



Fusion 90 Minute Plant-On Molding

Fire-Rated Fusion Door 90 Minute (Positive Pressure) Plant-On Moldings – Category A & B Machining Specifications As of November 2006

Hardware Preparation:	All hardware to be prepared for must be labeled and listed
Hinges:	Per NFPA 80, Table 2-4.3.1, mortised ball-bearing hinges
Latch Sets:	Positive latching is required on all fire doors. Roller latches are not allowed.
Cylindrical:	Maximum 2 1/8 diameter hole with maximum 5" backset, minimum 2 3/4" backset, maximum centerline height 42" above floor
Mortise:	Maximum 1 1/16" wide x 4 1/2" deep x 6 1/2" high
Fire Exit Devices:	Rim, surface vertical rod, concealed vertical rod (CVR)
Closing Devices:	Floor closers, surface mounted closers (must be mounted with through bolts). Spring hinges (2 per leaf) closing devices must be per UBC 7-2 1997
Dust Boxes for Strike:	Required on pairs, must be metal construction – plastic not allowed
Dead Bolts:	Mortised minimum 5" from latch cutout, cylindrical minimum 5" CL to CL
Interconnected Dead Bolts:	Allowed
Flush Bolts:	Surface, mortised, automatic and manual
Viewers:	Maximum 1" diameter
Von Duprin EPT Device:	3" composite stile or 2" composite stile with lock block
Protection Plates:	Allowed up to 16" from bottom of door
Automatic Door Bottoms:	Surface, semi-mortised and mortised allowed. Maximum cutout 1" x 3/4". N/A
Metal Edges & Astragals:	*Metal edges not allowed with intumescent.* Supplied with all CVR construction: when metal edge is used, cat A is satisfied.
Raceways:	Maximum 3/8" x 3/8" channel, lower 40" of door, no closer than 1 1/8" to molding
Plant-Ons:	One or both faces, maximum width = 2 3/8"; maximum thickness 3/4", not closer than 3 1/2" from edge or hardware cutout, not more than 20% of door
Vision Panels:	100 sq. in. glass 90 min., minimum of 5 3/8" from edge of molding, door or hardware cutout
Dutch Doors:	N/A
Door & Transom:	Must be same construction as door. Transom bar must be used. Spring bolts must be applied as follows: 2" from each corner up to 18" tall require 2 per side; 18"-36" tall require 3 per side; 36"-40" require 4 per side.
Installation Instructions:	Installation instructions must be supplied with all orders that are machined. The instruction sheet must be <u>securely attached to each pallet of doors.</u>
Labeling:	Warnock Hersey "ONLY" may be used. The labels must be applied 60" from the bottom of the door on the hinge side. The only exception is when a "continuous hinge" is used; then a label shall be applied to the top rail. "S" label must accompany the label.
Secondary Labels:	These are to be overlapped with the main label to indicate the following: fire exit hardware, surface mounted hardware, fire retardant edges, listed side panel, "S" label for positive pressure.