

HOLLOW METAL

By **HMMA**

Hollow Metal Manufacturers Association
Ask for NAAMM Standards . . .

HMMA 800-96	<i>Introduction to Custom Hollow Metal</i>	HMMA 860-92	<i>Guide Specifications for Hollow Metal Doors and Frames</i>
ANSI/NAAMM HMMA 801-05	<i>Glossary of Terms for Hollow Metal Doors and Frames</i>	ANSI/NAAMM HMMA 861-00	<i>Guide Specifications for Commercial Hollow Metal Doors and Frames</i>
HMMA 802-92	<i>Manufacturing of Hollow Metal Doors and Frames</i>	ANSI/NAAMM HMMA 862-03	<i>Guide Specifications for Commercial Security Hollow Metal Doors and Frames</i>
HMMA 803-97	<i>Steel Tables</i>	ANSI/NAAMM HMMA 863-04	<i>Guide Specifications for Detention Security Hollow Metal Doors and Frames</i>
HMMA 810-87	<i>Hollow Metal Doors</i>	ANSI/NAAMM HMMA 865-03	<i>Guide Specifications for Swinging Sound Control Hollow Metal Doors and Frames</i>
HMMA 820-87	<i>Hollow Metal Frames</i>	ANSI/NAAMM HMMA 866-01	<i>Guide Specifications for Stainless Steel Hollow Metal Doors and Frames</i>
HMMA 830-02	<i>Hardware Selection for Hollow Metal Doors and Frames</i>	HMMA 867	<i>Guide Specifications for Commercial Laminated Core Hollow Metal Doors and Frames</i>
HMMA 831-97	<i>Recommended Hardware Locations for Custom Hollow Metal Doors and Frames</i>		
HMMA 840-99	<i>Installation and Storage of Hollow Metal Doors and Frames</i>		
HMMA 841	<i>Tolerances and Clearances for Hollow Metal Doors and Frames</i>		
HMMA 850-00	<i>Fire Rated Hollow Metal Doors and Frames</i>		



A Division of
NAAMM

≡ National Association of Architectural Metal Manufacturers ≡

Technical Summary HMMA 890-06

Hollow Metal by HMMA

Table of Contents

HMMA Guide Specifications	2
<i>Summary information on guide specifications for door and frame applications available from members of the Hollow Metal Manufacturers Association, Division of NAAMM.</i>	
Fire-Rated Doors	4
<i>Chart showing fire-rated doors (up to 3 hrs.) available from HMMA member firms.</i>	
Hollow Metal Doors	5
<i>Depicts some of the wide variation in door styles and construction details available from HMMA member firms.</i>	
Fire-Rated Frames	6
<i>Chart showing fire-rated frames (up to 3 hrs.) available from HMMA member firms. Also shows variety of frame profiles.</i>	
Frame Construction and Details	7
<i>Depicts a typical frame assembly and details of joints, jamb anchors, cut-off stops and a field assembled drywall frame.</i>	
Hardware Preparation and Locations	8
<i>Details on a variety of hardware preparations and recommended hardware locations.</i>	
Manufacturing Tolerances	9
<i>Recommended manufacturing and installation tolerances, plus guides to proper storage of doors and frames.</i>	
The Hollow Metal Manual	Back Cover
<i>Description of HMMA's technical publication, The Hollow Metal Manual (available in hard copy and on CD).</i>	

