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 make copies as needed.

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.

1. 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.

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 Center Line of the punchout. 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 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 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.

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.
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.

#205 RH ACTIVE
#206 LH INACTIVE
#207 STANDARD BEVEL SET ASTRAGAL & EDGE

#206 RH ACTIVE
#206 LH INACTIVE
#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

#210 RH ACTIVE
#206 LH INACTIVE
#209 PARALLEL BEVEL SET ASTRAGAL & EDGE for Double Egress Doors

#210 RH ACTIVE
#206 LH INACTIVE
#211 REVERSE BEVEL SET ASTRAGAL & EDGE

#204 RH ACTIVE
#206 LH INACTIVE
#212 SQUARE ASTRAGAL WITH BEVELED EDGE

#204 RH ACTIVE
#206 LH INACTIVE
#217 SQUARE ASTRAGAL AND SQUARE EDGE SET

#210 RH ACTIVE
#216 LH INACTIVE
#218 REVERSE BEVEL ASTRAGAL WITH SQUARE EDGE SET

#205 RH ACTIVE
#216 LH INACTIVE
#219 BEVELED ASTRAGAL WITH SQUARE EDGE SET

#204 RH ACTIVE
#206 LH INACTIVE
#226 SQUARE ASTRAGAL WITH REVERSE BEVELED EDGE

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

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

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

1 3/4 +010

#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", "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

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

ALL EDGES
20 GA. (.035)

ALL ASTRAGALS
16 GA. (.062)

Lead Lined Astragals

1/16" or 1/8" LEAD is crimped and glued in 20 GA. ASTRAGAL

1/16" or 1/8" LEAD is crimped and glued in 18 GA. Astragal with thru bolt attachment.

Standard Binder Post

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

Punchouts For
4½" or 5" Hinge Standard

Hinge Edge Protectors
Available in:
20 GA. CRS Painted
20 GA. or 18 GA. SS

#205 Std. Beveled Astragal
#204 Square Astragal (No Bevel)

Page 5
Mortise Lock
1-1/4" X 8"

Cylindrical Lock
1-1/8" X 2-1/4"

Standard Locks

8"
1-1/4"

Standard Strikes

ASA Strike
4-7/8" X 1-1/4"
w/ 3-3/8" Lip

T-Strike
2-3/4" X 1-1/8"
w/ 1-1/2" Lip

Page 6
ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

DOOR:  □ 1-3/4"  □ 1-13/16"  □ OTHER: __________

☐ SQUARE <-----Mark for Square Channel-----> SQUARE ☐

ACTIVE DOOR

OAL

(*) This Information is for MACHINING REFERENCE ONLY
ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

ACTIVE DOOR

(*) This Information is for MACHINING REFERENCE ONLY
ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405
715-223-6324
FAX: 715-223-3352

8/15/03

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: ____________

INACTIVE DOOR
ACTIVE DOOR

DOOR: □ 1-3/4" □ 1-13/16" □ OTHER:
□ SQUARE <-----Mark for Square Channel-----> SQUARE

OAL
SPECIAL MATERIAL
□ GALV. □ S.S. □ CRS

GAGE: ____________

FIRE PINS for
Less Bottom Rod (LBR) Applications

(*) This Information is for MACHINING REFERENCE ONLY

DIA. DIA.

* MFR * MFL

CL

AMS USE ONLY
FIRE PINS for
Less Bottom Rod (LBR) Applications

(*) This Information is for MACHINING REFERENCE ONLY
(*) This Information is for MACHINING REFERENCE ONLY
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: ____________________

INACTIVE DOOR
☐ 1-3/4”  ☐ 1-13/16”  ☐ OTHER: ___________________
☐ SQUARE ← Mark for Square Channel → SQUARE

ACTIVE DOOR

OAL

SPECIAL MATERIAL
☐ GALV.  ☐ S.S.  ☐ CRS

GAGE: __________

FIRE PINS for Less Bottom Rod (LBR) Applications

(*) This Information is for MACHINING REFERENCE ONLY
ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405
715-223-6324
FAX: 715-223-3352

P.O.: ______________________  DATE: ______________________  DOOR #:

M.O.: ______________________

ACCESSORY ITEM #: __________  DOOR ITEM: __________

NO. of SETS REQ.: __________  DATE REQ.: __________  DRAWN BY: __________  DATE: __________

□ STD. BEIGE  □ SPECIAL COLOR: __________  □ NO PAINT  □ VENEER: __________

ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

TOP

CL of Punch Out

* MFR

OAL

BOTTOM

ACTIVE DOOR

TOP

CL of Punch Out

* MFR

OAL

BOTTOM

SARGENT PR 8700
1-1/4 x 8 with (2) 3-7/16 Lips

SARGENT PP 8700
1-1/4 x 8

□ SQUARE <--- Mark for Square Channel ---> SQUARE

(*) This Information is for MACHINING REFERENCE ONLY
ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405
715-223-6324
FAX: 715-223-3352

8/15/03

CUSTOMER: ___________________________  DOOR #: ___________________________

P.O.: _______________________  DATE: _______________________

M.O.: ___________________________

ACCESSORY ITEM #: __________  DOOR ITEM: __________

NO. of SETS REQ.: _______  DATE REQ.: ___________  DRAWN BY: _______  DATE: ______缺点

STD. BEIGE  □ SPECIAL COLOR: __________  □ NO PAINT  □ VENEER: __________

LHR ACTIVE
RHR INACTIVE

ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

DOOR: □ 1-3/4"  □ 1-13/16"  □ OTHER: __________

□ SQUARE <--- Mark for Square Channel ---► SQUARE

TOP

CL of Punch Out

* MFL

SARGENT PR 8700
1-1/4 x 8 with (2) 3-7/16 Lips

OAL

BOTTOM

ACTIVE DOOR

CL of Punch Out

* MFR

SARGENT PP 8700
1-1/4 x 8

SPECIAL MATERIAL
□ GALV.
□ S.S.
□ CRS

GAGE: ______

(*) This Information is for MACHINING REFERENCE ONLY
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
DOUBLE EGRESS SET

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: ____________________________

ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

ACTIVE DOOR

☐ 1-3/4"  ☐ 1-13/16"  ☐ OTHER: ____________________________

☐ SQUARE <<< Mark for Square Channel >>> SQUARE

SARGENT PR 8700
1-1/4 x 8 with (2) 3-7/16 Lips

SARGENT PP 8700
1-1/4 x 8

(*) This Information is for MACHINING REFERENCE ONLY
ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

- CL of Punch Out
- OAL
- SARGENT PR 8700
  1-1/4 x 8 with (2) 3-7/16 Lips

ACTIVE DOOR

- CL of Punch Out
- * MFR
- SPECIAL MATERIAL
  - GALV.
  - S.S.
  - CRS
- GAGE: _____

(*) This Information is for MACHINING REFERENCE ONLY
ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405
715-223-6324 PARALLEL BEVEL SET FAX: 715-223-3352

