



Inchcape Testing Services

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MACHINING SPECIFICATIONS

FOR

FERCHE MILLWORK, INC.
P.O. BOX 39
RICE, MINNESOTA 56367

**FERCHE 20 MINUTE WITHOUT HOSE STREAM WOOD VENEERED
SIDELITE / BORROWED LITE FRAME**

REPORT NO: 13153 - 764

ANY CHANGES OR MODIFICATIONS OF THIS MACHINING
SPECIFICATION MUST BE APPROVED BY INCHCAPE TESTING SERVICES NA, INC.
IN WRITING.

ANY DEVIATIONS FROM THIS SPECIFICATION WILL BE
CAUSE FOR REJECTION OF THE FRAME.

FEBRUARY 1996

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PRE - MACHINING INSPECTION

Each unmachined fire door frame eligible for a certification label shall have the following stamped identification on the back of the door frame:

1. Manufacturer's name: FERCHE MILLWORK;
2. Hourly rating: 20 MINUTE LITE FRAME; and
3. WH registered logo.

SIZE

Maximum Height	8'0"
Maximum Width	4'0"
Minimum Jamb Depth	3-3/4"
Maximum Visible Light	4600 square inches

MINIMUM DIMENSIONS

Jamb Thickness	3/4"
Applied Stop Depth	5/8"
Applied Stop Width	1-1/4"
Casing:	
Thickness	1/4"
Width	1-1/2"

Refer to figure 1.

NOTE: Stop to be rabbeted to accept clip.

GLAZING

Glass	Glass is to be nominal 1/4" fire rated wired glass.
Glazing Clips	26 gauge galvanized steel proprietary (Ferche Millwork) glazing clips. Clips are to be spaced 6" or less from corners; 12" or less between clips; a minimum of two clips per side.
Sealant	Glazing tape or silicone caulk

INSTALLATION INSTRUCTIONS

Installation instructions for frames shall include at least the following information:

1. Maximum height and width allowed.
2. Maximum space allowed between frame and buck stud, and insulation requirements (1/8" without insulation; 1/4" with insulation).
3. Type and size of fasteners with maximum spacing and attachment methods. (Jamb installation: 10d nails or 2-1/2" screws; 24" o.c.) (Stops installed with: 16 gauge staples or 1-1/4" brads and field nailed with 6d nails, minimum of 2" from ends and 12" o.c.) (Clips installed with: Clip #1 • 18 gauge staples or 4d nails; Clip #2 • 4d nails).

Refer to figure 2.

MARKINGS

Each machined door frame shall have a certification label attached at approximately eye level on the hinge jamb with minimum 5/8" spiral nails.

DRAWINGS INDEX

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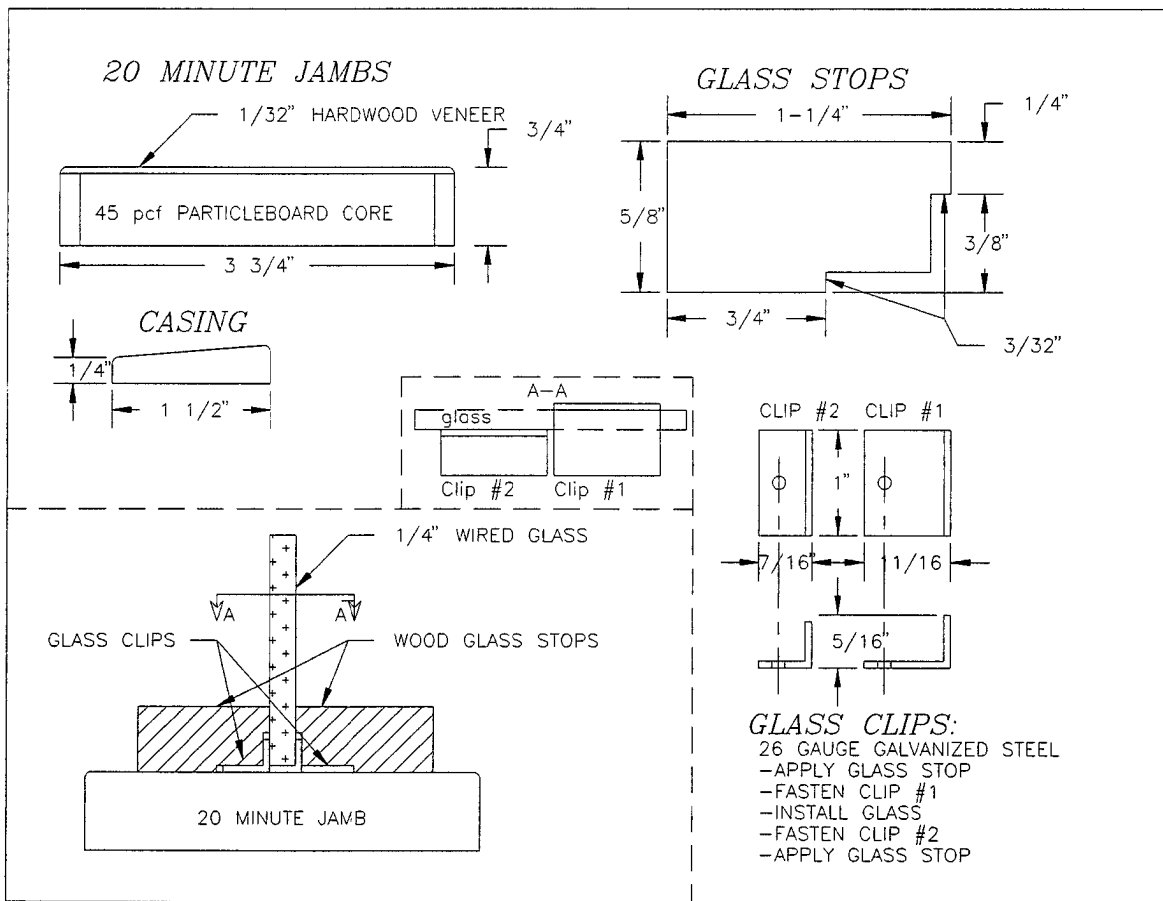


