

Machining Templates for Edge & Astragal Sets

Included is a new set of Machining Templates dated 8/15/03 for our Edge & Astragal Sets, T-Astragals, Lock and Hinge Edge Protectors and Dutch Door Edge & Astragal Sets. Please destroy all old versions and use these new templates ONLY. Keep this set as your originals and <u>make copies as needed</u>.

The new templates combine several different Edge & Astragal Sets onto one template. There are now only five (5) template sets which make up the twelve (12) standard Edge & Astragal Sets we manufacture. Each set has two (2) templates, a LH/RHR template and a RH/LHR template. The following steps can be used to select and complete the correct template.

 Determine if your pair of doors are Parallel Beveled. Most Double Egress openings use Parallel Beveled doors. If this is not the case go to ITEM #2. If this is true:

Determine whether the Lock or Strike is on the leaf with the Astragal Lip. If the Strike is on the Astragal Leaf select the templates for the #209/#225 Set otherwise select the templates for the #209A/#225A Set which have the Lock on the Astragal Leaf. Proceed to ITEM #4.

- 2. If your opening does NOT require the use of an Astragal Lip select the template set for the Styles #208/#223/#224 and proceed to ITEM #4, otherwise go to ITEM #3.
- If the Astragal Lip should be located on the hinge side of the doors.
 Select the template set for the Styles #211/#217A/#218/#226.
 otherwise

You require the template set for the Styles #207/#212/#217/#219. Proceed to ITEM #4.

- 4. At this point you now have only two (2) templates to choose from, either the LH/RHR template or the RH/LHR template. To determine the correct handing study the overhead door swing views on each template and circle the correct door movement. You have now selected the correct template.
- 5. If you are familiar with our Style numbers, check the box at the top of the form for the set you require. We included a chart on Page 4 showing the various Styles, refer to this Chart to help you select the correct Style number. If you are still not sure which is the correct Style number each template has Check Boxes next to each leaf for indicating if that leaf is square rather than Beveled. From this information we can determine the correct Style number.

- 6. Each template now has two (2) Strikes and two (2) Locks for your convenience. The top Strike and Lock should ONLY be used if you have two Strikes and Locks. Check the boxes for the correct Lock and Strike Punchouts or check the template box and provide a detail sheet with your Order. Complete the dimensions for the Strike and Lock in the boxes provided. Remember these dimensions are from the top of the door down to the Center Line of the Punchout. Please double check the offset between the Strike and Lock. That is the most common error we find on templates.
- 7. If you require Flushbolts select the correct Flushbolt from the Table or check the Other Box and provide a detail sheet with your Order. Complete the boxes for the Top and Bottom flushbolts as needed. If your flushbolt has a 12", 24", etc. rod we need the dimension from the bottom or top of the channel to the Center Line of the punchout. For any other flushbolt we need the dimension from the bottom or top of the channel to the end of the punchout.

EXAMPLE: An Automatic Flushbolt that has a 1" x 9" plate will usually have a dimension from the top or bottom of the channel to the end of the punchout of 9". That is the dimension we require. Sometimes this dimension will vary dependent on the placement of the flushbolt in the door or if it is a retrofit application. A Manual Flushbolt that has a 1" x 6-3/4" plate and a 12" rod will usually have a dimension of 12" from the top or

bottom of the channel to the <u>Center Line of the punchout</u>. In this case we are looking for the 12" dimension.

Record the dimension in each box that applies. Next, put an arrow point at the Center Line or at the end of the punchout to indicate that your dimension is from the top or bottom of the channel to that point.

8. Make sure you complete the OVERALL LENGTH box.

9. OTHER SELECTIONS:

FINISH: Beige Po

Beige Powder Paint is our standard finish. We also offer a Gray and Dark Bronze Powder Paint as standard finishes. You can also request a Special Color. Special Colors are either powder paint or air dried lacquer dependent on color. You must provide a Color Chip with your Order when requesting a Special Color. If you check the veneer box you must indicate the species and slice in the space provided. Please be advised that we are limited to the species and slice our supplier can provide. If you select NO PAINT you must select Galvanized or Stainless Steel material. We will not be responsible for Cold Roll Steel Channels with No Paint.

DOOR SIZE: At

At the top of the Dimension area you can mark the Door Size. If NOT marked we assume the Door to be 1-3/4". Be sure you know your actual door thickness. Many doors are sold as 1-3/4" Doors but will actually measure 1-13/16" or more. Our channels are designed to fit very tightly so they do not rattle as the years pass. Our channels will not fit a door that measures over 1-3/4". If you suspect your doors may be heavy have the channels manufactured for 1-13/16" or more. The cost is nominal when compared to replacing them in the field.

SPECIAL MATERIAL: We have provided an area to specify if the channel set is to be made of

Special Material. If you require special material mark the correct material selection and include the Gage of the edge material required. 20 Gage is standard for channels, however 18 Gage and 16 Gage material is available. Astragals are 16 Gage unless you request a special gage.

LEAD LINED ASTRAGALS:

Where applicable we have included a section for Lead Lined Astragals. If you are ordering a Lead Lined Astragal check the box, give us the desired lip width. If not specified the lip width will be 1-3/4". Also you can choose between 1/16" or 1/8" lead. If not specified 1/16" lead is standard.

Please NOTE:

A Lead Lined Astragal flange cannot be notched.

NOTCHED ASTRAGAL LIPS: On sets where the lock is located on the channel with the Astragal Lip we have included a Check Box for you to indicate you want the Astragal Lip notched so the Strike Lip on the opposite door can pass through without interference. This is an option, standard practice is to cut the strike lip off. The size and placement of the notch is determined by the size and CL of the Strike Lip. If you are ordering a complete set we know the size and placement from the Strike detail. In this case if you want the Astragal lip notched you only need to check the box provided. If you are only ordering the Astragal leaf ONLY then we need to know the size of the Strike Lip (3-3/8", 1-1/2", etc.) and the CL of the Strike. In this case check the box for NOTCHED LIP and provide the Strike Lip Length in the space provided and put the CL dimension for the Strike in the Strike CL Box.

OTHER TEMPLATES: We have included templates for Ordering T-Astragals, Lock and Hinge Edge Protectors in either full "U" channels or in

> "L" channels. We also included some special templates for Spring Bolts and Panic Hardware Devices. Included also are templates for Edge and Astragal Sets for Dutch Doors.

10. Complete the information section of the form and submit it with your purchase order and any other detail sheets. Please do not send us a Purchase Order for machined Edge and Astragals without a completed Machining Template. We cannot process your Order until we receive the completed template.

We hope this information will be helpful. If you have any questions or require assistance in completing these forms please call and ask for Customer Service.

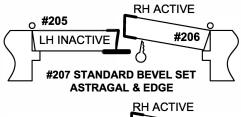
Thank You for your business.

ALL METAL STAMPING, INC.

715-223-6324 411 W. Spruce Street, P.O. Box 485 FAX: 715-223-3352 Abbotsford, WI. 54405-0485 www.allmetalstamping.com

UL LISTED EDGE & ASTRAGAL SETS

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





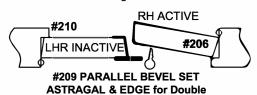
#208 DOUBLE EDGE SET - BEVELED (Shown)

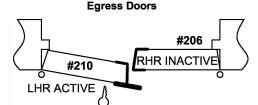
#223 DOUBLE EDGE SET - SQUARE (#216 + #216)

#224 1 SQUARE/1 BEVELED (#216 + #206)

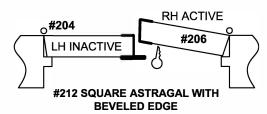
#225 EDGE SET-PARALLEL BEVELED (#227 + #206)

#225 for Double Egress Doors



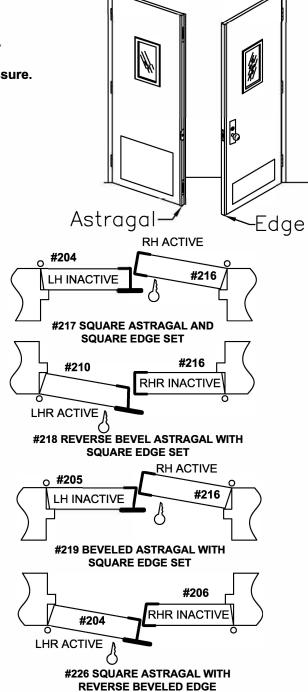


#211 REVERSE BEVEL SET ASTRAGAL & EDGE



OTHER ITEMS

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



- * Standard finish is beige powder paint.
- * All bevels are $\frac{1}{8}$ " in 2".
- * Punched and coined for #8 X $\frac{3}{4}$ " Phillips Flat Head Screws (included).
- * Hole Centers 12" or less, 3½" 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.

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715-223-6324

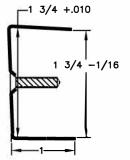
ALL METAL STAMPING, INC.

411 W. Spruce Street, P.O. Box 485 Abbotsford, WI. 54405-0485

FAX: 715-223-3352

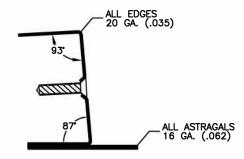
EDGE & ASTRAGAL SPECIFICATIONS

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



#206 Beveled Edge (shown) #216 Square Edge (No Bevel) -1 3/4

#205 Std. Beveled Astragal



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

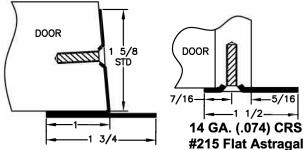
#227 Beveled Edge Machined w/Strike open to low side of bevel.

