



Karpen Steel

Custom Doors & Frames

The Custom Quick-Ship Professionals

Division 08 1110



MADE ON *right.* *time.*

When we call ourselves *The Custom Quick-Ship Professionals*, it's not a declaration we take lightly. That's why we've adopted "Made Right. On Time." as the internal creed by which our company operates, and we back it with strict operating procedures that guarantee you get precisely what you need when you need it.

We employ an extensive system of checks and balances to ensure we manufacture to your exact specifications, with no less than six sets of eyes checking your order as it travels through customer service and engineering on its way to our shop. There we use the highest quality, American made materials to manufacture your product.

Not only do we work hard to give you the best quality products, we are committed to getting them to you exactly when you need them, even if that deadline is just days away. Our standard lead time is 10 working days, but our **RUSH** programs, especially designed for time critical orders, can get you your products even faster. While there are a few exceptions, most of our products are available on a 5-day **RUSH**. We also have **RUSH** programs that range anywhere from 1 to 9 working days from receipt of order. Our customer service team can also work with freight carriers to find you expedited shipping options.

In the end, the quality and efficiency of our work is best evidenced in our phenomenal customer satisfaction rates. Time after time, our clients express their appreciation for our attention to detail, often saying it feels like the Karpen Steel team is specifically looking out for their business. For us, it's simply a part of our service to you as *The Custom Quick-Ship Professionals*.

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DISTRIBUTION

Karpen Steel Custom Doors & Frames, as a manufacturer and member of DHI and NAAMM, strongly believes in the relationship between manufacturers, distributors, contractors, and the end user or owner. We sell only to distributors in the door and hardware industry. A distributor is defined as a professional supplying to the contracting profession the assorted components of architectural openings, including skilled services. The distributor has a direct, professional, business relationship with various manufacturers in the commercial door and hardware industry.

OUR WEBSITE CONTAINS OUR CATALOG, DRAWINGS FOR USE IN SUBMITTALS, AND COMPLETE PRODUCT LISTINGS.

KARPEN STEEL CUSTOM DOORS & FRAMES

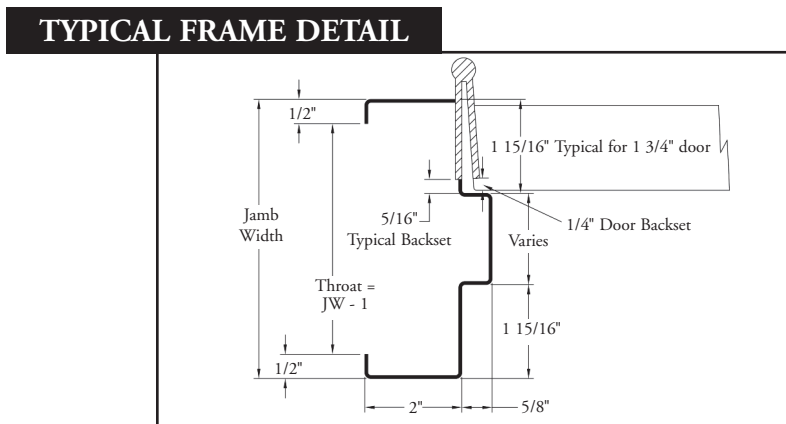
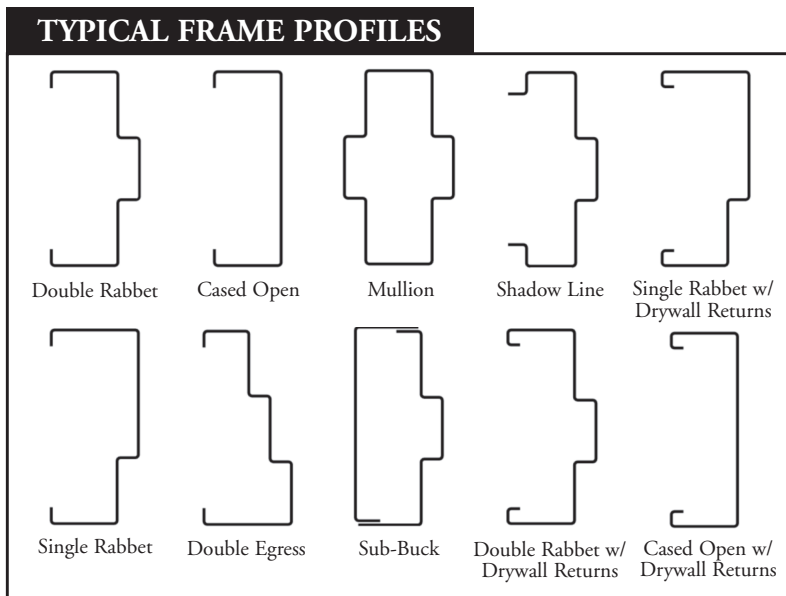
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**STEEL
doors
frames
POCKET
frames
acoustic
UNITS
lead-
lined
AND MORE...**