HMMA Guide Specifications

Hollow Metal Guide Specifications	HMMA 860 - Hollow Metal Doors & Frames	HMMA 861- Commercial Hollow Metal Doors and Frames	HMMA 862 - Commercial Security Hollow Metal Doors and Frames	HMMA 863 - Detention Security Hollow Metal Doors and Frames	HMMA 865 - Swinging Sound Control Hollow Metal Doors and Frames
Intended applications	For use in apartment and other building projects where traffic is light and hard usage is not anticipated	For use in commercial and industrial projects, where rigorous use is anticipated . . . schools, office buildings, hospitals, industrial buildings, hotels, convention centers, nursing homes	Commercial security applications such as airports, convention centers, hotels and offices, and foreign and domestic buildings such as, embassies, offices and barracks.	For use in jails, prisons, detention centers and secured areas in hospitals and courthouses	For applications in TV, radio and sound studios, theaters and music rooms
Doors					
Face Sheets, Interior Doors	0.032 in. (0.8mm)	0.042 in. (1.0mm)	0.067 in. (1.7mm)	0.067 in. (1.7mm) 0.093 in. (2.3mm)	0.042 in. (1.0mm)
Face Sheets, Exterior Doors	0.042 in. (1.0mm)	0.053 in. (1.3mm)	0.067 in. (1.7mm)	0.067 in. (1.7mm) 0.093 in. (2.3mm)	0.042 in. (1.0mm)
Material Type	Pickled and oiled, hot rolled, or A60 Galvneal	Pickled and oiled, hot rolled, or A60 Galvneal	Pickled and oiled, hot rolled, or A60 Galvneal	Pickled and oiled, hot rolled, or A60 Galvneal	Pickled and oiled, hot rolled, or A60 Galvneal
Minimum thickness	1¾ in. (44.4mm)	1¾ in. (44.4mm)	1¾ in. (44.4mm)	2 in. (50.8mm)	1¾ in. (44.4mm)
Stiffeners/Core	0.026 in. (0.6mm)	0.026 in. (0.6mm)	0.042 in. (1.0mm)	0.042 in. (1.0mm)	Manufacturer's standard
Vertical Edges	Continuous weld interlocking seam, or intermittent welded exposed seam	Continuous weld	Continuous weld	Reinforced by 0.123 in. (3.1mm, 10 ga.) continuous steel channel, continuous weld	Manufacturer's standard
Top and Bottom Edges	0.053 in. (1.3 mm) continuous recessed steel channel	0.053 in. (1.3 mm) continuous recessed steel channel	0.093 in. (2.3 mm) continuous recessed steel channel	0.123 in. (3.1 mm)	0.053 in. (3.1 mm,) continuous recessed steel channel
Frames					
Interior Openings	0.042 in. (1.0mm) - 0.053 in. (1.3mm) for hollow core wood doors	0.053 in. (1.3mm) - 0.067 in. (1.7mm) for openings of more than 4 ft. (1219 mm)	0.093 in. (2.3mm)	0.093 in. (2.3mm) 0.067 in. (1.7mm)	0.067 in. (1.7mm)
Exterior Openings (1)	0.053 in. (1.3mm)	0.053 in. (1.3mm)- 0.067 in. (1.7mm) for openings over 4 ft. (1219mm) wide	0.093 in. (2.3mm)	0.093 in. (2.3mm) 0.067 in. (1.7mm)	0.067 in. (1.7mm)
Construction	Welded or knocked-down with integral stop and trim	Welded units with integral stop and trim	Welded units with integral stop and trim	Welded units with integral stop and trim	Welded units with integral stop and trim
Floor Anchors	0.053 in. (1.3mm) welded inside jambs	Same thickness as frame, welded inside jambs	Same thickness as frame, welded inside jambs	Same thickness as frame, welded inside jambs	0.067 in. (1.7mm), welded inside jamb
Jamb Anchors	In masonry walls (9), 0.053 in. (1.3mm) steel or 0.156-in. diam. steel wire. For stud partitions, 0.042 in. (1.0mm) steel anchors welded inside jambs	In masonry walls (9), 0.053 in. (1.3mm) steel or 0.156-in. diam. steel wire. For stud partitions, 0.042 in. (1.0mm) steel anchors welded inside jambs	In masonry walls (10), 0.067 in. (1.7mm) steel or 0.156-in. diam. steel wire. For stud partitions, 0.053 in. (1.3mm) steel anchors welded inside jambs	Same thickness as frame	In masonry walls (11), 0.053 in. (1.3mm) steel or 0.156-in. dia. steel wire. For stud partitions, 0.042 in. (1.0mm) steel anchors welded inside jambs
For complete specifications	See HMMA 860	See HMMA 861	See HMMA 862	See HMMA 863	See HMMA 865

Hollow Metal Guide Specifications	HMTA 866	HMTA 867
Intended applications	For specialized applications where corrosion resistance beyond that of commercial hollow metal, or where aesthetics is of primary concern	For commercial applications where moderate use is anticipated such as: office buildings, convention centers, and industrial buildings
Doors		
Face Sheets, Interior Doors	0.042 in. (1.0mm)	0.032 in. (0.8mm)
Face Sheets, Exterior Doors	0.042 in. (1.0mm)	0.042 in. (1.0mm)
Material Type	Type 304 or 316 Stainless Steel	Pickled and oiled, hot rolled, or A60 Galvalume
Minimum thickness	1/4 in. (4.4mm)	1/4 in. (4.4mm)
Stiffeners/Core	0.026 in. (0.6mm) Welded Stiffener or Laminated Core	Laminated Core
Vertical Edges	Welded or Exposed Seam	Welded or Exposed Seam
Top and Bottom Edges	Closed with 0.053 in. (1.3mm) continuous recessed	Closed with 0.053 in. (1.3mm) continuous recessed
Frames		
Interior Openings	0.053 in. (1.3mm) - 0.067 in. (1.7mm) for openings over 4 ft. (1219mm) wide	0.042 in. (1.0mm) for hollow core wood doors - 0.053 in. (1.3mm)
Exterior Openings	0.053 in. (1.3mm) - 0.067 in. (1.7mm) for openings over 4 ft. (1219mm) wide	0.053 in. (1.3mm)
Construction	Welded K.D. or slip-on with integral stop and trim	Welded K.D. or slip-on with integral stop and trim
Floor Anchors	0.067 in. (1.7mm) welded inside jambs	0.042 in. (1.0mm) welded inside jambs
Jamb Anchors	In masonry walls (9), 0.053 in. (1.3mm) steel or 0.156-in. diam. steel wire. For stud partitions, 0.042 in. (1.0mm) steel anchors secured inside jambs	In masonry walls (9), 0.053 in. (1.3mm) steel or 0.156-in. diam. steel wire. For stud partitions, 0.042 in. (1.0mm) steel anchors secured inside jambs
For complete specifications	See HMTA 866	See HMTA 867

General Notes

Materials: For doors and frames – commercial quality, level, cold-rolled steel conforming to ASTM A 1008/A 1008M or hot-rolled, pickled and oiled steel conforming to ASTM A 1011/A 1011M or stainless steel conforming to ASTM A 666, Type 304 or 316. Material thicknesses listed in chart are minimums. Where recommended in the guide specifications, use zinc-coated steel conforming to ASTM A 653 / A 653M.