#231 "L" Shaped Lock Edge Protector - Beveled

#233 "L" Shaped Lock Edge Protector - Square

"T", "Z" & Flat Astragals

No Fire Ratings

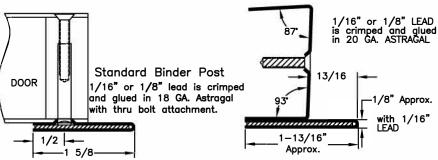


18 GA. (.048) CRS Edge/16 GA. (.062) Astragal #229 "T" Astragal - Reverse Bevel (shown)

#213 "T" Astragal - Beveled

#214 "T" Astragal - Square

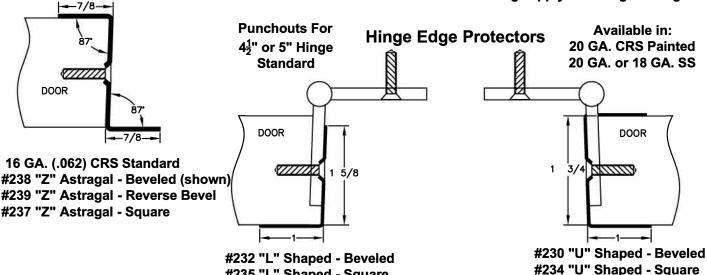
Lead Lined Astragals



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

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

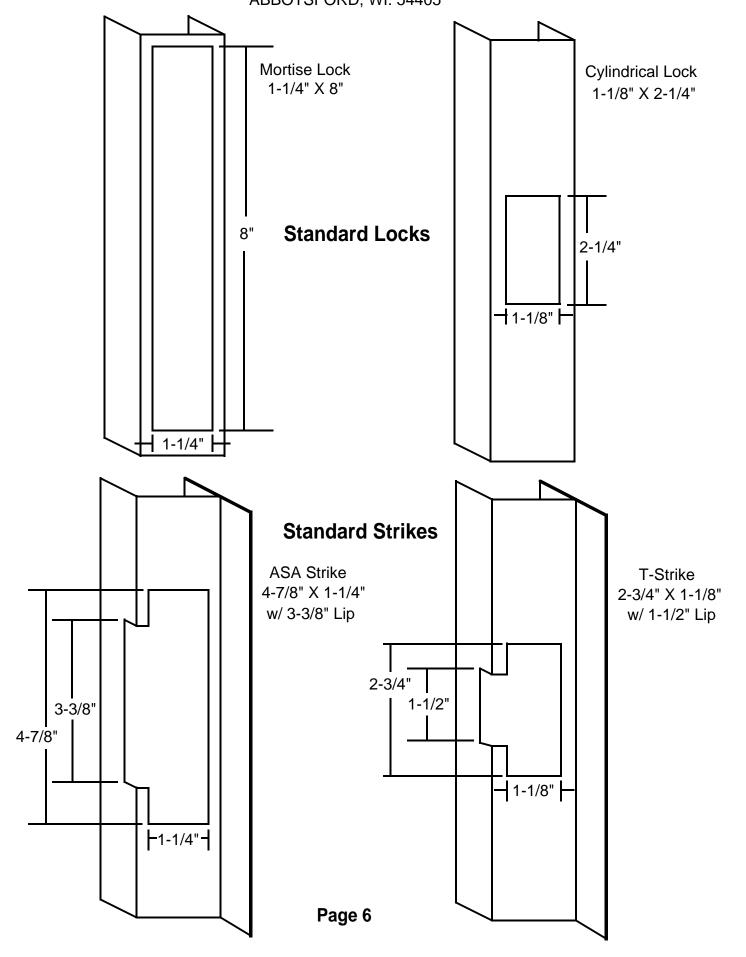
Listings apply to Astragal & Edge Sets ONLY



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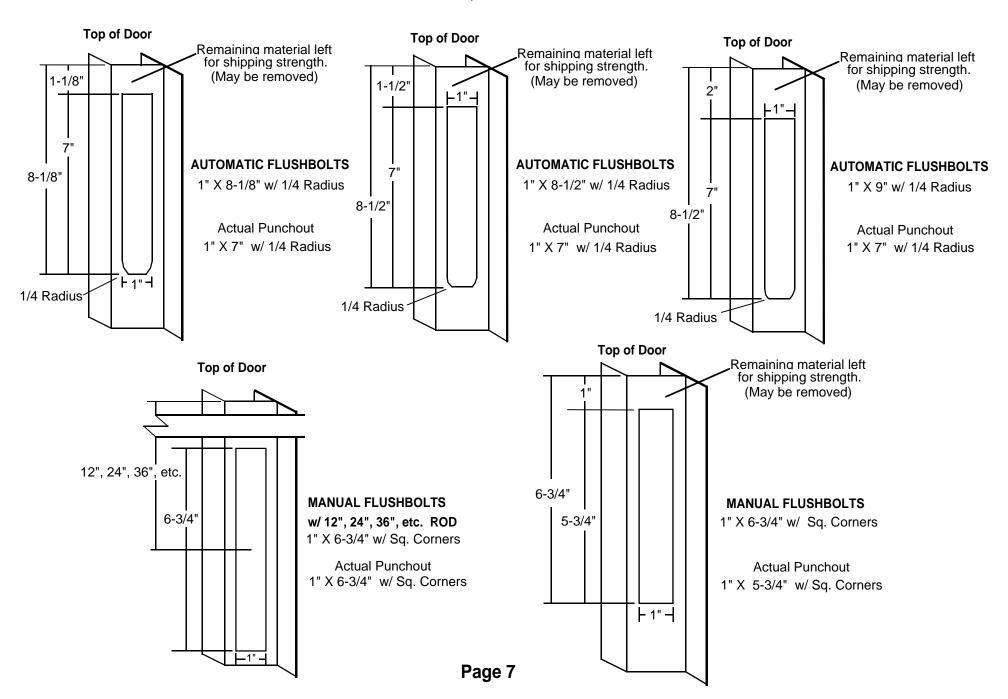
#235 "L" Shaped - Square

ALL METAL STAMPING, INC. 411 W. SPRUCE ST. ABBOTSFORD, WI. 54405



STANDARD FLUSHBOLTS

ALL METAL STAMPING, INC. 411 W. SPRUCE ST. ABBOTSFORD, WI. 54405



8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 FAX: 715-223-3352 715-223-6324 Please Check One:

207

212

217

219 LH/RHR ACTIVE DOOR #: _____ CUSTOMER: P.O.: _____ DATE: _____ ACCESSORY ITEM #: _____ DOOR ITEM: _____ __ NO. of SETS REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ □ STD. BEIGE □ SPECIAL COLOR: _____ □ NO PAINT □ VENEER: _____ LH ACTIVE RHR ACTIVE ☐ LEAD LINED ASTRAGAL RH INACTIVE LHR INACTIVE LIP WIDTH: KEY SIDE -☐ 1/16" LEAD ☐ 1/8" LEAD KEY SIDE ALL DIMENSIONS ARE FROM TOP OF DOOR. **INACTIVE DOOR** ACTIVE DOOR DOOR: 1-3/4" 1-13/16" OTHER: SQUARE <----- SQUARE LOCK STRIKE CL 1-1/8 X 2-1/4 4-7/8 X 1-1/4 W/3-3/8 LIP 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP TOP TEMPLATE# TEMPLATE# <----> 2nd STRIKE/LOCK ----> CL CL-LOCK STRIKE 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP 1-1/4 X B 2-3/4 X 1-1/8 w1-1/2 LIP CL TEMPLATE # * MFL TEMPLATE #____ * MFR SPECIAL Actual MATERIAL OAL Cutout **FLUSHBOLTS** Size GALV. Flushbolts with 12, 24, Auto. 356 1 x 8-1/8 w/1/4 radius etc., rods give S.S. 1 x 7 dimension to 1 x 8-1/2 w/ 1/4 radius Automatic CL, for all BOTTOM CRS 1 x 7 others give Automatic 1 x 9 w/ 1/4 radius dimension 1 x 5-3/4 1 x 6-3/4 w/sq. corners from end of Manual 358 CL-GAGE: ____ channel to Manual 1 x 6-3/4 w/sq. 12",24",etc. rod 1 x 6-3/4 end of cutout. Other (*) This Information is for MACHINING REFERENCE ONLY

715-223-	
	207 □ 212 □ 217 □ 219 RH/LHR ACTIVE
CUSTOMER:	DOOR #:
P.O.:	DATE:
The state of the s	
ACCESSORY ITEM	#: DOOR ITEM:
NO. of SETS REQ.:	DATE REQ.: DRAWN BY:DATE:
□ STD. BEIGE □ SP	PECIAL COLOR: DNO PAINT VENEER:
LHR ACTIVE KEY SIDE	RHR INACTIVE LEAD 1/8" LEAD LINED ASTRAGAL LIP WIDTH: LH INACTIVE KEY SIDE
INACT	ALL DIMENSIONS ARE FROM TOP OF DOOR. ACTIVE DOOR ACTIVE DOOR
	DOOR: □ 1-3/4" □ 1-13/16" □ OTHER: □ SQUARE <mark channel="" for="" square=""> SQUARE □</mark>
TOP CL-	STRIKE
CL * MFL	□ 2-3/4 X 1-1/8 w1-1/2 LIP □ 1-1/4 X 8 □ CL
OAL	FLUSHBOLTS Actual Cutout Size Flushbolts Flushbolts GALV.
-	Auto. 356 1 x 8-1/8 w/ ¹ / ₄ radius 1 x 7 with 12, 24, etc., rods give dimension to S.S.
воттом	CL, for all
	Automatic 1 x 9 w/ 4 radius dimension dimension 1 x 5-3/4 from end of
CL	Manual 1 x 6-3/4 w/sq. 12",24",etc. rod 1 x 6-3/4 channel to end of cutout.
	Other
	(*) This Information is for MACHINING REFERENCE ONLY

