified testing facility, recognized and accepted by all major building code organizations such as ICBO, BOCA, and Southern Building Congress, and local authorities. Authority to machine fire doors outside the manufacturing facility may be granted by Warnock Hersey International. This authority may be granted to customers and distributors of products manufactured by ASSA ABLOY Wood Doors upon completion of the following procedures:

1. A written request to ASSA ABLOY Wood Doors to release our machining authority must be submitted.
2. Upon release of the machining authority by ASSA ABLOY Wood Doors, Warnock Hersey will forward the necessary application forms and requirements directly to the applicant.
3. Upon completion of the application, an inspection will be scheduled by Warnock Hersey.
4. After satisfactory inspection Warnock Hersey will release the machining authorities and order the necessary labels.

Door Code Chart

Machining and Coordination Information

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Any information not provided on code or type chart is considered a special instruction. Missing information may delay the order.

1. Quantity		9. Species	
Enter quantity of doors required for this line		<u>Description</u>	<u>Code</u>
2. ID Mark		"A" Plain Sliced Red Oak	SRO
Enter any identification mark(s) for this line (10 characters or less)		"A" Rift Red Oak	RRO
3. Series		"A" Plain Sliced White Oak	SWO
<u>Description</u>	<u>Code</u>	"A" Rift White Oak	RWO
Graham Supreme Door	GSD	"A" Rotary Natural Birch	RNB
Graham Premium Door	GPD	"A" Rotary Select White Birch	RWB
Graham Custom Door	GCD	"A" Plain Sliced Natural Birch	SNB
Maiman Thermal Fused	MTF	"A" Plain Sliced Select White Birch	SWB
4. Construction		"A" Flat Cut Mahogany	FCM
<u>Description</u>	<u>Code</u>	"A" Plain Sliced Cherry	PSC
Particleboard Core	PC	"A" Plain Sliced Black Walnut	PSW
Agrifiber Core	AF	Medium Density Overlay	MDO
Engineered Composite Core	EC	Primed Hardboard	PHR
Fire Door Core	FD	Paint Grade Birch	PBR
Acoustical Core	AC	<u>Sketch Door™ Species</u>	
Hollow Core	HC	Metropolitan Collection	
5. Additional Information		Plain Sliced Cherry	H01
<u>Description</u>	<u>Code</u>	Plain Sliced Red Oak	H02
Sketchface Door	S	Quarter Sliced Red Oak	H03
Acoustical Door	A	Plain Sliced White Birch	H04
3-Ply High Pressure Decorative Laminate	PL3	Plain Sliced White Oak	H05
5-Ply High Pressure Decorative Laminate	PL5	Rift White Oak	H06
6. Edge Construction		<u>Provence Collection</u>	
<u>Description</u>	<u>Code</u>	Plain Sliced Cherry	V01
Edgebanded (available GSD & GPD Only)	5	Plain Sliced Red Oak	V02
Hardwood Edges	7	Quarter Sliced Red Oak	V03
7. Label		Plain Sliced White Birch	V04
All ASSA ABLOY Wood Doors fire rated products are listed and labeled under authorities extended to ASSA ABLOY Wood Doors by Warnock Hersey.		Plain Sliced White Oak	V05
<u>Description</u>	<u>Code</u>	Rift White Oak	V06
Neutral Pressure		<u>Colonial Collection</u>	
Factory Machined	W	Plain Sliced Cherry	T01
Machined under field label authority	N	Plain Sliced Red Oak	T02
Positive Pressure Category "A"		Quarter Sliced Red Oak	T03
Factory Machined	A	Plain Sliced White Birch	T04
Machined under field label authority	J	Plain Sliced White Oak	T05
Positive Pressure Category "B"		Rift White Oak	T06
Factory Machined	B	Custom Designs	
Machined under field label authority	M	SCU	
8. Rating		<u>Laminate</u>	
<u>Description</u>	<u>Code</u>	-Customer must provide manufacturer, model/SKU, and finish code	
20 minute (PC, AF, SL, or EC cores only)	20	-Example: WilsonArt/Asian Sun/7951	
45 minute (FD core only)	45		
60 minute (FD core only)	60		
90 minute (FD core only)	90		
Sound Transmission Class 29	S29		
Sound Transmission Class 30	S30		
Sound Transmission Class 31	S31		
Sound Transmission Class 35	S35		
Sound Transmission Class 41	S41		
Sound Transmission Class 42	S42		
Sound Transmission Class 46	S46		
		10. Face Type	
		<u>Description</u>	<u>Code</u>
		Flush	F
		Flush with Narrow Vision	FNV
		Flush Full Glass	FG
		Flush Full Louver	FGL
		Special Face Type (by special drawing)	FFD
		For more detailed Face Types, see Face Type Chart	

Door Code Chart

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11. Moulding

In the case of multiple lites, louvers or combinations, the moulding profile will be uniform to all cutouts unless otherwise specified. Graham will supply louvers as indicated by the code unless otherwise specified. All glazing mouldings are sized for use with 1/4 inch thick glazing materials. Custom profile mouldings will be subject to special tooling charges.