Please Check One: □ 209 W/ASTRALGAL □ 225 DOUBLE EDGE RH/LHR ACTIVE

CUSTOMER: ___________________ DATE: ___________________ DOOR #: ___________________

P.O.: ___________________ M.O.: ___________________

ACCESSORY ITEM #: ___________ DOOR ITEM: ___________________

NO. of SETS REQ.: ___________ DATE REQ.: ___________ DRAWN BY: ___________________ DATE: ___________

□ STD. BEIGE □ SPECIAL COLOR: ___________________ □ NO PAINT □ VENEER: ___________________

□ LEAD LINED ASTRALGAL LIP WIDTH: ___________
   □ 1/16" LEAD □ 1/8" LEAD

LHR INACTIVE

RH INACTIVE

KEY SIDE

LHR INACTIVE

RH INACTIVE

KEY SIDE

ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

ACTIVE DOOR

DOOR: □ 1-3/4" □ 1-13/16" □ OTHER: ___________

□ <-----Mark for NO ASTRALGAL LIP

CL

TOP

CL

* MFL

OAL

BOTTOM

CL

STRIKE

- □ 4-7/8 X 1-1/4 w/2-3/8 Lip
- □ 2-3/4 X 1-1/8 w/1-1/2 Lip
- □ TEMPLATE #

LOCK

- □ 1-1/8 X 2-1/4
- □ 1-1/4 X 1-1/4
- □ TEMPLATE #

* MFL

SPECIAL MATERIAL

□ GALV. □ S.S. □ CRS

GAGE: ________

<------ 2nd STRIKE/LOCK ------->

CL

CL

AUTOMATIC FLUSHBOLTS

<table>
<thead>
<tr>
<th>Type</th>
<th>Actual Cutout Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Auto. 356</td>
<td>1 x 8-1/8 w/7/8 radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 8-1/2 w/7/8 radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 8 w/7/8 radius</td>
</tr>
<tr>
<td>Manual 358</td>
<td>1 x 6-3/4 w/sq. corners</td>
</tr>
<tr>
<td>Manual</td>
<td>1 x 6-3/4 w/sq. 12&quot;, 24&quot;, etc., rod</td>
</tr>
<tr>
<td>Other</td>
<td>1 x 6-3/4 w/sq.</td>
</tr>
</tbody>
</table>

Flushbolts with 12, 24, etc., rods give dimension to CL, for all others give dimension from end of channel to end of cutout.

(*) This Information is for MACHINING REFERENCE 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: __________________________

INACTIVE DOOR

DOOR:  □ 1-3/4"  □ 1-13/16"  □ OTHER: __________________________

ACTIVE DOOR

OAL

FIRE PINS for
Less Bottom Rod (LBR) Applications

DIA.

* MFL

DIA.

* MFR

SPECIAL MATERIAL
□ GALV.
□ S.S.
□ CRS

GAGE: ____________

(*) This Information is for MACHINING REFERENCE ONLY
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: ____________________________

INACTIVE DOOR

DOOR: ☐ 1-3/4" ☐ 1-13/16" ☐ OTHER: ____________________________
☐ <-----Mark for NO ASTRAGAL LIP

ACTIVE DOOR

OAL

DIA. DIA.

* MFL * MFR

FIRE PINS for
Less Bottom Rod (LBR) Applications

SPECIAL MATERIAL
☐ GALV. ☐ S.S. ☐ CRS

GAGE: ______

(*) This Information is for MACHINING REFERENCE ONLY
ALL DIMENSIONS ARE FROM TOP OF DOOR.

ACTIVE DOOR

DOOR:  □ 1-3/4"  □ 1-13/16"  □ OTHER: ____________

□ SQUARE <-----Mark for Square Channel------> SQUARE

LOCK

□ 1-1/8 X 2-1/4
□ 1-1/4 X 8
□ TEMPLATE #

STRIKE

□ 4-7/8 X 1-1/4 w/3-3/8 LIP
□ 2-3/4 X 1-1/8 w/1-1/2 LIP
□ TEMPLATE #

□ 2ND NOTCHED LIP

STRIKE LIP LENGTH ____________

<----- 2nd LOCK/STRIKE ------->

LOCK

□ 1-1/8 X 2-1/4
□ 1-1/4 X 8
□ TEMPLATE #

STRIKE

□ 4-7/8 X 1-1/4 w/3-3/8 LIP
□ 2-3/4 X 1-1/8 w/1-1/2 LIP
□ TEMPLATE #

NOTCHED LIP --> STRIKE LIP LENGTH ____________

OAL

□ GALV.
□ S.S.
□ CRS

SPECIAL MATERIAL

GAGE: ________ (*) This Information is for MACHINING REFERENCE ONLY

Lead Lined Astragal flange cannot be notched.

□ LEAD LINED ASTRAGAL

LIP WIDTH: ________

□ 1/16" LEAD  □ 1/8" LEAD

Cut Strike Lip or Notch Astragal

RH ACTIVE

LH INACTIVE
ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

☐ SQUARE <-----Mark for Square Channel #214

STILE WIDTH _____________ 1-5/8" Standard

STRIKE

☐ 4-7/8 X 1-1/4 w/NO LIP
☐ 2-3/4 X 1-1/8 w/NO LIP
☐ TEMPLATE # ____________

☐ NO LIP FOR SHIPPING
☐ SPECIAL MATERIAL
☐ GALV.
☐ S.S.
☐ CRS

GAGE: ____________

Flushbolts with 12, 24, etc., rods give dimension to CL, for all others give dimension from end of channel to end of cutout.