Testing and Performance: **HMTA 861** requires the following test: Performance Test for Steel Doors and Hardware Reinforcings (ANSI A250.4). **HMTA 862** incorporates testing procedures and performance requirements promulgated by NILECJ for class IV doors (ASTM F 476) including Jamb/Wall Stiffness Performance, Door Impact Test, Door and Glazing Panel Impact Resistance Performance, (new test) and SD-STD-01.01 (Rev G) or LPS 1175: Issue 5 standards for Forced Entry and Ballistic Resistance Testing. **HMTA 863** requires the following tests: Static Load test; Rack test; Impact test; Edge Crush test; Side-light frame test; and multiple light frame test under ASTM F 1450 and F 1592. Bullet Resistance testing, where applicable, is performed in accordance with UL-752. Manufacturers must submit independent laboratory reports certifying performance required by these tests on sample doors and frames as specified in the standards. **HMTA 867** requires the following test: Performance Test for Steel Doors and Hardware Reinforcings (ANSI A250.4).

HMMA Fire-Rated Doors

HMMA leading the way in joint fire door testing, research and development; hose stream testing, positive pressure testing to UBC 7-2 and ISO 3008.

Fire Door Features

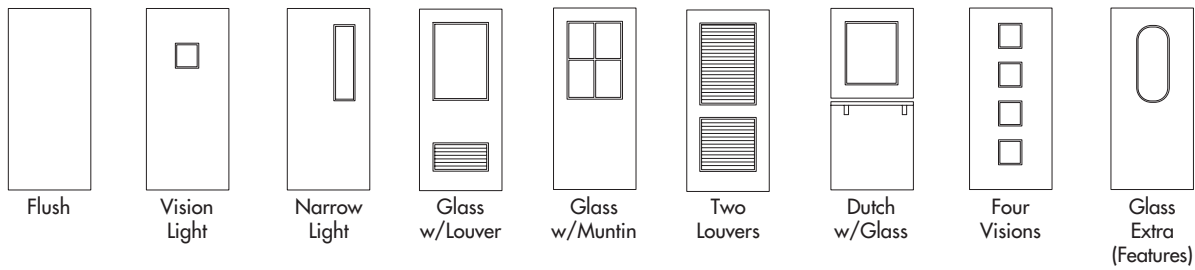
Door Description	Hourly Rating			Maximum Door Opening (2) Sizes	Swinging Single	Swinging in Pairs	Face Sheets				Single Door or Active Leaf of Pair				Pairs, Inactive Leaf				Without Astragal (up to 1-1½ hours)		
	3-hour	1-½-hour	¾-hour				0.093 in. (2.3mm)	0.067 in. (1.7mm)	0.053 in. (1.3mm)	0.042 in. (1.0mm)	Latch Throw	Latch	Mortise	Rim	Fire Exit Hardware		Open Back Strike	Automatic Flush Bolt		Manual Flush Bolt	With Astragal
															Vertical Rods, Concealed or Exposed	Vertical Rods, Concealed or Exposed					
Basic Fire Door	•	•	•	4'0"x8'0" 5'0"x12'0" 4'0"x10'0" 8'0"x8'0" 8'0"x8'0" 8'0"x10'0" 10'0"x12'0"	•	•	•	•	•	•	1/2" ¾" ¾" 1/2" 1/2" ¾" ¾"	•	•	•	•		•	•	•	•	•
Temperature Rise Fire-Rated 450°F 450°F 250°F 250°F	•	•	•	4'0"x10'0" 5'0"x12'0" 8'0"x10'0" 10'0"x12'0" 4'0"x8'0" 8'0"x8'0"	•	•	•	•	•	•	5/8" ¾" 5/8" ¾" 1/2" ¾"	•	•	•	•	•	•	•	•	•	•
Double Egress	•	•	•	8'0"x10'0"	•	•	•	•	•	•		•	•	•	•	•	•	•	•	•	•
Stainless Steel	•	•	•	4'0"x8'0" 8'0"x8'0"	•	•	•	•	•	•	¾ ¾	•	•	•	•	•	•	•	•	•	•
Dutch	•	•	•	4'0"x8'0"	•	•	•	•	•	•	¾"	•	•	•	•	•	•	•	•	•	•
Louvered	•	•	•	4'0"x8'0" 8'0"x8'0"	•	•	•	•	•	•	1/2" ¾"	•	•	•	•	•	•	•	•	•	•
Sound	•	•	•	4'0"x8'0"	•	•	•	•	•	•	1/2"	•	•	•	•	•	•	•	•	•	•
Radiation Retarding	•	•	•	4'0"x8'0" 8'0"x7'2" 8'0"x8'0"	•	•	•	•	•	•	1/2" ¾" ¾"	•	•	•	•	•	•	•	•	•	•
Pressure Resistant	•	•	•	3'6"x7'2"	•	•	•	•	•	•	¾"	•	•	•	•	•	•	•	•	•	•

The HMMA Division of NAAMM and its 60-plus member firms are leaders in fire door research and development. Through their ongoing joint fire test program, these hollow metal manufacturers construct and test a variety of fire-rated door and frame configurations. The most recent successful testing has been completed under "positive pressure" furnace conditions in accordance with UBC 7-2 and ISO 3008.