8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 FAX: 715-223-3352 715-223-6324 Please Check One: ☐ 208 ☐ 223 ☐ 224 LH/RHR ACTIVE DOOR #: ____ CUSTOMER: P.O.: ______ DATE: ______ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: _____ __ NO. of SETS REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ □ STD. BEIGE □ SPECIAL COLOR: _____ □ NO PAINT □ VENEER: ____ LH ACTIVE RHR ACTIVE RH INACTIVE LHR INACTIVE KEY SIDE KEY SIDE ALL DIMENSIONS ARE FROM TOP OF DOOR. **ACTIVE DOOR INACTIVE DOOR** DOOR: 1-3/4" 1-13/16" OTHER: _____ SQUARE <----- SQUARE LOCK STRIKE 1-1/8 X 2-1/4 CL . 4-7/8 X 1-1/4 w/3-3/8 LIP 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP TOP TEMPLATE# TEMPLATE# <----> 2nd STRIKE/LOCK ----> CL CL-STRIKE 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP CL CL TEMPLATE# TEMPLATE #____ * MFL * MFR **SPECIAL** Actual MATERIAL OAL **FLUSHBOLTS** Cutout Size Flushbolts GALV. with 12, 24, Auto. 356 1 x 8-1/8 w/1/4 radius etc., rods give S.S. 1 x 7 dimension to Automatic 1 x 8-1/2 w/1/4 radius CL. for all BOTTOM CRS 1 x 7 others give **Automatic** 1 x 9 w/1/4 radius dimension 1 x 6-3/4 w/sq. corners 1 x 5-3/4 from end of Manual 358 CLchannel to GAGE: ____ 1 x 6-3/4 w/sq. 12",24",etc. rod 1 x 6-3/4 Manual end of cutout. Other (*) This Information is for MACHINING REFERENCE ONLY

8/15/03 ALL ME ⁻ 715-223	TAL STAMPING, INC., ABBOTS	SFORD, WI. 54405 FAX: 715-223-3352	AMS USE ONLY
Please	Check One: □ 208 □ 223 □ 224 RH	/LHR ACTIVE	
	DATE:		
	DAIL.		
	#: DOOR ITEM:		
	DATE REQ.:		
DSTD BEIGE DS	PECIAL COLOR:	DRAWN BY:	DATE:
LHR A		LH INACTIVE	RH ACTIVE
INACT	ALL DIMENSIONS ARE FR TIVE DOOR DOOR: 1-3/4" 1-13/16" SQUARE <mark for="" square<="" th=""><th>ACT</th><th>IVE DOOR</th></mark>	ACT	IVE DOOR
CL TOP CL CL * MFL	STRIKE 4-7/8 x 1-1/4 w/3-3/8 LIP 2-3/4 x 1-1/8 w1-1/2 LIP TEMPLATE # STRIKE 4-7/8 x 1-1/4 w/3-3/8 LIP 2-3/4 x 1-1/8 w1-1/2 LIP TEMPLATE #		CL CL * MFR
			OBESIA
OAL	FLUSHBOLTS	Actual Cutout Size	SPECIAL MATERIAL
OAL	FLUSHBOLTS Auto. 356 1 x 8-1/8 wi1/4 radius	Cutout Size Flushbolts with 12, 24,	The state of the s
	I	Cutout Size Flushbolts with 12, 24, etc., rods give dimension to	MATERIAL
BOTTOM	Auto. 356 1 x 8-1/8 w/1/4 radius	Cutout Size 1 x 7 1 x 7 1 x 7 1 x 7 1 x 7 1 x 7 1 x 7	MATERIAL GALV.
	Auto. 356 1 x 8-1/8 w/1/4 radius Automatic 1 x 8-1/2 w/1/4 radius	Cutout Size 1 x 7 1 x 7 1 x 7 1 x 7 CL, for all	MATERIAL GALV. S.S.

715-223	3-6324	FAX: 715-223-3352	AMS USE ONLY
Please Chec	ck One: 208 223 224 LH/F	RHR ACTIVE LBR	
P.O.:	DATE:		
ACCESSORY ITEM	#: DOOR ITEM:		
NO. of SETS REQ.:	DATE REQ.:	DRAWN BY:	DATE:
STD. BEIGE SP	ECIAL COLOR:	□ NO PAINT □ VENEER:	DATE
	ACTIVE RHR ACTIVE		NACTIVE /
INACTIVE	DOOR	ACTIV	/E DOOR
_	DOOR: 1-3/4" 1-13/16"		
	SQUARE <mark for="" squar<="" td=""><td>e Channel> SQUARE</td><td></td></mark>	e Channel> SQUARE	
OAL	FIRE PIN Less Bottom Rod (LE		SPECIAL MATERIAL GALV. S.S. CRS GAGE:
CL	DIA.	DIA.	CL
	* MFR	* MFL	

8/15/03 ALL METAL 715-223-63		BOTSFORD, WI. 54405 FAX: 715-223-3352	AMS USE ONLY
	ne: 🗆 208 🗆 223 🗆 224 i		
CUSTOMER:		DOOR #:	
P.O.:	DATE:		
M.O.:			
ACCESSORY ITEM #:	DOOR ITEM	l:	
		DRAWN BY:	
☐ STD. BEIGE ☐ SPECI	AL COLOR:	□ NO PAINT □ VENEER:	
LHR ACTIVE	RHR INACTIVE \	LH INACTIVE RH	ACTIVE
INACTIVE	DOOR	ACTI	VE DOOR
	DOOR: 1-3/4" 1-1	3/16" OTHER:	
	SQUARE <mark for="" s<="" td=""><td>equare Channel> SQUARE</td><td></td></mark>	equare Channel> SQUARE	
OAL		E PINS for od (LBR) Applications	SPECIAL MATERIAL GALV. S.S. CRS GAGE:
CL	DIA.	DIA.	
	* MFL	* MFR	

715-223-6	L STAMPING, INC., ABBO 324	TSFORD, WI. 54405 FAX: 715-223-3352	AMS USE ONLY
	one: 208 223 224 LH/		
	D.T.		
	DATE:		
	DOOR ITEM: _		
NO. of SETS REQ.: _	DATE REQ.:	DRAWN BY:	DATE:
□ STD. BEIGE □ SPEC	IAL COLOR:	_ □ NO PAINT □ VENEER: I	
LHR INACTI	RHR ACTIVE	LH ACTIVE	RH INACTIVE
INACTIVE DO	OOR	ACT	TIVE DOOR
	DOOR: 1-3/4" 1-13/16		
1	SQUARE <mark for="" squar<="" td=""><td>e Channel> SQUARE</td><td></td></mark>	e Channel> SQUARE	
OAL CL CL	FIRE PIN Less Bottom Rod (Li		SPECIAL MATERIAL GALV. S.S. CRS GAGE: CL

	223-63	24		VVI. 54405 5-223-3352	AND OSE UNLY
		ne: □ 208 □ 223 □ 22			
		DATE:			
		DOOR I			
		DOOR I			
		DATE REQ.: _ AL COLOR:			
	R ACTIVE	RHR INACTIVE \		LH INACTIVE	RH ACTIVE
IN	ACTIVE	DOOR		ACT	IVE DOOR
		DOOR: 1-3/4"	1-13/16" OTH		
		SQUARE <mark fo<="" td=""><td></td><td></td><td></td></mark>			
OAL		11	FIRE PINS for 1 Rod (LBR) Applica	tions	SPECIAL MATERIAL GALV. S.S. CRS GAGE:
CL	0	DIA.		DIA.	CL CL
		* MFL		* MFR	

8/15/03 ALL MET 715-223	TAL STAMPING, INC., ABBO 3-6324	TSFORD, WI. 54405 FAX: 715-223-3352	AMS USE ONLY
	208 □ 223 □ 224 LH/RHR AG	CTIVE for SARGENT PP & PR 87	
	DATE:		
ACCESSORY ITEM	#: DOOR ITEM: _		
	DATE REQ.:		
□ STD. BEIGE □ SP	ECIAL COLOR:	□ NO PAINT □ VENEER:	
LHR INACT	RHR ACTIVE	LH ACTIVE	INACTIVE /
INACTIVE	DOOR: 1-3/4" 1-13/10	ACT	IVE DOOR
CL of Punch Out * MFR OAL	SARGENT PR 8700 1-1/4 x 8 with (2) 3-7/16 Lips	SARGENT PP 8700 1-1/4 x 8	CL of Punch Out * MFL SPECIAL MATERIAL GALV. S.S. CRS GAGE:

^(*) This Information is for MACHINING REFERENCE ONLY

8/15/03 ALL METAL STAN 715-223-6324		FORD, WI. 54405 AX: 715-223-3352	AMS USE ONLY
Please Check One: 208 223 CUSTOMER:			
P.O.:	DATE:		
M.O.:			
ACCESSORY ITEM #:	DOOR ITEM:		
NO. of SETS REQ.:			
☐ STD. BEIGE ☐ SPECIAL COLO			
LHR ACTIVE RHR I	NACTIVE \	LH INACTIVE RI	H ACTIVE
INACTIVE DOOR	L DIMENSIONS ARE FRO	ACT	TIVE DOOR
CL of Punch Out	ENT PR 8700 8 with (2) 3-7/16 Lips	SARGENT PP 8700 1-1/4 x 8	CL of Punch Out * MFR SPECIAL MATERIAL GALV. S.S. CRS GAGE:

^(*) This Information is for MACHINING REFERENCE ONLY

8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 PARALLEL BEVEL SET FAX: 715-223-3352 225 LH/RHR ACTIVE for SARGENT PP & PR 8700

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				- 1
				-

CUSTOMER:	GRESS SET	OR #:	
P.O.: DATE:			
M.O.:			
ACCESSORY ITEM #: DOO	R ITEM:		
NO. of SETS REQ.: DATE REC	Q.: DR	AWN BY:	_DATE:
☐ STD. BEIGE ☐ SPECIAL COLOR:		VENEER:	
LH INACTIVE RHR ACTIVE	LH ACTIV	RHR INACTIVE	
ALL DIMENSION	ONS ARE FROM TOP OF I	DOOR.	
	1-13/16" OTHER: ark for Square Channel> S		DOR
CL of Punch Out * MFR OAL BOTTOM		ENT PP 8700 1-1/4 x 8	* MFL SPECIAL MATERIAL GALV. S.S. CRS GAGE:

8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 PARALLEL BEVEL SET FAX: 715-223-3352 225 RH/

I WINTER DEALE OF I	1 AX. 1 13-223-333
LHR ACTIVE for SARGENT	PP & PR 8700
DOLIBI E ECDECC CE	т

CUSTOMER:		DOOR #:	
P.O.:	DATE:		
М.О.:			
ACCESSORY ITEM #:	DOOR ITEM:		
	DATE REQ.:		
☐ STD. BEIGE ☐ SPECIAL	. COLOR:	□ NO PAINT □ VENEER:	
LHR ACTIVE U	RH INACTIVE	LHR INACTIVE	RH ACTIVE
	ALL DIMENSIONS ARE F		
			IVE DOOR
	DOOR:		
	SQUARE < Mark for Squa	re Channel> SQUARE	
I *MFL III III	SARGENT PR 8700 I-1/4 x 8 with (2) 3-7/16 Lips	SARGENT PP 8700 1-1/4 x 8	CL of Punch Out * MFR SPECIAL MATERIAL GALV. S.S. CRS GAGE:

AMS USE ONLY 8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 PARALLEL BEVEL SET FAX: 715-223-3352 Please Check One: 209 w/ASTRAGAL 225 DOUBLE EDGE LH/RHR ACTIVE CUSTOMER: _____ DOOR #: _____ P.O.: _____ DATE: _____ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: ____ __ NO. of SETS REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ ☐ STD. BEIGE ☐ SPECIAL COLOR: _____ ☐ NO PAINT ☐ VENEER: ___ RHR ACTIVE [LH ACTIVE ☐ LEAD LINED ASTRAGAL LH INACTIVE LIP WIDTH:_____ RHR INACTIVE ☐ 1/16" LEAD ☐ 1/8" LEAD KEY SIDE KEY SIDE ALL DIMENSIONS ARE FROM TOP OF DOOR. **INACTIVE DOOR ACTIVE DOOR** ¬ DOOR: ☐ 1-3/4" ☐ 1-13/16" ☐ OTHER: _____ [<-----Mark for NO ASTRAGAL LIP LOCK CL ' 4-7/8 X 1-1/4 w/3-3/8 LIP 1-1/8 X 2-1/4 2-3/4 X 1-1/8 w1-1/2 LIP 1-1/4 X 8 TOP TEMPLATE #____ TEMPLATE# <----> 2nd STRIKE/LOCK -----> CL-CL LOCK STRIKE 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP □ 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP CL CL TEMPLATE# TEMPLATE #____ * MFL * MFR SPECIAL OAL Actual MATERIAL **FLUSHBOLTS** Cutout Size GALV. Flushbolts Auto. 356 1 x 7 with 12, 24, 1 x 8-1/8 w/ 1/4 radius etc., rods give S.S. 1 x 7 Automatic dimension to 1 x 8-1/2 w/1/4 radius BOTTOM CL, for all CRS 1 x 7 Automatic others give 1 x 9 w/ 1/4 radius dimension Manual 358 1 x 6-3/4 w/sq. corners 1 x 5-3/4 from end of CL-GAGE: channel to 1 x 6-3/4 Manual 1 x 6-3/4 w/sq. 12",24",etc. rod end of cutout. Other (*) This Information is for MACHINING REFERENCE ONLY

715-223	TAL STAMPING, INC., ABBOTSFORD, -6324 PARALLEL BEVEL SET FAX: 719	WI. 54405 5-223-3352
ase Check One: D 20	9 w/ASTRAGAL □ 225 DOUBLE EDGE	
O.:	DATE:	
	1 #: DOOR ITEM:	
of SETS REQ.:	: DATE REQ.:	DRAWN DV.
STD BEIGE Tel	PECIAL COLOR: D NO PAIN	DRAWN BY:DATE:
OID. BLIGE - 3	PECIAL COLOR: LI NO PAIN	IT UVENEER:
LHR ACTIVE KEY SIDE	LEAD LINED ASTRAGAL LIP WIDTH: 1/16" LEAD 1/8" LEAD	LHR INACTIVE
CL TOP	□ 4-7/8 X 1-1/4 w/3-3/8 LIP □ 1-1/8 X □ 2-3/4 X 1-1/8 w1-1/2 LIP □ 1-1/4 X □ TEMPLATE # □ TEMPL/ STRIKE □ 4-7/8 X 1-1/4 w/3-3/8 LIP □ 2-3/4 X 1-1/8 w1-1/2 LIP	ACTIVE DOOR R:
OAL	FLUSHBOLTS Actual Cutout Size	SPECIAL MATERIAL GALV
	Auto. 356 1 x 8-1/8 w/ ¹ / ₄ radius 1 x 7	with 12, 24,
	Automatic 1 x 8-1/2 w/1/4 radius 1 x 7	dimension to S.S.
BOTTOM	TA O II Z W/74 ladius	
ВОТТОМ	Automatic 1 x 9 w/1/4 radius 1 x 7	CL, for all others give CRS
BOTTOM		
	Automatic 1 x 9 w/4 radius 1 x 7	others give dimension CRS

715-223-6324 PARALLEL BEVEL SET FAX: 715-223-3352 Please Check One:

209 w/ASTRAGAL

225 DOUBLE EDGE LH/RHR ACTIVE Less Botttom Rod (LBR) CUSTOMER: DOOR #: _____ P.O.: _____ DATE: _____ ____ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: ____ __ NO. of SETS REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ ☐ STD. BEIGE ☐ SPECIAL COLOR: _____ ☐ NO PAINT ☐ VENEER: ____ LH ACTIVE LH INACTIVE RHR INACTIVE **RHR ACTIVE INACTIVE DOOR ACTIVE DOOR** DOOR: 1-3/4" 1-13/16" OTHER: ______ <-----Mark for NO ASTRAGAL LIP **SPECIAL** MATERIAL OAL GALV. S.S. FIRE PINS for CRS Less Bottom Rod (LBR) Applications GAGE: DIA. DIA. CL CL * MFL * MFR

8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405

	24 PARALLEL BEVEL SE		Table 180 ONL 1
Please Check One: D 209 \		BLE EDGE RH/LHR ACT	IVE
CUSTOMER:	Less Bottor	n Rod (LBR) DOOR #:	
		DRAWN BY:	
STD. BEIGE SPEC	IAL COLOR:	NO PAINT UVENEER:	
LHR ACTIVE \$\frac{1}{2}	RHINACTIVE	LHR INACTIVE	RHACTIVE
INACTIV	E DOOR	ACT	IVE DOOR
		6" OTHER:	
	<mark astraga<="" for="" no="" p=""></mark>	AL LIP	
OAL	FIRE P Less Bottom Rod (INS for LBR) Applications	SPECIAL MATERIAL GALV. S.S. CRS GAGE:
CL	DIA. * MFL	DIA. * MFR	CL

AMS USE ONLY 2/21/12 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 PARALLEL BEVEL SET FAX: 715-223-3352 Check One: ☐ 209A W/ASTRAGAL ☐ 225A DOUBLE EDGE LH/RHR ACTIVE CUSTOMER: _____ DOOR #: _____ P.O.: _____ DATE: _____ ___ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: _____ __ NO. of SETS REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ ☐ STD. BEIGE ☐ SPECIAL COLOR: ☐ NO PAINT ☐ VENEER: ☐ RHR ACTIVE Lead Lined Astragal flange LH ACTIVE cannot be notched. Cut Strike Lip or Notch Astragal LH INACTIVE ☐ LEAD LINED ASTRAGAL RHR INACTIVE Cut Strike Lip or LIP WIDTH: **KEY SIDE KEY SIDE Notch Astragal** ☐ 1/16" LEAD ☐ 1/8" LEAD ALL DIMENSIONS ARE FROM TOP OF DOOR. **ACTIVE DOOR INACTIVE DOOR** <-----Mark for NO ASTRAGAL LIP STRIKE LOCK 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP ·CL 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP TEMPLATE # TOP 2ND NOTCHED LIP STRIKE LIP LENGTH <----> CL. CL LOCK STRIKE 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP CL CL TEMPLATE #____ TEMPLATE # * MFR * MFL NOTCHED LIP--> STRIKE LIP LENGTH OAL Actual FLUSHBOLTS Cutout Flushbolts Size with 12, 24, Auto, 356 1 x 7 1 x 8-1/8 w/1/4 radius etc., rods give **SPECIAL** dimension to 1 x 7 Automatic **BOTTOM** 1 x 8-1/2 w/1/4 radius MATERIAL CL, for all others give GALV. Automatic 1 x 7 1 x 9 w/1/4 radius dimension ·CL from end of S.S. Manual 358 1 x 6-3/4 w/sq. corners 1 x 5-3/4 channel to 1 x 6-3/4 w/sq. 12",24",etc. rod end of cutout. Manual 1 x 6-3/4 **CRS** Other (*) This Information is for MACHINING REFERENCE ONLY GAGE:

2/21/12 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 PARALLEL BEVEL SET FAX: 715-223-3352 Check One: 209A w/ASTRAGAL 225A DOUBLE EDGE RH/LHR ACTIVE DOOR #: _____ CUSTOMER: _____ P.O.: ______ DATE: _____ ___ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: ____ ___ NO. of SETS REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ □ STD. BEIGE □ SPECIAL COLOR: _____ □ NO PAINT □ VENEER: ____ Lead Lined Astragal flange Cut Strike Lip or Notch Astragal RH ACTIVE LHR ACTIVE cannot be notched. RH INACTIVE ☐ LEAD LINED ASTRAGAL LHR INACTIVE LIP WIDTH: **KEY SIDE** Cut Strike Lip or Notch Astragal KEY SIDE ☐ 1/16" LEAD ☐ 1/8" LEAD ALL DIMENSIONS ARE FROM TOP OF DOOR. **ACTIVE DOOR INACTIVE DOOR** DOOR: 1-3/4" 1-13/16" OTHER: _____ <----Mark for NO ASTRAGAL LIP LOCK STRIKE 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP CL 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP TEMPLATE # TEMPLATE # TOP 2ND NOTCHED LIP STRIKE LIP LENGTH <----> 2nd LOCK/STRIKE ----> CL. CL LOCK STRIKE 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP 2-3/4 X 1-1/8 w1-1/2 LIP 1-1/4 X 8 CL CL TEMPLATE # * MFR * MFL NOTCHED LIP--> STRIKE LIP LENGTH OAL Actual **FLUSHBOLTS** Cutout Size Flushbolts with 12, 24, Auto. 356 1 x 7 1 x 8-1/8 w/1/4 radius etc., rods give SPECIAL dimension to Automatic 1 x 7 1 x 8-1/2 w/1/4 radius BOTTOM MATERIAL CL, for all others give GALV. Automatic 1 x 7 1 x 9 w/1/4 radius dimension ·CL from end of S.S. Manual 358 1 x 6-3/4 w/sq. corners 1 x 5-3/4 channel to Manual 1 x 6-3/4 w/sq. 12",24",etc. rod 1 x 6-3/4 end of cutout. **CRS** Other (*) This Information is for MACHINING REFERENCE ONLY GAGE:

AMS USE ONLY ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 2/21/12 715-223-6324 FAX: 715-223-3352 Please Check One: ☐ 211 ☐ 217A ☐ 218 ☐ 226 LH/RHR ACTIVE DOOR #: CUSTOMER: ____ P.O.: _____ DATE: _____ ACCESSORY ITEM #: DOOR ITEM: _____ ___ NO. of SETS REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ _____ □ NO PAINT □ VENEER: _____ ☐ STD. BEIGE ☐ SPECIAL COLOR: Lead Lined Astragal flange Cut Strike Lip or Notch Astragal cannot be notched. RHR ACTIVE □ LEAD LINED ASTRAGAL RH INACTIVE LHR INACTIVE **KEY SIDE** LIP WIDTH: Cut Strike Lip or Notch Astragal ☐ 1/16" LEAD ☐ 1/8" LEAD ALL DIMENSIONS ARE FROM TOP OF DOOR. **ACTIVE DOOR INACTIVE DOOR** DOOR: 1-3/4" 1-13/16" OTHER: SQUARE <----- Mark for Square Channel-----> SQUARE LOCK 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP -CL 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP TEMPLATE # TOP 2ND NOTCHED LIP STRIKE LIP LENGTH <----> CL. CL LOCK STRIKE 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP 2-3/4 X 1-1/8 w1-1/2 LIP 1-1/4 X 8 CL CL TEMPLATE# TEMPLATE # * MFR * MFL NOTCHED LIP--> STRIKE LIP LENGTH OAL Actual FLUSHBOLTS Cutout Flushbolts Size with 12, 24, Auto. 356 1 x 8-1/8 w/1/4 radius etc., rods give **SPECIAL** dimension to 1 x 7 Automatic 1 x 8-1/2 w/1/4 radius CL, for all **BOTTOM** MATERIAL others give GALV. Automatic 1 x 7 1 x 9 w/1/4 radius dimension ·CL from end of Manual 358 1 x 6-3/4 w/sq. corners 1 x 5-3/4 S.S. channel to end of cutout. Manual 1 x 6-3/4 w/sq. 12",24",etc. rod 1 x 6-3/4 **CRS** Other (*) This Information is for MACHINING REFERENCE ONLY GAGE:

2/21/12 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 AMS USE ONLY 715-223-6324 FAX: 715-223-3352 Please Check One:

211

217A

218

226 RH/LHR ACTIVE DOOR #: _____ CUSTOMER: P.O.: _____ DATE: _____ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: _____ __ NO. of SETS REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ □ STD. BEIGE □ SPECIAL COLOR: _____ □ NO PAINT □ VENEER: ____ Lead Lined Astragal flange Cut Strike Lip or Notch Astragal RH ACTIVE cannot be notched. LHR ACTIVE LH INACTIVE □ LEAD LINED ASTRAGAL RHR INACTIVE **KEY SIDE** LIP WIDTH: Cut Strike Lip or Notch Astragal ☐ 1/16" LEAD ☐ 1/8" LEAD ALL DIMENSIONS ARE FROM TOP OF DOOR. **ACTIVE DOOR INACTIVE DOOR** DOOR: 1-3/4" 1-13/16" OTHER: _____ SQUARE <----- Mark for Square Channel-----> SQUARE STRIKE 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP -CL 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP TEMPLATE #____ TOP ☐ TEMPLATE #_____ 2ND NOTCHED LIP STRIKE LIP LENGTH <----> CL CL LOCK STRIKE 1-1/8 X 2-1/4 4-7/8 X 1-1/4 w/3-3/8 LIP 1-1/4 X 8 2-3/4 X 1-1/8 w1-1/2 LIP CL CL TEMPLATE #____ TEMPLATE # * MFL * MFR NOTCHED LIP--> STRIKE LIP LENGTH ___ OAL Actual **FLUSHBOLTS** Cutout **Flushbolts** Size with 12, 24, Auto, 356 1 x 7 1 x 8-1/8 w/1/4 radius etc., rods give **SPECIAL** dimension to Automatic 1 x 8-1/2 w/1/4 radius **BOTTOM** MATERIAL CL, for all others give GALV. Automatic 1 x 7 1 x 9 w/1/4 radius dimension CL from end of S.S. Manual 358 1 x 6-3/4 w/sq. corners 1 x 5-3/4 channel to Manual 1 x 6-3/4 w/sq. 12",24",etc. rod end of cutout. 1 x 6-3/4 **CRS** Other GAGE: ____ (*) This Information is for MACHINING REFERENCE ONLY

9/28/04 ALL METAL S 715-223-6324			FORD, WI. 5440 FAX: 715-223-3352		AMS USE ONLY
Please Check One: 213 ST. CUSTOMER:	ANDARD BEVE	L 🗆 214 S	QUARE LH/RHI		
P.O.:					
M.O.:					
ACCESSORY ITEM #:					
NO. of PCS. REQ.:					
☐ STD. BEIGE ☐ SPECIAL					
LHR INACTIVE RHR ACTIV		LEAD LINED A IP WIDTH: 1/16" LEAD	ASTRAGAL	KEY SIDE -	RH INACTIVE
INACTIV	/E DOOR	Mark for Sq	FROM TOP OF DO uare Channel #214	OOR.	
CL TOP CL * MFR	☐ 4-7/8 X 1	LIP SI	NO LIP FOR SHIPPING STRENGTH KE	SPECIAL MATERIAL GALV. S.S. CRS	
BOTTOM	Flushbolts with 12, 24, etc., rods give dimension to CL, for all others give dimension	Auto. 356 Automatic Automatic Manual 358	1 x 8-1/8 w/1/4 radius 1 x 8-1/2 w/1/4 radius 1 x 9 w/1/4 radius	Actual Cutout Size 1 x 7 1 x 7 1 x 7	
CL	from end of channel to	Manual 358	1 x 6-3/4 w/sq. corners 1 x 6-3/4 w/sq. 12",24",etc. rod	1 x 6-3/4	
	end of cutout.	Other			
	(*) This Informa	ation is for M	ACHINING REFEREN	CE ONLY	

9/28/04 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 "T" ASTRAGAL FAX: 715-223-3352 715-223-6324 Please Check One:

213 STANDARD BEVEL

214 SQUARE RH/LHR ACTIVE DOOR #: CUSTOMER: _____ P.O.: ______ DATE: _____ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: _____ __ NO. of PCS. REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ □ STD. BEIGE □ SPECIAL COLOR: _____ □ NO PAINT □ VENEER: ____ RH ACTIVE ☐ LEAD LINED ASTRAGAL LHR ACTIVE LH INACTIVE RHR INACTIVE LIP WIDTH:_____ **KEY SIDE** ☐ 1/16" LEAD ☐ 1/8" LEAD **KEY SIDE** ALL DIMENSIONS ARE FROM TOP OF DOOR. **INACTIVE DOOR** STILE WIDTH ______ 1-5/8" Standard SQUARE <-----Mark for Square Channel #214 STRIKE **SPECIAL** ☐ 4-7/8 X 1-1/4 w/NO LIP NO LIP FOR CL -☐ 2-3/4 X 1-1/8 w/NO LIP SHIPPING MATERIAL TOP TEMPLATE # _____ STRENGTH GALV. S.S. <----- 2nd STRIKE CRS CL-STRIKE 4-7/8 X 1-1/4 w/NO LIP NO LIP FOR 2-3/4 X 1-1/8 W/NO LIP SHIPPING GAGE: CL ☐ TEMPLATE #___ STRENGTH * MFL Actual **FLUSHBOLTS** Cutout OAL Auto. 356 1 x 7 **Flushbolts** 1 x 8-1/8 w/1/4 radius with 12, 24, etc., rods give Automatic 1 x 8-1/2 w/1/4 radius dimension to BOTTOM CL, for all Automatic 1 x 7 1 x 9 w/ 1/4 radius others give dimension Manual 358 1 x 6-3/4 w/sq. corners 1 x 5-3/4 from end of CL-1 x 6-3/4 channel to Manual 1 x 6-3/4 w/sq. 12",24",etc. rod end of cutout. Other

(*) This Information is for MACHINING REFERENCE ONLY

AMS USE ONLY 8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 "T" ASTRAGAL 715-223-6324 FAX: 715-223-3352 Please Check One:

229 REVERSE BEVEL

214 SQUARE LH/RHR ACTIVE CUSTOMER: DOOR #: _____ P.O.: ______ DATE: _____ ____ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: ____ __ NO. of PCS. REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ ☐ STD. BEIGE ☐ SPECIAL COLOR: ☐ NO PAINT ☐ VENEER: RHR ACTIVE LH ACTIVE ☐ LEAD LINED ASTRAGAL LH INACTIVE LIP WIDTH: RHR INACTIVE ☐ 1/16" LEAD ☐ 1/8" LEAD KEY SIDE KEY SIDE -ALL DIMENSIONS ARE FROM TOP OF DOOR. **INACTIVE DOOR** SQUARE <-----Mark for Square Channel #214 STILE WIDTH 1-5/8" Standard STRIKE SPECIAL CL -☐ 4-7/8 X 1-1/4 w/NO LIP NO LIP FOR MATERIAL 2-3/4 X 1-1/8 w/NO LIP SHIPPING TOP GALV. TEMPLATE # _____ STRENGTH S.S. CRS <----- 2nd STRIKE CL-GAGE: STRIKE 4-7/8 X 1-1/4 w/NO LIP NO LIP FOR 2-3/4 X 1-1/8 w/NO LIP SHIPPING CL TEMPLATE #_____ STRENGTH * MFR Actual **FLUSHBOLTS** Cutout OAL **Flushbolts** Auto, 356 1 x 7 1 x 8-1/8 w/ 1/4 radius with 12, 24, etc., rods give Automatic 1 x 8-1/2 w/1/4 radius 1 x 7 dimension to

(*) This Information is for MACHINING REFERENCE ONLY

1 x 9 w/1/4 radius

1 x 6-3/4 w/sq. corners

1 x 6-3/4 w/sq. 12",24",etc. rod

1 x 5-3/4

1 x 6-3/4

Automatic

Manual 358

Manual

Other

CL. for all

others give dimension

from end of

end of cutout.

channel to

BOTTOM

CL-

Please Check One: 229 REVERSE BEVEL USTOMER:	214 SQUA	RE RH/LHR DOOR #:		
O.: DATE:				
.0.:				
CCESSORY ITEM #: DOOR IT				
O. of PCS. REQ.: DATE REQ.:				
STD. BEIGE SPECIAL COLOR:				
LIP W	D LINED ASTR	_	LHR INACTIVE	RH ACTIVE KEY SIDE
ALL DIMENSIO INACTIVE DOOR STILE WIDTH SQUARE <mar< td=""><td> 1-5/8" Stand</td><td>ard</td><td>OR.</td><td></td></mar<>	1-5/8" Stand	ard	OR.	
TOP	w/NO LIP w/NO LIP nd STRIKE NO LIP F SHIPPIN	SHIPPING STRENGTH GA	SPECIAL IATERIAL GALV. S.S. CRS	
OAL	FLUSHI	BOLTS	Actual Cutout Size	
Flushbolts with 12, 24,	Auto. 356 1 x 8	-1/8 w/ 1/4 radius	1 x 7	
etc., rods give dimension to	Automatic 1 x 8	1-1/2 w/ 1/4 radius	1×7	
BOTTOM CL, for all others give	Automatic 1 x 5	w/ 1/4 radius	1 x 7	
CL dimension from end of	Manual 358 1 x 6	-3/4 w/sq. corners	1 x 5-3/4	
channel to end of cutout.		i-3/4 w/sq. 12",24",etc. rod	1 x 6-3/4	
	Other			

Please Check One: 22 CUSTOMER: P.O.: M.O.: ACCESSORY ITEM NO. of PCS. REQ.:	ALL METAL STAMPING, INC., ABBOTS 715-223-6324 "T" ASTRAGAL 29A REVERSE BEVEL 214A SQUAF DATE: #: DOOR ITEM: DATE REQ.: DOOR PA	FAX: 715-223-3352 RE LH/RHR ACTIVE DOOR #: DRAWN BY:DATE:
LHR INACTIVE Cut Strike Lip or Notch Astragal	Lead Lined Astragal flange cannot be notched. □ LEAD LINED ASTRAGAL LIP WIDTH: □ 1/16" LEAD □ 1/8" LEAD	Cut Strike Lip or Notch Astrag
CL * MFL OAL	ALL DIMENSIONS ARE FROM IVE DOOR SQUARE <mark #="" 1-1="" 1-5="" 2-1="" 2nd="" 4="" 8="" 8"="" char="" cl="" for="" length="" lip="" lock="" notched="" of="" square="" standard="" stile="" strike="" template="" width="" x=""> STRIKE LIP LENGTH CL of the STRIKE to locate LIP location</mark>	SPECIAL MATERIAL GALV. S.S. CRS GAGE:

		AMS USE ONLY
	METAL STAMPING, INC., ABBO 23-6324 "T" ASTRAGAL	
	REVERSE BEVEL 214A SQU	
P.O.:	DATE:	
M.O.:		
ACCESSORY ITEM #:	DOOR ITEM:	
NO. of PCS. REQ.:	DATE REQ.:	DRAWN BY: DATE:
STD. BEIGE SPECIAL	L COLOR:	DRAWN BY:DATE:
LHR ACTIVE RHR INACT Cut Strike Lip of	Lead Lined Astragal flange cannot be notched. □ LEAD LINED ASTRAG LIP WIDTH: □ 1/16" LEAD □ 1/8" LEAD	Cut Strike Lip or Notch Astragal LH INACTIVE KEY SIDE
ACTIVE D	ALL DIMENSIONS ARE FROM OOR + STILE WIDTH 1-5/8" Standar SQUARE <mark ch<="" for="" square="" td=""><td>rd</td></mark>	rd
CL * MFR OAL	Lock 1-1/8 X 2-1/4 1-1/4 X 8 TEMPLATE # 2ND NOTCHED LIP STRIKE LIP LENGTH CL of Strike 2nd LOCK 1-1/8 X 2-1/4 1-1/4 X 8 TEMPLATE # NOTCHED LIP> STRIKE LIP LENGTH CL of the STRIKE to locate LIP locate	S.S. CRS GAGE:

16/07 ALL 715-2	METAL 23-6324	STAMPING, II	NC., ABBC	OTSFORD, WI. 5	4405 -3352	AMS USE ONLY
Please Check	One: 2	37 SQUARE	238 STD.	BEVEL LH/RHR	ACTIVE	
					₹#:	
CESSORY	TEM #:	DC	OR ITEM: _			
of SETS R	EQ.:	DATE R	EQ.:	DRAV	VN RY-	DATE:
STD. BEIGE	□ SPEC	IAL COLOR:		□ NO PAINT □ V	ENEED.	DAIL
7	HR INACTIVE	RHR ACTIVE	_	LH ACTIVE KEY S	T RH INAC	
IN.	ACTIVE Astra	DOOR gal Lip DOOR: 1	-3/4"	FROM TOP OF D 13/16" OTHER: _ uare Channel #237		
CL TOP CL- CL * MFR		☐ 4-7/8 X ☐ 2-3/4 X ☐ TEMPL		E	SPECIAL IATERIAL GALV. S.S. CRS	
OAL		Flushbolts	FI	LUSHBOLTS	Actual Cutout Size	
		with 12, 24, etc., rods give	Auto. 356	1 x 8-1/8 w/1/4 radius	1x7	
		dimension to CL, for all	Automatic	1 x 8-1/2 w/1/4 radius	1 x 7	
воттом	1 1	OL, IOI all				
воттом	┃ ┌┐┃	others give	Automatic	1 x 9 w/¼ radius	1 x 7	
воттом		11 11 11	Automatic Manual 358	1 x 9 w/¼ radius 1 x 6-3/4 w/sq. corners	1 x 7	
		others give dimension				