(*) This Information is for MACHINING REFERENCE ONLY
ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

STILE WIDTH 1-5/8" Standard

☐ SQUARE <----- Mark for Square Channel #214

STRIKE

☐ 4-7/8 X 1-1/4 w/NO LIP
☐ 2-3/4 X 1-1/8 w/NO LIP
☐ TEMPLATE #

<------ 2nd STRIKE

STRIKE

☐ 4-7/8 X 1-1/4 w/NO LIP
☐ 2-3/4 X 1-1/8 w/NO LIP
☐ TEMPLATE #

Flushbolts with 12, 24, etc., rods give dimension to CL, for all others give dimension from end of channel to end of cutout.

(*) This Information is for MACHINING REFERENCE ONLY
ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR
- STILE WIDTH 1-5/8" Standard

□ SQUARE <----- Mark for Square Channel #214

- STRIKE
  □ 4-7/8 x 1-1/4 w/NO LIP
  □ 2-3/4 x 1-1/8 w/NO LIP
  □ TEMPLATE #

<-------- 2nd STRIKE

- STRIKE
  □ 4-7/8 x 1-1/4 w/NO LIP
  □ 2-3/4 x 1-1/8 w/NO LIP
  □ TEMPLATE #

GAGE: ________

** flushbolts with 12, 24, etc., rods give dimension to CL, for all others give dimension from end of channel to end of cutout.**

<table>
<thead>
<tr>
<th>FLUSHBOLTS</th>
<th>Actual/ Cutout Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Auto. 356</td>
<td>1 x 8-1/6 w/4 radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 8-1/2 w/4 radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 9 w/4 radius</td>
</tr>
<tr>
<td>Manual 3sg</td>
<td>1 x 6-3/4 w/sq. corners</td>
</tr>
<tr>
<td>Manual</td>
<td>1 x 6-3/4 w/sq. 12&quot;,24&quot;,etc. rod</td>
</tr>
<tr>
<td>Other</td>
<td></td>
</tr>
</tbody>
</table>

(*) This Information is for MACHINING REFERENCE ONLY
ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405
715-223-6324 "T" ASTRAGAL FAX: 715-223-3352

Please Check One: □ 229A REVERSE BEVEL □ 214A SQUARE LH/RHR ACTIVE

CUSTOMER: ___________________ DATE: ___________________ DOOR #: ___________________
P.O.: ___________________ M.O.: ___________________ ACCESSORY ITEM #: __________ DOOR ITEM: ___________________
NO. of PCS. REQ.: __________ DATE REQ.: __________ DRAWN BY: __________ DATE: __________
□ STD. BEIGE □ SPECIAL COLOR: ___________________ □ NO PAINT □ VENEER: ___________________

Cut Strike Lip or Notch Astragal
LHR INACTIVE

RHR ACTIVE

KEY SIDE

Lead Lined Astragal flange cannot be notched.
□ LEAD LINED ASTRAGAL
LIP WIDTH: __________
□ 1/16" LEAD □ 1/8" LEAD

LH ACTIVE

Cut Strike Lip or Notch Astragal
RH INACTIVE

KEY SIDE

ALL DIMENSIONS ARE FROM TOP OF DOOR.

ACTIVE DOOR
□ SQUARE <-----Mark for Square Channel #214A

STILE WIDTH __________ 1-5/8" Standard

Lock
□ 1-1/8 X 2-1/4
□ 1-1/4 X 8
□ TEMPLATE # __________

□ 2ND NOTCHED LIP
STRIKE LIP LENGTH __________
CL of Strike __________

GAGE: __________

2nd LOCK

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 location __________

(*) This Information is for MACHINING REFERENCE ONLY
ALL DIMENSIONS ARE FROM TOP OF DOOR.

