

C/S Acrovyn® Doors

ACROVYN DOOR SYSTEM - MACHINE SHEET GUIDE

This machine sheet guide has been developed to help CS customers provide all necessary information to fabricate and machine their Acrovyn Door System requirements. Following this guide will help ensure that your doors are built accurately and avoid delivery delays due to missing information. Please use this guide in conjunction with the attached machine sheet which includes numerical cross references. Please contact your local CS representative, regional sales manager or sales coordinator with any questions.

1. Provide **FRAME OPENING DIMENSIONS** Width x Height (Example 3/0 x 7/0).
2. Provide the **PREFIT DOOR DIMENSIONS** Width x Height allowing for clearance at the latch jamb, hinge jambs and header. Also, take into account the undercut dimension when determining the prefit height.

The typical clearance CS allows at jambs is 1/8" (1/4" total). For example, the prefit width for a 3'-0" opening would be 2'-11 3/4". CS allows 1/16" per leaf (1/8" total between leaves) at the meeting edge of a standard pair configuration. The prefit height is determined by deducting 1/8" at the header + the specified undercut dimension.

3. Indicate the **TYPE OF OPENING** such as Single, Pair, Double Egress (DE) or Dutch. Please provide all Dutch door information, including shelf size, side of door, height of top and bottom leaves and any other relative information that will ensure the requirement is fabricated correctly.
4. Specify the **FIRE RATING** requirement (NR, SM, 20, 45, 60 or 90). Also indicate whether doors are to be Positive Pressure (PP) or require an S Label (S).
5. Indicate whether **BLOCKING** is required for closers, exit devices, etc. Standard CS blocking is 5". If special blocking is required, please indicate type and location in the machining information.
6. Provide the **CS FACE COLOR NUMBER AND COLOR NAME**. (Example #372 Classic Maple)
7. Provide the **CS EDGE COLOR NUMBER AND COLOR NAME**. (Example #372 Classic Maple or SS for Stainless Steel)
8. Please indicate **LITE OR LOUVER** requirements if specified. If a lite is required, indicate whether the dimensions provided reflect exposed glass or the actual cut out. Provide the lite width x height, location from the lock stile to lite and location from the top of door to lite.

If CS is supplying the lite kit(s), please indicate the type of kit required. The lite kits available from CS are metal*, wood veneer*, wood bead or wood overlap.

* All Metal Stampings, Inc., model 110 is CS standard metal and wood veneer kits and will be supplied unless notified otherwise.

If lite kits are to be supplied by others, please provide the Manufacture and Model so the proper clearances can be allowed.

IMPORTANT NOTE 1: The maximum exposed glass allowed in CS fire rated doors using standard wire glass and listed lite kits is as follows:

20 min.	1,296* sq. in.
45 min.	1,296 sq. in.
60 min.	100 sq. in.
90 min.	100 sq. in.

* Lite kits with larger exposed glass areas are available using specific glazing and or kits. Contact you local CS representative, regional sales manager or sales coordinator for larger lite kit limitations.

IMPORTANT NOTE 2: 20, 45, 60 & 90 minute certifications limit the following cutout distances:

- 5" from top and sides, all doors
- 10" from bottom all doors
- 1.5" from lock NR & 20(excluding 20 LL)
- 5" from lock 45/60/90 and 20LL

Please consider this when specifying lite size and location.

9. If **FLUSHBOLTS** are required, specify the Manufacturer, Model, Location and Template number. Also advise whether the flushbolt is required top and bottom or top only.
10. If **CONCEALED CLOSERS / STOPS** are required, specify the Manufacturer, Model and Template number. Also provide the degree of opening for each requirement.
11. If **DEADLOCKS** are required, specify the Manufacturer, Model, Location and Template number.
12. If **CONCEALED VERTICAL RODS** are required, specify the Manufacturer, Model and Template number.

Any additional machining requirements that are not already indicated should be specified in this section. Include manufacturer, model, sizes and locations if applicable.

13. If **KICKPLATES** are required specify whether *Stainless Steel or Acrovyn are required. Also provide height and required on push or pull side, or both.



* CS standard Stainless Steel kickplates are fabricated with ¼” legs that return between the replaceable edges and door core. If conventional flat kickplates are preferred, please indicate such on the machine sheet.

14. When **BUTT HINGES** are specified, location dimensions should be taken from the top of door to the top of each hinge.
15. Provide the **HINGE BACKSET**. To reduce the chance a door will bind once installed, CS will not machine a door with a hinge backset spec. greater than ¼”.
16. Provide the **UNDERCUT** dimension. (The clearance from finished floor to door bottom) Please review the following guideline when specifying clearances for fire rated doors:

In accordance with NFPA80 Section 4.8.4.1 the clearance under the bottom of the door shall be a maximum of ¾”.

NOTE: Some local code authorities may not have adopted 4.8.4.1 yet. Therefore it is the responsibility of whoever is providing the machining information to confirm applicable under door clearances with their local code authority.

17. Provide **LOCKSET LOCATION** from top of door to center of lockset.
18. Provide **LOCK BACKSET**.
19. Provide **STRIKE** information, especially when it is to be machined in the inactive leaf of a pair or when an Electric Strike is specified.
20. Provide **STRIKE LOCATION** taken from top of frame to center of the strike plate.
21. Provide **DEADLOCK LOCATION** if required. Also include manufacturer, model, size, backset and template no.
22. Provide all **HINGE INFORMATION** including manufacturer, model, size (including height and thickness) and template no.
23. Provide all **LOCKSET INFORMATION** including manufacturer, model, (specify whether cylindrical* or mortise) and template no.

* If a cylindrical latch is specified indicate the latch bore diameter at location 23.
24. Show all **DOOR NUMBERS** that are to be fabricated and machined in accordance with the information provided thus far. Separate multiple door numbers on the same line using a comma (,)
25. Indicate the **SWING** for all doors shown on the list created in 24. (LH, RH, LHR or RHR) This is determined by the door swing as viewed from the outside or secured side of the opening. See the machine sheet detail for further clarification. Note, doors with panic hardware / exit devices must be RHR or LHR.

26. Provide the **CUSTOMER** contact information CS should use if questions arise.
27. Provide the **NAME OF THE PROJECT**.
28. Include the **SIGNATURE** of the person providing the fabrication and machining information.
29. Show the **DATE** when the machine sheets were prepared.
30. Show the **PAGE NUMBER**.