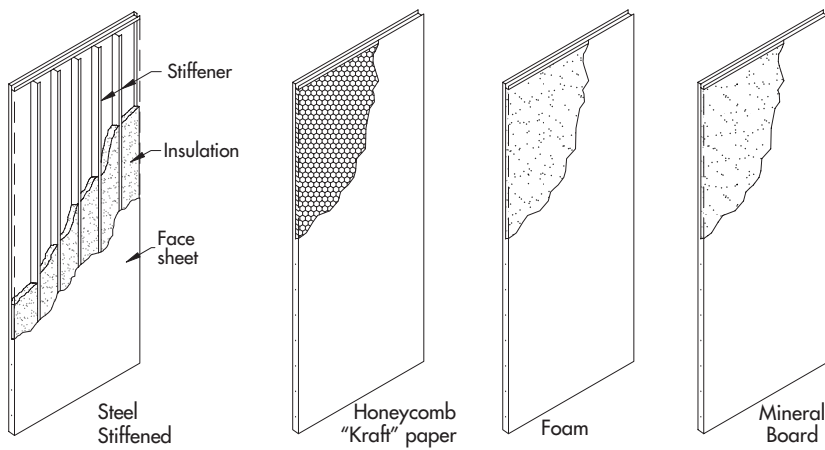
HMMA Hollow Metal Doors

5

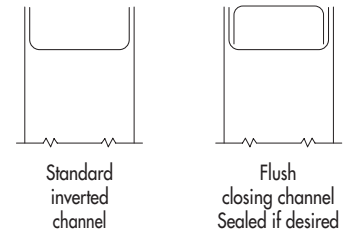
NAAMM's HMMA member companies offer wide variations in door design and construction. Illustrated below are just a few of the almost limitless designs available to meet hollow metal door requirements.



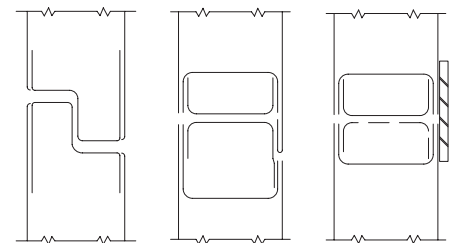
Core Constructions



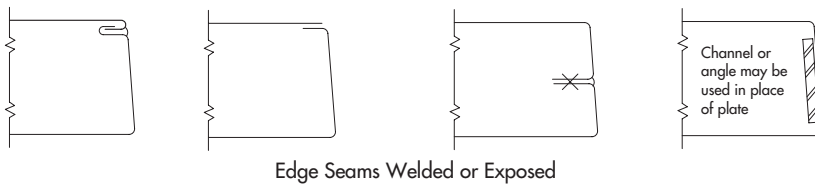
Top Edge Detail



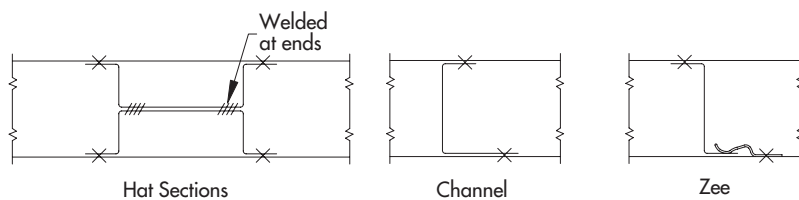
Flush Transom Panel



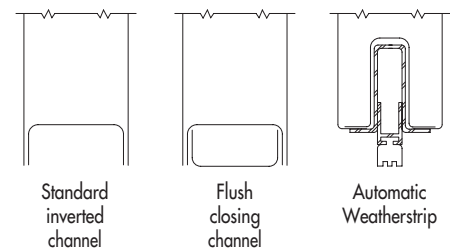
Common Beveled Edge Profiles



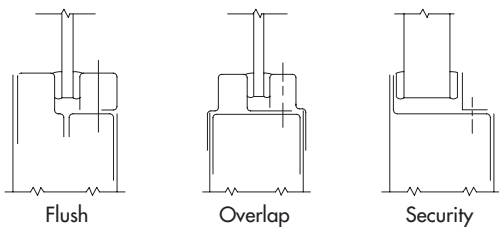
Representative Stiffener Sections



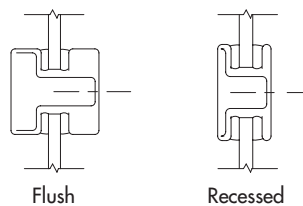
Bottom Edge Detail



Glass Lights



Muntins



HMMA Fire-Rated Frames

HMMA leading the way in joint fire door testing, research and development; hose stream testing, positive pressure testing to UBC 7-2 and ISO 3008.