<u>Description</u>	<u>Code</u>
M2G - lip, all glass cutouts only	2
M3G - beveled lip, all glass cutouts only	3
M6G - flush, all glass cutouts only	6
L1900 - fusible link louver	F
M110 - metal vision panel, all cutouts	Z
M2L - 20 minute beveled lip, all glass cutouts	2L
M2F - 20 minute flush	2F
M2W - lip / wood louver	2W
M6W - flush / wood louver	6W
M2M - lip / metal louver	2M
M6M - flush / metal louver	6M
M2G - lip lite / metal framed louver	2S
M2G - lip lite / wood framed louver	2T
M3G - beveled lip lite / metal framed louver	3S
M3G - beveled lip lite / wood framed louver	3T
M6G - flush lite / metal framed louver	6S
M6G - flush lite / wood framed louver	6T
L600F - metal framed louver core, all cutouts	S
L100F - wood framed louver core, all cutouts	T
Different profile (requires special instructions)	DP
Cutout only (provide actual cutout size)	CO
Flat wood astragal	FWA

12. Width

Dimensions are to be entered on the order form in nominal feet and inches.

Standard clearance for prefit with = 1/8" each stile or 1/4" total for single doors or pairs with metal edges. Pairs without metal edges have a standard clearance of 3/32" each stile or 3/16" total. Any requirements other than those listed need to be identified in special instructions or on a machining sheet.

12	
WIDTH	
FT	IN
3	0
2	4

13. Height

Dimensions are to be entered on the orderform in nominal feet and inches.

Standard clearance for prefit height = 1/8" top, 5/8" bottom or 3/4" total. Bottom clearance will vary only by frame manufacturer's standard, special instruction or machining sheet .

13	
HEIGHT	
FT	IN
7	0
8	6

14. Thickness

<u>Description</u>	<u>Code</u>
1 3/8"	8
1 3/4"	4
2 1/4"	2

15. Hand

<u>Description</u>	<u>Code</u>
Right hand hinged	R
Left hand hinged	L
Right hand reverse hinged	RR
Left hand reverse hinged	LR
No hand	NH

16. Bevel

<u>Description</u>	<u>Code</u>
Bevel both stile edges	3/3
Bevel lock stile edge only	3L
Bevel hinge stile edge only	3H
No bevel, square edges (allows prefit)	0
Full and square (overrides standard prefit)	FS

17. Frame Manufacturer

<u>Description</u>	<u>Code</u>
CURRIES	CU
Ceco	C
Dittco	DI
Amweld	A
Mesker	M
Steelcraft	S
Pioneer	PI
Republic	RE
Timely	TI
Dean Steel	DS
Rediframe	RD
Special, Existing	SP
No Machining	NM

18. Hinge

<u>Description</u>	<u>Weight</u>	<u>Code</u>
1 Pair, 3 1/2	.123	352
1 1/2 Pair, 3 1/2	.123	353
2 Pair, 3 1/2	.123	354
1 Pair, 4	.130	402
1 1/2 Pair, 4	.130	403
2 Pair, 4	.130	404
1 Pair, 4 1/2	.134	452
1 1/2 Pair, 4 1/2	.134	453
2 Pair, 4 1/2	.134	454
1 Pair, 4 1/2	.180	H452
1 1/2 Pair, 4 1/2	.180	H453
2 Pair, 4 1/2	.180	H454
1 Pair, 5 x 4 1/2	.146	502
1 1/2 Pair, 5 x 4 1/2	.146	503
2 Pair, 5 x 4 1/2	.146	504
1 Pair, 5 x 4 1/2	.190	H502
1 1/2 Pair, 5 x 4 1/2	.190	H503
2 Pair, 5 x 4 1/2	.190	H504
Blank - No Prep		G19
Top Pivots		PTT
Bottom Pivots		PTB
Pivot Sets		PTS
intermediate Pivots		PTM
Pocket Pivots		PTP
Anchor Hinge		HGA
Full height continuous hinge		Specify manufacturer and model

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Door Code Chart

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19. Set

Description	Code
Set of 2 bifold panels	2P
Set of 4 bifold panels	4P
Standard grain match pair	2D
Double egress grain match pair	2E
Set of 2 bifold panels with hardware	2B
Set of 4 bifold panels with hardware	4B
Set of 3 grain matched	3
Set of 4 grain matched	4
Single door with transom	T
Single door with side panel	SF

*All standard transom units are continuous grain matched to the door. End grain matching is available as an option in GSD, GPD or GCD constructions only. Any door and transom combination which exceeds 10'0" in total combined height will require end grain matching.