ACTIVE DOOR

SQUARE <-----Mark for Square Channel #214A

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

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 location

(*) This Information is for MACHINING REFERENCE ONLY
2/16/07  ALL METAL STAMPING, INC., ABBOTSFORD, WI.  54405
715-223-6324  "Z" ASTRAGAL  FAX: 715-223-3352

Please Check One:  □ 237 SQUARE  □ 238 STD. BEVEL 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:


ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

DOOR:  □ 1-3/4"  □ 1-13/16"  □ OTHER: ___________________________

□ SQUARE ——— Mark for Square Channel #237

STRIKE

□ 4-7/8 X 1-1/4 w/3-3/8 LIP
□ 2-3/4 X 1-1/8 w/1-1/2 LIP

□ TEMPLATE # ___________________________

<——— 2nd STRIKE

STRIKE

□ 4-7/8 X 1-1/4 w/3-3/8 LIP
□ 2-3/4 X 1-1/8 w/1-1/2 LIP

□ TEMPLATE # ___________________________

SPECIAL MATERIAL

□ GALV.
□ S.S.
□ CRS

GAGE: ___________________________

Flushbolts with 12, 24, etc., rods give dimension to CL. for all others give dimension from end of channel to end of cutout.

<table>
<thead>
<tr>
<th>FLUSHBOLTS</th>
<th>Actual Cutout Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Auto. 356</td>
<td>1 x 8-1/8 w/% radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 8-1/2 w/% radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 9 w/% radius</td>
</tr>
<tr>
<td>Manual 358</td>
<td>1 x 6-3/4 w/eq. corners</td>
</tr>
<tr>
<td>Manual</td>
<td>1 x 6-3/4 w/eq. 12&quot;, 24&quot;, etc. rod</td>
</tr>
<tr>
<td>Other</td>
<td></td>
</tr>
</tbody>
</table>

(*) This Information is for MACHINING REFERENCE ONLY.
ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405
715-223-6324 “Z” ASTRAGAL FAX: 715-223-3352

Please Check One: □ 237 SQUARE □ 238 STD. BEVEL RH/LHR ACTIVE

CUSTOMER: ___________________________ DOOR #: ___________________________
P.O.: ___________________ DATE: ___________________________
M.O.: ___________________________ ___________________________
ACCESSORY ITEM #: ___________________ DOOR ITEM: ___________________________
NO. of SETSREQ.: _______ DATE REQ.: ___________________________ DRAWN BY: _______ DATE: _______
□ STD. BEIGE □ SPECIAL COLOR: ___________________ □ NO PAINT □ VENEER: ___________________________

LHR ACTIVE

□ 1-3/4" □ 1-13/16" □ OTHER: ___________

ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

□ 1-3/4" □ 1-13/16" □ OTHER: ___________

<< Astragal Lip □ SQUARE ------Mark for Square Channel #237

STRIKE

□ 4-7/8 X 1-1/4 w/3-3/8 LIP
□ 2-3/4 X 1-1/8 w/1-1/2 LIP
□ TEMPLATE #

<-------- 2nd STRIKE

SPECIAL MATERIAL

□ GALV. □ S.S. □ CRS

GAGE: _______

Flushbolts with 12, 24, etc., rods give dimension to CL, for all others give dimension from end of channel to end of cutout.

(*) This Information is for MACHINING REFERENCE ONLY

<table>
<thead>
<tr>
<th>FLUSHBOLTS</th>
<th>Actual Cutout Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Auto. 356</td>
<td>1 x 8-1/8 w/4 radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 8-1/2 w/4 radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 9 w/4 radius</td>
</tr>
<tr>
<td>Manual 35e</td>
<td>1 x 6-3/4 w/sq. corners</td>
</tr>
<tr>
<td>Manual</td>
<td>1 x 6-3/4 w/sq. 12&quot;,24&quot;,etc. rod</td>
</tr>
<tr>
<td>Other</td>
<td></td>
</tr>
</tbody>
</table>
ALL DIMENSIONS ARE FROM TOP OF DOOR.

DOOR: □ 1-3/4" □ 1-13/16" □ OTHER: __________
□ SQUARE ------Mark for Square Channel #237

STRIKE
□ 4-7/8 X 1-1/4 w/3-3/8 LIP
□ 2-3/4 X 1-1/8 w/1-1/2 LIP
□ TEMPLATE #__________

<-------- 2nd STRIKE

CL

TOP

CL

* MFR

OAL

BOTTOM

CL

Flushbolts with 12, 24, etc., rows give dimension to CL, for all others give dimension from end of channel to end of cutout.