Fire Frame Features

Frame Description	Hourly Rating			Maximum Frame Opening (2) Sizes	Swinging Single	Swinging in Pairs	(3)		Wall					Maximum Door or Window (2) Opening Sizes	Maximum Transom Light or Panel (1, 2) Opening Sizes	Maximum Side Light or Panel (1, 2) Opening Sizes			
	3-hour	1-1/2-hour	3/4-hour				0.093 in. (2.3mm, 12 ga.)	0.067 in. (1.7mm, 14 ga.)	0.053 in. (1.3mm, 16 ga.)	New Masonry	Existing Masonry	Steel Studs	Wood Studs				Adjustable Floor Knee	Cut-off Stop	Stainless Steel
Three-Sided Frame	•	•	•	4'0"x10'0" 5'0"x10'0" 8'0"x10'0" 10'0"x12'0"	•	•	•	•	•	•	•	•	•	•	4'0"x10'0" 8'0"x10'0" 10'0"x12'0"	4'0"x10'0"			
Double Egress	•	•	•	8'0"x10'0"	•	•	•	•	•	•	•	•	•	•	•	8'0"x8'0"			
Transom with Bar and 1 3/4" Panel	•	•	•	4'0"x11'0" 8'0"x11'0" 5'0"x12'0" 10'0"x12'0"	•	•	•	•	•	•	•	•	•	•	•	3'6"x7'2" 7'0"x7'2"	3'6"x3'6" 7'0"x3'0" 4'0"x4'0" 8'0"x4'0"		
Transom with Bar and 3/8" -3/4" Panels	•	•	•	4'0"x10'0" 8'0"x10'0" 5'0"x12'0" 10'0"x12'0"	•	•	•	•	•	•	•	•	•	•	•	4'0"x10'0" 8'0"x10'0" 10'0"x12'0"	4'0"x2'8" 8'0"x2'8"		
Transom with No Bar and 1"-3/4" Panels	•	•	•	4'0"x11'4" 8'0"x11'2"	•	•	•	•	•	•	•	•	•	•	•	4'0"x9'0" 8'0"x8'0"	4'0"x4'6" 8'0"x4'0"		
Multiple Swing Door Opening	•	•	•	12'0"x8'0" 13'6"x12'0"			•	•	•	•	•	•	•	•	•	8'0"x8'0"			
Fire Door With Transom and Side Light or Panel	•	•	•	13'6"x12'0" 13'6"x12'0" (4)	•	•	•	•	•	•	•	•	•	•	•	4'0"x10'0" 8'0"x10'0" 4'0"x10'0" 8'0"x10'0" 4'6"x4'6"	3'0"x4'0" 3'0"x4'0" 4'6"x4'6" 4'6"x4'6"	3'0"x4'6" 3'0"x4'6" 4'6"x4'6" 4'6"x4'6"	
Fire Window Frame	•	•		13'2"x11'7"			•	•	•	•	•					4'6"x4'6"			

(1) When glazing is used instead of panels in transoms and side lights, the maximum permitted rating is 1 1/2 hour.

(2) Equivalent metric dimensions in millimeters can be obtained by multiplying number of feet by 304.8.

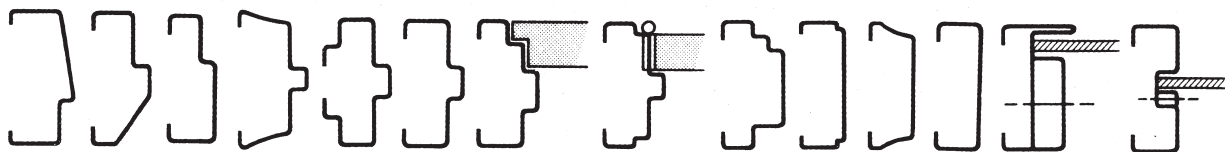
(3) Material thickness may vary for some approved products.

(4) Maximum dimensions per segment. May be in the same plane or projected.

HMMA Hollow Metal Frames

The widest variety of frame profiles are available from NAAMM HMMA members. A sampling of profile configurations is shown below:

Profile Variations

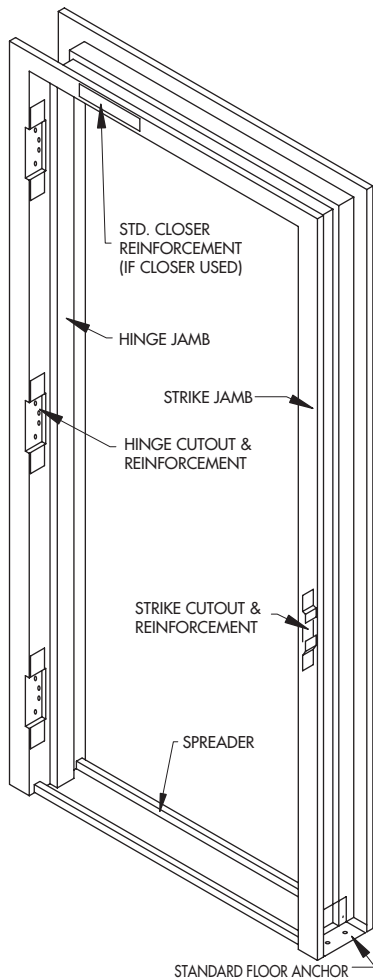


HMMA members furnish many combinations of features to meet special design considerations, functions and applications. For all the details, contact any HMMA member listed on the back.