20. Group / Pairing

Description	Code
Start the set here	<
Set continues	*
Stop the set here	>
Start and stop the set	<>

21. Deadlock

Place "Y" (yes) in top half of the box if the lock used is a deadlock. If used on a fire rated door the deadlock must be self-latching. In bottom half of box, specify height above finish floor.

22. Lock / Strike / Flushbolts

Description	Code
Cylindrical & Mortise Locks	
Note: 2 3/4" backset is standard. Specify if other	
Gov't 160 Mod 1" x 2 1/4" face x 2 3/4" B.S.	G1
Gov't 161* (or 2 1/8" face bore deadlock)	G2
*If used as deadlock place "Y" in column 21 and indicate height above finished floor (standard is 48" AFF if left blank).	
Gov't 161 (Lever thrubolt prep)	G2A
Gov't 86 Escutcheon Trim (1 3/4" min. width trim)	G3
Gov't 86 Edge (pocket) only	G3AE
Gov't 86 Sectional trim	G3A
Card Lock - mortised	CDLM
Card Lock - cylindrical	CDLC
Mortise Deadlock	G17
Cylindrical Deadlock	G16
Roller Latch	RL
Hospital Latch - cylindrical	HSPC
Hospital Latch - mortise	HSPM
Lock Blank	G19
Unit Locks	
Unit Locks (Specify Manufacturer & Location)	G6

Exit Devices

Rim	G11
Rim vertical rod	G11A
Mortise	G12
Concealed vertical rod	G12A
SARGENT PP & PR device	G14C
Push Pull	G18
Push Pull Bar	G18A
Flush Pull	FPM
Trim	
Dummy Trim	DT
Dummy Trim / Edge Prep	DTE

Strikes

4 7/8" Strike with Lip	E1
2 3/4" Strike with Lip	E2
3 1/2" Strike without Lip (Deadlock)	E3
2 3/4" Strike without Lip (Deadlock)	E4
Electric Strike	E9
4 7/8" No Lip	E1B
Open Back	OBS
Miscellaneous Strikes	STR
Concealed Hold / Stop	CH
Electric Power Transfer	EPT
Electric Raceway	RW
Door Bottom	DB

Advise Lock, Function and Type of Strike

Flushbolts

Top Down 12" Up 12"	H1
Top Down 24" Up 12"	H124
Top Down 36" Up 12"	H136
Surface Bolts	SB
Flushbolts (non ANSI)	FB
Corner Mount	H7

23. Hardware Manufacturer

Description	Code
Alarm Lock	AL
Adams-Rite	AD
ARROW	AW
Best	BE
Cal Royal	CA
Door Controls Int.	DC
Dorma	DO
Falcon	FA
Glynn Johnson	GJ
Hager Hinge	HA
HES	HS
Ives	IV
Locknectics	LO
Monarch (Wood)	MO
PDQ Hardware	PQ
Precision	PR
Corbin Russwin	RU
Rockwood	RD
SARGENT	SA
Securitron	SU
Schlage	SC
Simplex	SI
Tesa	TE
Trimco	TC
Vingcard	VI
Von Duprin	VD
Von Duprin (Wood)	VW
Yale	YA

Door Code Chart

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24. Lock Series / Function

Specify the manufacturers' lock series and function number

25. Trim

Specify the manufacturers' outside trim code

26. Mullion

Specify the manufacturers' mullion number when used with sets

27. Edge

<u>Description</u>	<u>Code</u>
Double Metal Edge - 1" machined	DE
Double Metal Edge - 1" unmachined	DB
Astragal and Edge - 1" machined	AE
Astragal and Edge - 1" unmachined	AB
Double Metal Edge - 5" machined	CE
Double Metal Edge - 5" unmachined	CB
Wood Flat Astragal unmachined	WA

28. Prefinish

<u>Description</u>	<u>Code</u>
Primed - 6 Sides	PR6
Sealed - 6 Sides	SL6
Sealed - Top and Bottom	STB
Clear	100
Fallow	125
Barley	175
Spiced Walnut	200
Zin	225
Copper	250
Russet	275
Medium Brown	300
Rose	325
Cocoa	350
Hazel	375
Corsica	380
Dark Walnut	400
Cactus	425
Medium Red	500
Umber	550
Wheat	600
Buff	625
Sandy	650
Apricot	675
Dark Brown	700
Auburn	775
Dark Red	800
Midnight	850
Burgandy	901
Cayenne	902
Ochre	925
Sedona	950
Custom	CST

29. Blocking Profile

See Blocking Profile Chart

30. Special Hardware Elevation

Use this field when referencing an elevation on a Graham machining sheet.