(*) This information is for MACHINING REFERENCE ONLY
ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405
715-223-6324 "Z" ASTRAGAL FAX: 715-223-3352

CUSTOMER: ___________________________ DATE: ___________________________ DOOR #: ___________________________

P.O.: ___________________________ M.O.: ___________________________

ACCESSORY ITEM #: ___________________________ DOOR ITEM: ___________________________

NO. of SETS REQ.: ___________________________ DATE REQ.: ___________________________ DRAWN BY: ___________________________ DATE: ___________________________

☐ STD. BEIGE ☐ SPECIAL COLOR: ___________________________ ☐ NO PAINT ☐ VENEER: ___________________________

ALL DIMENSIONS ARE FROM TOP OF DOOR.

INACTIVE DOOR

☐ 1-3/4" ☐ 1-13/16" ☐ OTHER: ___________________________

<-- Astragal Lip ☐ SQUARE <-- Mark for Square Channel #237

SPECIAL MATERIAL
☐ GALV. ☐ S.S. ☐ CRS

GAGE: ___________________________

Flushbolts with 12, 24, etc., rods give dimension to CL, for all others give dimension from end of channel to end of cutout.

<table>
<thead>
<tr>
<th>FLUSHBOLTS</th>
<th>Actual Cutout Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Auto. 356</td>
<td>1 x 8-1/8 w/¼ radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 8-1/2 w/¼ radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 9 w/¾ radius</td>
</tr>
<tr>
<td>Manual 358</td>
<td>1 x 6-3/4 w/q. corners</td>
</tr>
<tr>
<td>Manual</td>
<td>1 x 6-3/4 w/q. 12&quot;, 24&quot;, etc., rod</td>
</tr>
<tr>
<td>Other</td>
<td></td>
</tr>
</tbody>
</table>

(*) This Information is for MACHINING REFERENCE ONLY
ALL DIMENSIONS ARE FROM TOP OF DOOR.

ACTIVE DOOR

Astragal Lip ->

DOOR: □ 1-3/4" □ 1-13/16" □ OTHER: ________
□ SQUARE <---- Mark for Square Channel #237A

LOCK
□ 1-1/8 X 2-1/4
□ 1-1/4 X 8
□ TEMPLATE #________

□ 2ND NOTCHED LIP
STRIKE LIP LENGTH ________
<----- 2nd LOCK

LOCK
□ 1-1/8 X 2-1/4
□ 1-1/4 X 8
□ TEMPLATE #________

□ NOTCHED LIP--> STRIKE LIP LENGTH ________

SPECIAL MATERIAL
□ GALV.
□ S.S.
□ CRS

GAGE: ________

(*) This Information is for MACHINING REFERENCE ONLY
ALL DIMENSIONS ARE FROM TOP OF DOOR.

ACTIVE DOOR

DOOR: □ 1-3/4" □ 1-13/16" □ OTHER: ________________

<-- Astragal Lip □ SQUARE <-----Mark for Square Channel #237A

LOCK
□ 1-1/8 X 2-1/4
□ 1-1/4 X 8
□ TEMPLATE #______________________

□ 2ND NOTCHED LIP STRIKE LIP LENGTH
<--------- 2nd LOCK

SPECIAL MATERIAL
□ GALV.
□ S.S.
□ CRS

GAGE: __________

(*) This Information is for MACHINING REFERENCE ONLY
ALL METAL STAMPING, INC., ABBOTSFORD, WI. 54405
715-223-6324
FAX: 715-223-3352

Please Check One: □ 230 □ 234 “U” HINGE 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: __________________

LH/RHR TOP VIEW

ALL DIMENSIONS ARE FROM TOP OF DOOR

RH/LHR TOP VIEW

SPECIAL MATERIAL

□ S.S □ GALV. □ CRS

20 GA. (.035) STANDARD

GAGE: ________________

□ Mark for SQUARE Channel #234

PCS. REQ. LH

PCS. REQ. RH

Hinge size

4-1/2" or 5" Standard

*MFR (*) MACHINING REFERENCE ONLY

* MFL

AMS USE ONLY
#250 DOOR EDGE w/5" LEGS - 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: ___________________________