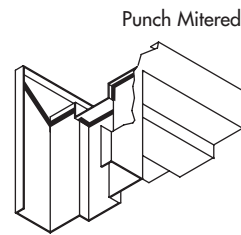
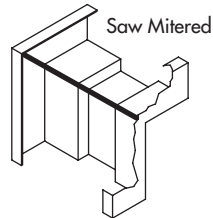
HMMA Frame Construction and Details

7

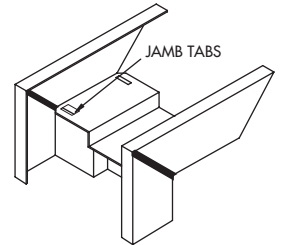
Typical Frame Assembly



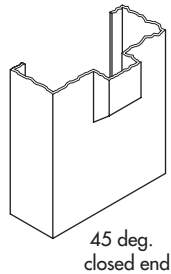
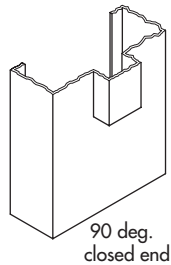
Continuously Welded Corner Joints



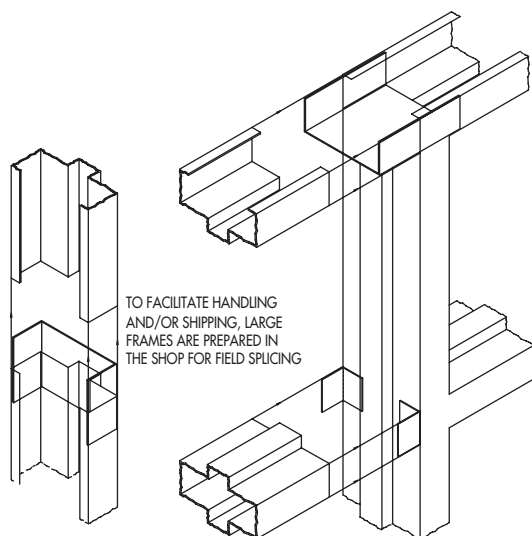
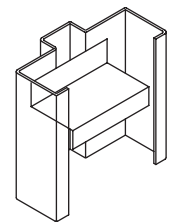
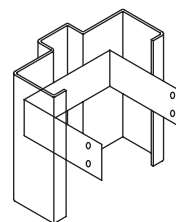
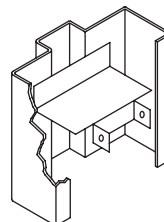
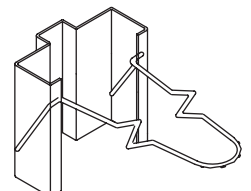
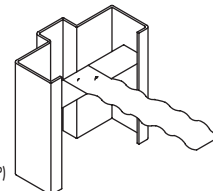
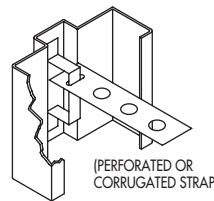
Face Welded Corner Joint