OMER:				DOOR #		
					BY:DATE	
D. BEIGE	SPECI	AL COLOR:		□ NO PAINT □ VEN	EER:	
	ACTIVE .	RHR INACTIVE		LH INACTIVE	RH ACTIVE KEY SIDE	
INA	CTIVE	ALL DIMENS	IONS ARE F	ROM TOP OF DO	OR.	
	Ī		1_12/16"	OTHER:		
Г	- Actron			Square Channel #23		
	- Astrago	SQUARE	- <iviaik ioi<="" td=""><td>Square Channel #23</td><td>1</td><td></td></iviaik>	Square Channel #23	1	
TOP		☐ 2-3/4 X 1-1	1/4 w/3-3/8 LIP 1/8 w1-1/2 LIP E # 2nd STRIKE	S	PECIAL ATERIAL] GALV.] S.S.	
		☐ 4-7/8 X 1-1/4 w/3-3	3/8 LIP	L	_	
CL	Ц	□ 2-3/4 X 1-1/8 w1-1/	/2 LIP		CRS	
* MFL	4	☐ TEMPLATE #		GA	GE:	
		Flushbolts	FL	LUSHBOLTS	Actual Cutout Size	
OAL		with 12, 24,	Auto 250	1 x 8-1/8 w/¼ radius	1 x 7	
OAL		etc., rods give	Auto. 356			
		The straightful of the straightf	Auto. 356	1 x 8-1/2 w/1/4 radius	1 x 7	
BOTTOM		etc., rods give dimension to		1 x 8-1/2 w/¼ radius 1 x 9 w/¼ radius	1x7 1x7	
	П	etc., rods give dimension to CL, for all others give	Automatic			

2/16/07 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405

2/16/07 ALL METAI 715-223-6324	L STAMPING, IN "Z" ASTRA	C., ABBO ⁻ GAL	TSFORD, WI. 54 FAX: 715-223-3	405 352	AMS USE ONLY
Please Check One: 237 CUSTOMER:	SQUARE □ 239	REVERS	E BEVEL LH/RHI	R ACTIV	E
P.O.:					
M.O.:					
ACCESSORY ITEM #:				-	-
NO. of SETS REQ.:	DATE REC) ·	DDAW	N. D.V.	
☐ STD. BEIGE ☐ SPEC		٠	DRAW	N BY:	DATE:
LH INACTIVE	RHR ACTIVE	-	LH ACTIVE	RH	R INACTIVE
INACTIVE DO	OOR agal Lip DOOR:	1-3/4" 1	FROM TOP OF DO -13/16" OTHER: Square Channel #237		
CL TOP CL CL * MFR	☐ 4-7/8 X 1-1/ ☐ 2-3/4 X 1-1/ ☐ TEMPLATE	8 w1-1/2 LIP # 2nd STRIKE B LIP LIP		M .	PECIAL ATERIAL GALV. S.S. CRS
BOTTOM	Flushbolts with 12, 24, etc., rods give dimension to CL, for all others give dimension from end of channel to end of cutout.	Auto. 356 Automatic Automatic Manual 358 Manual	1 x 8-1/8 w/½ radius 1 x 8-1/2 w/½ radius 1 x 9 w/½ radius 1 x 6-3/4 w/sq. corners 1 x 6-3/4 w/sq. 12",24",etc. rod	Actual Cutout Size 1 x 7 1 x 7 1 x 7 1 x 5-3/4 1 x 6-3/4	
	(*) This Information	Other			

16/07 ALL META 715-223-632	L STAMPING, II	NC., ABBO	OTSFORD, WI. 5 FAX: 715-223	4405 -3352	AMS USE ONLY
Please Check One: 237 USTOMER:	SQUARE - 23	9 REVER	SE BEVEL RH/LI		
0.:					
.0.:					
CCESSORY ITEM #:					
D. of SETS REQ.: _	DATE R	FO ·	DPAL	MN DV.	DATE
STD. BEIGE SPE	CIAL COLOR:			VIN D1:	DATE:
LHR ACTIV	٨			NACTIVE	H ACTIVE
INACTIVE D	OOR		E FROM TOP OF D		
< Astra			I6"		
CL TOP CL CL * MFL	☐ 4-7/8 X 1 ☐ 2-3/4 X 1 ☐ TEMPLA	/2 LIP	E	SPECIAL MATERIA GALV. S.S. CRS	L
OAL	Flushbolts with 12, 24,	FL	LUSHBOLTS	Actual Cutout Size	
	etc., rods give dimension to	Auto, 356	1 x 8-1/8 w/¼ radius	1 x 7	
ВОТТОМ	CL, for all others give	Automatic	1 x 8-1/2 w/¼ radius	1 x 7	
	dimension from end of	Automatic Manual 358	1 x 9 w/¼ radius	1 x 7	
CL	channel to	Manual	1 x 6-3/4 w/sq. corners 1 x 6-3/4 w/sq. 12",24",etc. rod	1 x 5-3/4	
	end of cutout.	Other	. A 0-01-1 W/Sq. 12 ,24",etc. rod	1 x 6-3/4	
	(+) This is a		CHINING REFERENCE		

2/16/07 ALL 715-2	METAL ST. 23-6324	AMPING, INC., ABBOTS "Z" ASTRAGAL	FORD, WI. 54405	AMS USE ONLY
Please Check One:	237A SQL	JARE □ 239A REVERSE	BEVEL LH/RHR AC	TIVE
		DATE:		
		DOOR ITEM:		
		DATE REQ.:		
☐ STD. BEIGE	☐ SPECIAL C	OLOR: [O NO PAINT O VENEER:	
LH Cut Strike Lip or	R INACTIVE	R ACTIVE KEY SIDE		Strike Lip or Notch Astragal
ACT	I DOOK	ALL DIMENSIONS ARE FR OR:	OTHER:	
CL * MFL OAL		/8 X 2-1/4	G	SPECIAL MATERIAL GALV. S.S. CRS AGE:

	VIETAL STAMPING, INC., ABI 23-6324	BOTSFORD, WI. 54405 FAX: 715-223-3352	AMS USE ONLY
	237A SQUARE 239A REV	'ERSE BEVEL RH/LHR ACTIVE DOOR #:	
		Λ:	
		DRAWN BY:	
		DO PAINT DVENEER:	
	RHR INACTIVE Cut Strike Lip or Notch Astragal	Cut Strike Lip or Notch Astragal LH INACTIVE KEY SIDI	
CL * MFR	TIVE DOOR DOOR:	SPECIAL MATERIAL CK SS.S. CRS GAGE:	

ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324

FAX: 715-223-3352

Please Check One: ☐ 206 ☐ 216 LOCK EDGE PROTECTORS CUSTOMER: DOOR #: P.O.: _____ DATE: _____ ___ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: _____ ____ DATE REQ.: _____ DRAWN BY: ____ DATE: ____ □ STD. BEIGE □ SPECIAL COLOR: □ NO PAINT □ VENEER: □ KEY SIDE **KEY SIDE** KEY SIDE KEY SIDE LH/RHR TOP VIEW For SINGLE SWING DOORS ONLY RH/LHR TOP VIEW O.D. **SPECIAL** MATERIAL ☐ S.S ☐ GALV. ☐ CRS I.D. 20 GA. (.O35) STANDARD AMS USE ONLY GAGE: AMS USE ONLY ☐ Mark for SQUARE Channel #216 PCS. REQ. LH PCS. REQ. RH LOCK 1-1/8 X 2-1/4 1-1/4 X 8 TEMPLATE# 2ND LOCK ----> CL-OAL 1-1/8 X 2-1/4 1-1/4 X 8 - CL *MFR TEMPLATE # * MFL (*) MACHINING REFERENCE ONLY

ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 FAX: 715-223-3352

Please Check One: 231 233 "L" LOCK EDGE PROTECTORS

	heck One: L 231 L 233 L		#:
	DATE:		
M.O.:			
ACCESSORY ITEM #:	DOOR ITEM:		
	DRAWN BY:		
☐ STD. BEIGE ☐ SPECIAL	. COLOR:	DNO PAINT DVEN	IEER:
LH KEY SIDE	RHR KEY SIDE	RH KEY SIDE	LHR KEY SIDE
1-5/8" Standard AMS USE ONLY		SWING DOORS ONLY SPECIAL MATERIAL S.S GALV. CRS GAGE:	20 GA. (.035) STANDARD PCS. REQ. RH
* MFL		CL> CL -1/8 X 2-1/4 -1/4 X 8 EMPLATE #	*MFR

ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 FAX: 715-223-3352

Please Check One: 230 234 "U" HINGE EDGE PROTECTORS

CUSTOMER:	D	OOR #:
P.O.:	DATE:	
VI.O.:		
	DOOR ITEM:	
	_ DRAWN BY: DA	
	R:	
LH KEY SIDE	RHR KEY SIDE	RH LHR KEY SIDE
LH/RHR TOP VIEW O.D. BACK SET I.D. AMS USE ONLY	ALL DIMENSIONS ARE FROM TOP SPECIAL MATERIAL S.S GALV. CRS 20 GA. (.035) STA GAGE: Mark for SQUARE Channel #234	NDARD
	_ PCS. REQ. LH	PCS. REQ. RH
OAL	HINGE SIZE 4-1/2" or 5" Standard	
MFR ()	MACHINING REFERENCE ONLY	* MFL

ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 FAX: 715-223-3352

Please Check One: 232 235 "L" HINGE EDGE PROTECTORS

CUSTOMER:		DOOR	R #:
P.O.:	DATE:		
M.O.:			
ACCESSORY ITEM #:	DOOR ITEM: _		
DATE REQ.:			
☐ STD. BEIGE ☐ SPECIAL COLOR			
LH KEY SIDE	RHR KEY SIDE	RH KEY SIDE	
LH/RHR TOP VIEW	ALL DIMENSIONS	ARE FROM TOP OF I	DOOR RH/LHR TOP VIEW
O.D.		SPECIAL	AMS USE ONLY
		MATERIAL	
BACK SET	<u></u>	☐ S.S ☐ GALV.	
	1-5/8" Standard		
I.D.	1-5/6 Standard		
AMS USE ONLY	G	AGE:	
	☐ Mark for SQUAR	E Channel #235	20 GA. (.O35) STANDARD
-	_ PCS. REQ. LH		PCS. REQ. RH
OAL	HINGE S 4-1/2	SIZE Tor 5" Standard	
MFR ()	MACHINING REFEREN	NCE ONLY	* MFL

8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324

FAX: 715-223-3352

AMS USE ONLY

#250	DOOR	EDGE w/5"	LEGS -	LH/RHR	ACTIVE
------	------	-----------	--------	--------	---------------

.: CESSORY ITEM #:			
		DRAWN BY:	
		DO PAINT DVENEER:	
LHR INACTIVE RH	R ACTIVE KEY SIDE	LH ACTIVE RH INACTI	VE /
SQUARF <	MARK FOR SOLIA	RE CHANNEL>	NIADE
	DOOR SIZE:		KOANE
	✓ ☐ 1-3/4"	_	
	☐ 1-13/16	"	
	☐ 2-1/4"		
-	OTH	ER	
	LOCK		1111
	1-1/8 X 2-1/4		CL
	□ _{1-1/4 X 8}		
DAL .			
			-
		STRIKE	
		4-7/8 X 1-1/4 w/3-3/8 LIP	1
CL	<u> </u>	2-3/4 X 1-1/8 w1-1/2 LIP	F
		TEMPLATE #	CL
	<u> </u>	TEM 2012 #	
			-
	FLUSHBOLTS	Actual Cutout	
	Auto. 356	Size 1x7	
	1 X 8-1/8 W/ /	4 radius	<u> </u>
	Automatic 1 x 8-1/2 w/1/	4 radius	11/
		1 47 1	
.	Automatic 1 x 9 w/ ¹ / ₄ ra Manual 358 1 x 6-3/4 w/si		CL'

AMS USE ONLY 8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 FAX: 715-223-3352 #250 DOOR EDGE w/5" LEGS - RH/LHR ACTIVE CUSTOMER: DOOR #: _____ P.O.: ______ DATE: _____ ____ M.O.: ACCESSORY ITEM #: _____ DOOR ITEM: _____ __ NO. of SETS REQ.: _____ DATE REQ.: _____ DRAWN BY: _____DATE:____ □ STD. BEIGE □ SPECIAL COLOR: _____ □ NO PAINT □ VENEER: ____ RH ACTIVE LHR ACTIVE RHR INACTIVE LH INACTIVE **KEY SIDE KEY SIDE** SQUARE <-----> MARK FOR SQUARE CHANNEL -----> SQUARE DOOR SIZE: 1-3/4" 1-13/16" 2-1/4" OTHER CL LOCK 1-1/8 X 2-1/4 □ 1-1/4 X 8 TEMPLATE #_____ OAL STRIKE 4-7/8 X 1-1/4 w/3-3/8 LIP 2-3/4 X 1-1/8 w1-1/2 LIP TEMPLATE #____ CL Actual **FLUSHBOLTS** Cutout Size Auto. 356 1 x 8-1/8 w/1/4 radius 1 x 7 Automatic 1 x 8-1/2 w/1/4 radius 1 x 7 Automatic 1 x 9 w/1/4 radius

1 x 6-3/4 w/sq. corners

1 x 6-3/4 w/sq. 12",24",etc. rod

Manual 358 Manual

Other

1 x 5-3/4

1 x 6-3/4

Machining Templates for Style #222 Dutch Door Edge & Astragal Sets

There are four (4) Machining Templates for Dutch Door Edge & Astragal Sets, two (2) for LH/RHR doors and two (2) for RH/LHR doors. The difference in the two (2) LH/RHR and the two (2) RH/LHR is determined by whether the Strike or Lock is on the Astragal Edge. When completing the templates <u>all</u> measurements should be taken from the lock edge side of the door.

The following steps should be used to select the correct template from the four.

- 1. Determine whether the door is LH/RHR or RH/LHR. This will eliminate two (2) of the templates.
- 2. Determine whether the Strike or Lock will be on the Astragal Edge. This will eliminate one of the templates leaving the correct template by elimination.
- 3. Determine whether the Astragal Edge will be installed on the top or bottom leaf of the Dutch Door. Both views are shown on the template.
- 4. Check the box for the correct Lock and Strike Punchouts or check the template box and provide a detail sheet.
- 5. Complete all dimensions from the Lock Edge of the door to the center line of the lock and strike punchouts desired. Remember to include the overall length and the number of sets required.
- 6. Complete the information section of the form and submit it with your order.

If you require assistance in completing these electronic forms please call and ask for Customer Service at your convenience.

Thank You for your business.

8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 FAX: 715-223-3352 # 222 LH/RHR DOOR w/STRIKE ON ASTRAGAL EDGE

AMS USE ONLY				
	-			

CUSTOMER:	DOOR #:
P.O.: DATE:	
M.O.:	
ACCESSORY ITEM #: DOOR ITEM:	
NO. of SETS REQ.: DATE REQ.:	
☐ STD. BEIGE ☐ SPECIAL COLOR: [□ NO PAINT □ VENEER:
RHR KEY SIDE ASTRAGAL LIP UP KEY SIDE ASTRAGAL LIP DOWN	ASTRAGAL LIP DOWN KEY SIDE LH KEY SIDE ASTRAGAL LIP UP
ALL DIMENSIONS ARE FROM I	LOCK EDGE OF DOOR.
DOOR: 1-3/4" 1-13/16"	
#204 DUTCH DOOR TE	
SPECIAL MATERIAL GALV. S.S. GAGE: CRS	
STRIKE 4-7/8 X 1-1/4 w/3-3/8 LIP 2-3/4 X 1-1/8 w1-1/2 LIP TEMPLATE #	LOCK

8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 FAX: 715-223-3352 # 222 RH/LHR DOOR w/STRIKE ON ASTRAGAL EDGE

AMS USE ONLY

CUSTOMER: _		_ DOOR #:	
	DATE:		
M.O.:	W		
ACCESSORY I	TEM #: DOOR ITEM:		
NO. of SETS R	EQ.: DATE REQ.:	DRAWN BY:	DATE:
STD. BEIGE	☐ SPECIAL COLOR:	□ NO PAINT □ VENEER:	
ASTRAG	LHR KEY SIDE ASTRAGAL LIP DOWN	KEY SIDE RH ASTRAGAL LIP UP	ASTRAGAL LIP DOWN KEY SIDE
A	ALL DIMENSIONS ARE FROM STRAGAL DOOR: 1-3/4" 1-13/16" #204 DUTCH DOOR TO	OTHER:	EDGE
OAL	CL _STRIKE	CL	

8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 FAX: 715-223-3352 # 222A LH/RHR DOOR w/LOCK ON ASTRAGAL EDGE

AMS USE ONLY					
			٦		
			- 1		

CUSTOMER:			DO	OOR #:	100
		DATE:			
		DOOR ITEM			
		DATE REQ.:			
STD. BEIGE	SPEC	IAL COLOR:	D NO PAINT	J VENEER:	
KEY SIDE ASTRAC		ASTRAGAL LIP UP KEY SIDE OWN	ASTRAGAL LI	Y SIDE LH	KEY SIDE ASTRAGAL LIP UP
A.C.	TRAG	ALL DIMENSIONS ARE F	ROM LOCK EDGE		
AS	I KAGA				EDGE
	L	DOOR: 1-3/4" 1-1			
		#204 DUTCH DOO	OR TEMPLATE	#216	
		SPECIAL MATERIAL GALV. S.S. GAC	3E:		
OAL		LOCK		-1/4 w/3-3/8 LIP -1/8 w1-1/2 LIP	

8/15/03 ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405 715-223-6324 FAX: 715-223-3352 # 222A RH/LHR DOOR w/LOCK ON ASTRAGAL EDGE

AMS USE ONLY

CUSTOMER: _			DOOR #:	
VI.O.:				
NO. of SETS RI	EQ.:	DATE REQ.:	DRAWN BY:	DATE:
STD. BEIGE	SPECIA	L COLOR:	D NO PAINT D VENEER:	
ASTRAGA	KEY'S	HR IDE STRAGAL LIP DOWN	I KEY SIDE RH ASTRAGAL LIP UP	ASTRAGAL LIP DOWN KEY SIDE
AS	A STRAGAL		OM LOCK EDGE OF DOOR.	EDGE
		DOOR: 1-3/4" 1-13/	16" OTHER:	
		#204 DUTCH DOOF	R TEMPLATE #216	
OAL		CL LOCK 1-1/8 X 2-1/4 1-1/4 X 8 TEMPLATE # SPECIAL MATERIAL GALV. S.S. GAGE: CRS	CL STRIKE 4-7/8 X 1-1/4 w/3-3/8 LIP 2-3/4 X 1-1/8 w1-1/2 LIP TEMPLATE #	