Figure 1 • Frame Components

Installation Instructions

for the

20 Minute

Fireframe

a

Door Frame & Sidelight Frame

Manufactured by

Ferche Millwork

Listed by

Warnock Hersey



General Specifications

Door Jamb

Maximum Door Size - 8'0" x 8'0"

Jamb Thickness - 3/4"

Minimum Jamb Width - 3 3/4"

Stop - 5/8" x 1 1/2"

Casing - 1/4" x 1 1/2" (min.)

Sidelight/Borrowed Lite

Maximum window size - 4'0" x 8'0"

Jamb Thickness - 3/4"

Minimum Jamb Width - 3 3/4"

Stop - 5/8" x 1 1/4"

Casing - 1/4" x 1 1/2" (min.)

Glazing Clips - 26 ga. galvanized steel

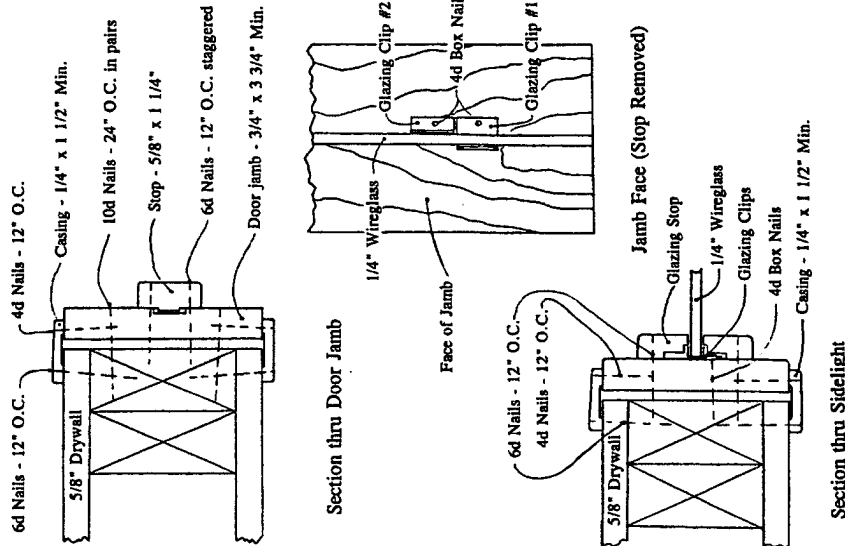
Glazing Compound - Silicone caulk or Tremco #440

glazing tape

Approved wood species for face veneer and edge strips - oak, cherry, mahogany, maple, poplar or any hardwood as dense or denser than poplar.

Figure 2 • Installation Instructions (Part 1)

Illustrations



20 Minute Door Frame Installation

Rough Opening - The maximum allowable gap between back of jamb and the framing member is 1/4". Example of opening size: a 3' 0" x 7' 0" door (85" jaw dia) requires a rough opening of 36" x 86".

Jamb Header/Side Assembly - Sides attach to header with 3-6d nails or 3 #8 x 2" screws.

Jamb Attachment - Fasten frame to studs with 10d nails in pairs at a maximum of 24" O.C. Place wood shims behind the nails.

Stop Attachment - Stop applied with 16 ga. staples or 1 1/4" brads. Field nail with 6d nails at 12" O.C., minimum of 2" from end. T-stop can be adjusted 1/4" within plough.

Shim Space - Any space between back of jamb and framing material which is greater than 1/4" must be filled with fiberglass.

Casing - Casing is nailed to jamb with 4d nails and nailed to structural member with 6d nails. Space nails at 12" O.C.

Hinge Attachment - Each hinge and strike will be attached to the jamb with one of the hinge screws having a minimum length of 3". Place shim behind each hinge and strike location.

Gasketing - Gasket shall be installed and applied in accordance with NFPA 80.

20 Minute Sidelight Frame Installation

Rough Opening - Finished opening to be 1/4" greater in height and width than wireglass. The maximum allowable gap between back of frame and the framing member is 1/4".

Frame Assembly - Sides of frame to be dadoed to accept top and bottom of frame. Assemble with 3 - 6d nails or 3 - #8 x 2" screws.

Frame Attachment - Fasten frame to studs with 10d nails in pairs at a maximum of 24" O.C. Place wood shims behind the nails.

Stop Attachment/Glazing Assembly - Glazing will be held in place with wooden stops as well as Ferche glazing clips. Install stop around inside of opening with 6d nails at 12" O.C. Position glazing clip (the one with the longer leg) against stop and fasten to frame with a 4d nail. Clips to be located within 6" of the corners and no more than 12" apart. Minimum of 2 clip sets per side. Place a bead of silicone caulking or a strip of Temco #440 glazing tape against stop. Place 1/8" thick neoprene setting blocks at the quarter points of the bottom frame member. Insert wireglass into frame. Position glazing clips (the clips with the shorter leg) next to the previously attached clips and fasten to the frame with 4d nails. Apply silicone or glazing tape, position wood stop and nail with 4d nails as before.

Shim Space - Any space greater than 1/8" between back of frame and structural member must be filled with fiberglass.

Casing - Casing is nailed to frame with 4d nails and nailed to structural member with 6d nails. Space nails at 12" O.C.

Figure 2 • Installation Instructions (Part 2)