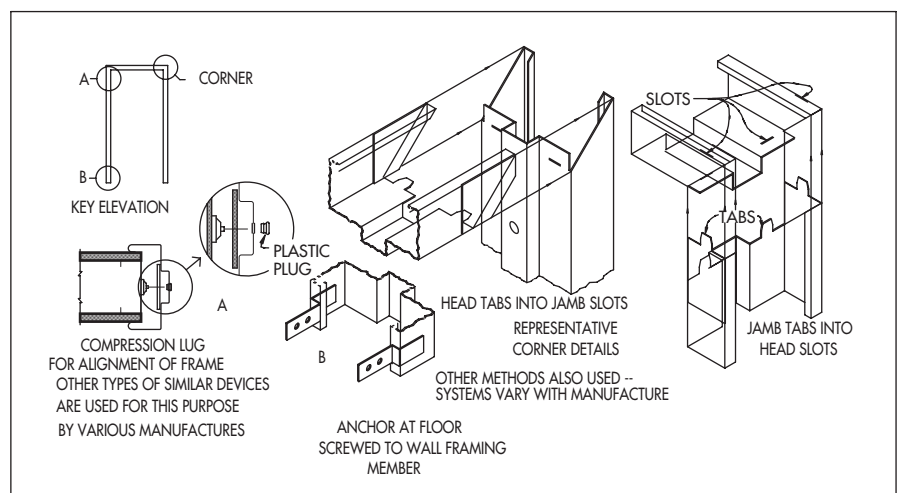
Cut-off Stops



Common Jamb Anchors

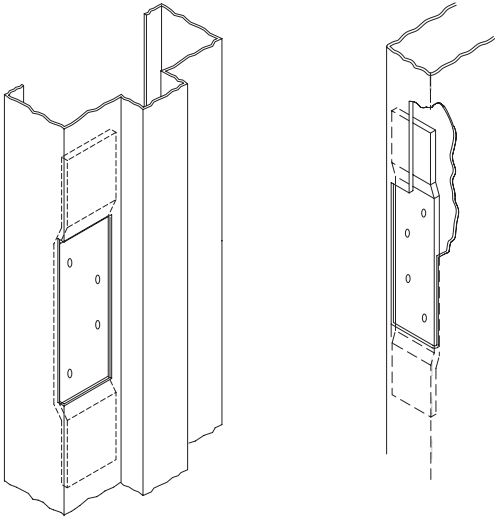


Field Assembled Drywall Frame

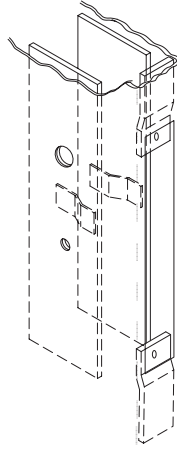


8 **HMMA** Hardware Preparation and Locations

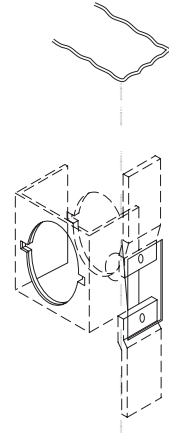
Butt Hinge



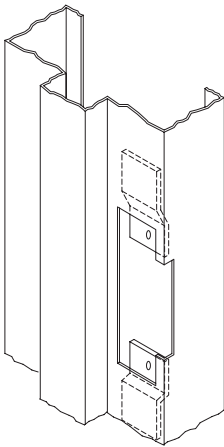
Mortise Lock



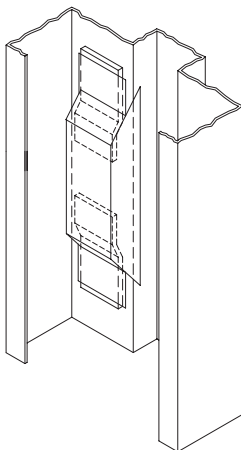
Cylindrical Lock



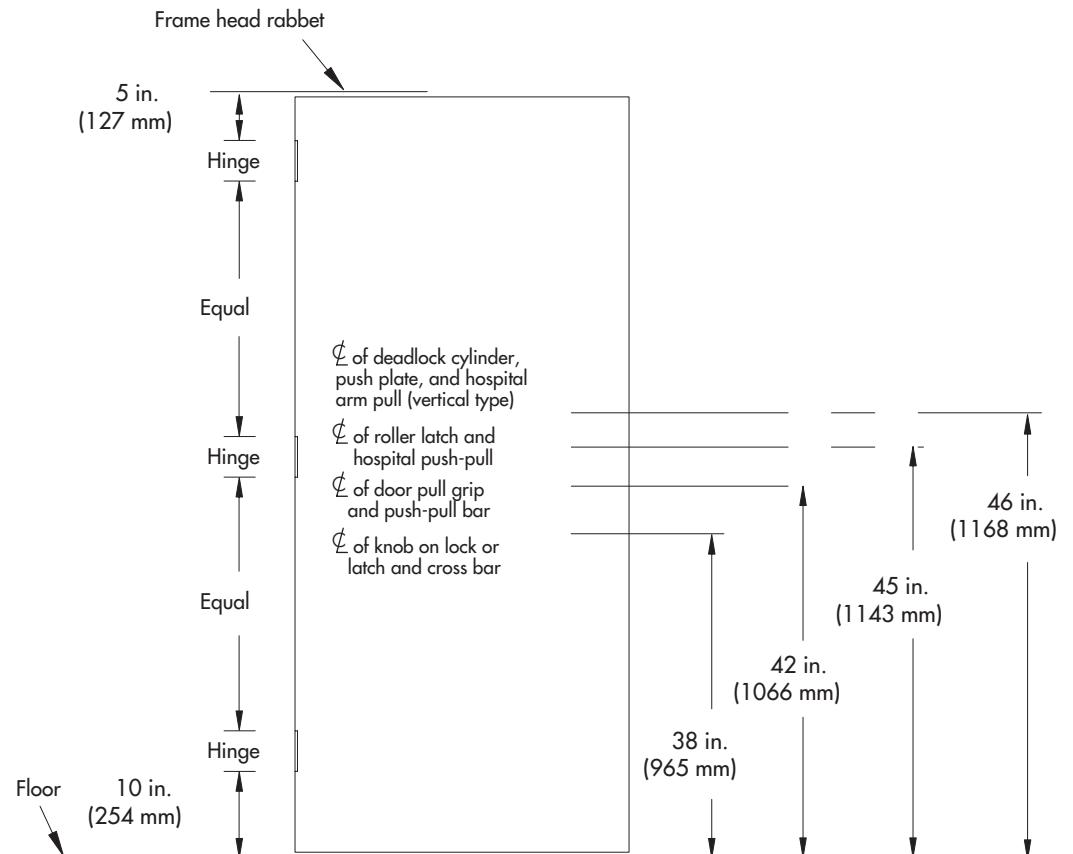
Strike in Frame



Mortar Guard

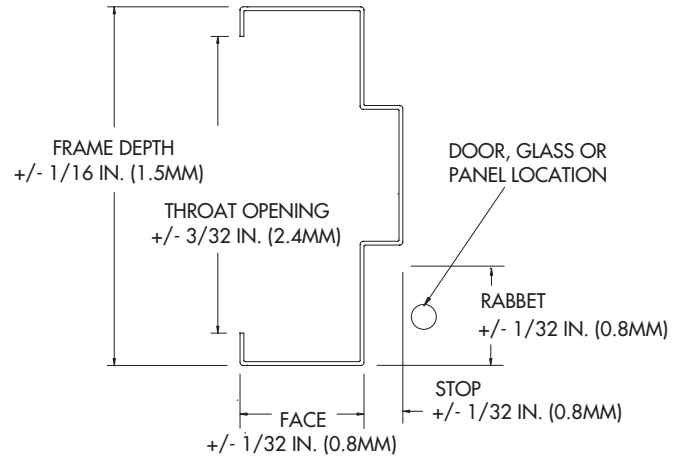


Recommended Hardware Locations



Manufacturing tolerances shall be maintained within the following limits:

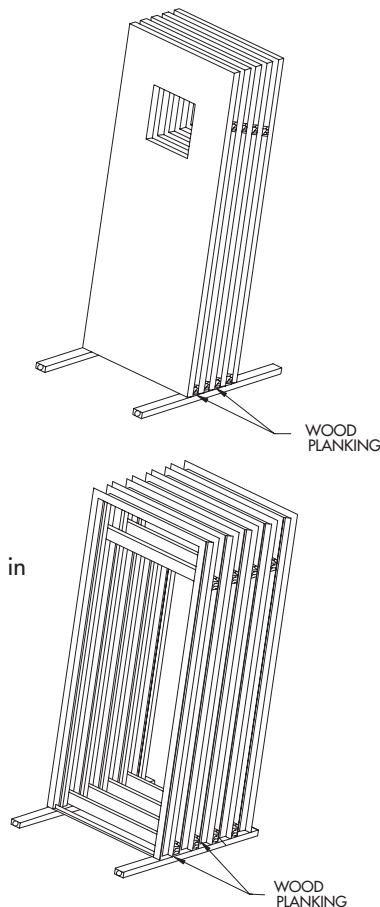
1. Frames for single door or pair of doors;
 - a. Width, measured between rabbets at the head: nominal opening width $+1/16$ in. (+1.5mm), $-1/32$ in. (-0.8mm).
 - b. Height (total length of jamb rabbet): nominal opening height $+1/16$ in. (+1.5mm), $-1/32$ in. (-0.8mm).
2. Doors:
 - a. Width $\pm 3/64$ in. (1.2mm)
 - b. Height $\pm 3/64$ in. (1.2mm)
 - c. Thickness $\pm 1/16$ in. (1.5mm)
3. Hardware:
 - a. Cutout dimension $+0.015$ in., -0 "
 - b. Location $\pm 1/32$ in. (0.8mm)



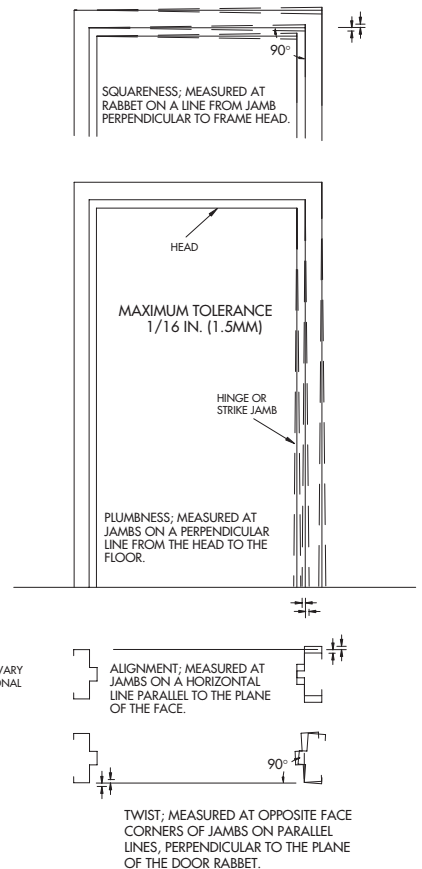
Storage

The contractor responsible for installation shall ensure that;

1. Wraps or covers from doors and frames are removed upon delivery.
2. Any scratches or disfigurements caused in shipping or handling are promptly cleaned and touched up with a rust-inhibitive primer.
3. Materials are properly on planks or dunnage in a dry location. Doors shall be stored in a verticle position and spaced by blocking.
4. Materials shall be covered to protect them from damage, but in such a manor as to permit air circulation.



Installation Tolerances



The Hollow Metal Manual

The **Hollow Metal Manual** is presented in 14 separate, saddle-stitched sections in an attractive three-ring binder. The Manual provides design professionals the most current information on manufacturing, door and frame designs and details, hardware preparation and location, installation and storage, fire-rated applications, common terms, plus the guide specifications.

The Hollow Metal Manufacturers Association (HMMA) Division of NAAMM, the National Association of Architectural Metal Manufacturers, publishes the **Hollow Metal Manual** to aid building design professionals in specifying hollow metal.

The HMMA guide specifications cover a broad range of door and frame applications. **HMMA 860** addresses doors and frames for light traffic areas. **HMMA 861** covers doors and frames appropriate for use in higher traffic, commercial applications. **HMMA 862** details doors and frames for commercial security applications; **HMMA 863** covers detention security doors and frames. **HMMA 865** is a guide for swinging sound control doors and frames. **HMMA 866** covers stainless steel hollow metal doors and frames. **HMMA 867** covers hollow metal doors and frames with laminated cores. HMMA members are ready to fill all your door and frame needs.

The Hollow Metal Manual is also available in downloadable form and on CD. Visit the Hollow Metal Manufacturers Association web site at www.hollowmetal.org.

Hollow Metal Manufacturers Association

a Division of

NAAMM

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