☐ SQUARE ← MARK FOR SQUARE CHANNEL → ☐ SQUARE

DOOR SIZE:
☐ 1-3/4"
☐ 1-13/16"
☐ 2-1/4"
☐ OTHER

LOCK
☐ 1-1/8 X 2-1/4
☐ 1-1/4 X 8
☐ TEMPLATE #________

STRIKE
☐ 4-7/8 X 1-1/4 w/3-3/8 LIP
☐ 2-3/4 X 1-1/8 w/1-1/2 LIP
☐ TEMPLATE #________

<table>
<thead>
<tr>
<th>FLUSHBOLTS</th>
<th>Actual Cutout Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Auto. 356</td>
<td>1 x 8-1/8 w/1/4 radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 8-1/2 w/1/4 radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 9 w/1/4 radius</td>
</tr>
<tr>
<td>Manual 358</td>
<td>1 x 6-3/4 w/sq. corners</td>
</tr>
<tr>
<td>Manual</td>
<td>1 x 6-3/4 w/sq. 12&quot;,24&quot;,etc. rod</td>
</tr>
<tr>
<td>Other</td>
<td>1 x 6-3/4</td>
</tr>
</tbody>
</table>
#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: __________________________

☐ Square ←---------- Mark for Square Channel ----------→ ☐ Square

Door Size:
☐ 1-3/4"
☐ 1-13/16"
☐ 2-1/4"
☐ Other

Lock:
☐ 1-1/8 x 2-1/4
☐ 1-1/4 x 8
☐ Template # ________

Strike:
☐ 4-7/8 x 1-1/4 w/3-3/8 Lip
☐ 2-3/4 x 1-1/8 w/1-1/2 Lip
☐ Template # ________

<table>
<thead>
<tr>
<th>Flushbolts</th>
<th>Actual Cutout Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>Auto. 356</td>
<td>1 x 6-1/8 w/1/4 radius</td>
</tr>
<tr>
<td>Automatic</td>
<td>1 x 6-1/2 w/1/4 radius</td>
</tr>
<tr>
<td>Manual 358</td>
<td>1 x 6 w/1/4 radius</td>
</tr>
<tr>
<td>Manual</td>
<td>1 x 6-3/4 w/sq. corners</td>
</tr>
<tr>
<td>Other</td>
<td>1 x 6-3/4 w/sq. 12&quot;, 24&quot;, etc. rod</td>
</tr>
</tbody>
</table>
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 all 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.
# 222 LH/RHR DOOR w/STRIKE ON ASTRAGAL EDGE

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: ___________________________

ALL DIMENSIONS ARE FROM LOCK EDGE OF DOOR.

ASTRALGAL

ASTRALGAL LIP UP

KEY SIDE

RHR

ASTRALGAL LIP DOWN

KEY SIDE

ASTRALGAL LIP DOWN

ASTRALGAL LIP UP

ASTRALGAL LIP DOWN

KEY SIDE

LH

KEY SIDE

ASTRALGAL LIP UP

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

#204 DUTCH DOOR TEMPLATE #216

☐ 1-3/4" ☐ 1-13/16" ☐ OTHER: ___________________________

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 w/1-1/2 LIP

☐ TEMPLATE #________

OAL

CL

LOCK

☐ 1-1/8 X 2-1/4

☐ 1-1/4 X 8

☐ TEMPLATE #________

CL
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: __________

ALL DIMENSIONS ARE FROM LOCK EDGE OF DOOR.

ASTRALGAL

DOOR:  □ 1-3/4"  □ 1-13/16"  □ OTHER: __________
#204 DUTCH DOOR TEMPLATE #216

STRIKE
☐ 4-7/8 X 1-1/4 w/3-3/8 LIP
☐ 2-3/4 X 1-1/8 w/1-1/2 LIP
☐ TEMPLATE # __________

SPECIAL MATERIAL
☐ GALV.
☐ S.S.  GAGE: ______
☐ CRS

OAL

LOCK
☐ 1-1/8 X 2-1/4
☐ 1-1/4 X 8
☐ TEMPLATE # __________