Frame SPECIFICATIONS

Karpen Steel manufactures custom hollow metal frames as specified.

FRAME MATERIALS		
MATERIAL TYPE	GAUGES	NOTES
Cold Rolled Steel (CRS)	14, 16	
Hot Rolled Pickled & Oiled (HRPO)	10, 12	3/4" backbends
A60 Galvannealed (A60 GALV) <i>Recommended where atmospheric conditions require extra protection.</i>	10, 12, 14, 16	3/4" backbends on 10 and 12 GA.
G90 Galvanized (G90 GALV)	14, 16	Special order. Not prime painted.
Stainless Steel (SS) (Type 304, #3/#4 Finish) <i>Recommended for areas where corrosive materials are present in the atmosphere.</i>	16	Not prime painted.



Profiles to be power brake formed in accordance with details shown on plans. Jamb and head to be assembled with tongue and slot connection. Miters accurately fitted, continuously welded on face, and ground smooth. Some profiles will be required to be manufactured with square cut head and jambs. Spreaders shall be welded to the bottom of the jambs to ensure safe shipment and parallel alignment in field setting.

REINFORCEMENTS

- Hinge reinforcement 7-gauge, 12" long
- Strike reinforcement 16-gauge with 11-gauge thread depth
- Flush bolt strike reinforcement 11-gauge
- Closer reinforcement 12-gauge, 18" long
- Frames shall be suitably reinforced for closers, brackets, and all other surface applied hardware.
- Drilling and tapping of surface hardware to be done in the field by the erector.

FINISH

- Frames shall be thoroughly cleaned after assembly, filled when necessary to ensure a smooth finish, and given a prime coat of rust inhibiting primer paint. The primer shall be air dried.

HINGE BACKSET

- 5/16" standard. Other backsets available

BACKBENDS

- 1/2" standard. Other backbends available

DOUBLE RABBET

- Equal Rabbet is standard
- Unequal is available

LEAD LINED

- See page 9.

FINISH

All frames (except stainless and G90) are prime painted.



UL LABELED 3-SIDED FRAMES

Karpen Steel can provide UL 3-hour labeled frames as follows:

PROFILE	WELDED/KD	JAMB WIDTH MIN/MAX
Double Rabbet	Welded	4"-14"
Single Rabbet	Welded	3"-4" 2" min. face door side
Single Rabbet	Welded	4"-14"
Double Egress	Welded or KD	5 3/4"-14"
Double Rabbet	KD	4 1/2"-14"
Single Rabbet	KD	3"-14"
Communicating Double Rabbet Only	Welded or KD	4 7/8"-14"

**Note: KD frames 2" min. face.
Welded frames 1 1/4" min. face typical.
Welded or KD 4" max. faces.*

BASE FRAME PRICING

Karpen Steel's base frame pricing is designed to allow you to give us the minimum amount of information in order to get your quote. Don't know if the hinges are standard or heavyweight? It doesn't matter. Don't know if you'll be using surface VR or flush bolts? That also doesn't matter.

PROFILE

- Standard 1/2" backbends
- Standard double rabbet, standard single rabbet or cased open
- 2" faces head and jamba

ANCHORS

- Steel stud, wood stud, new masonry or compression anchors

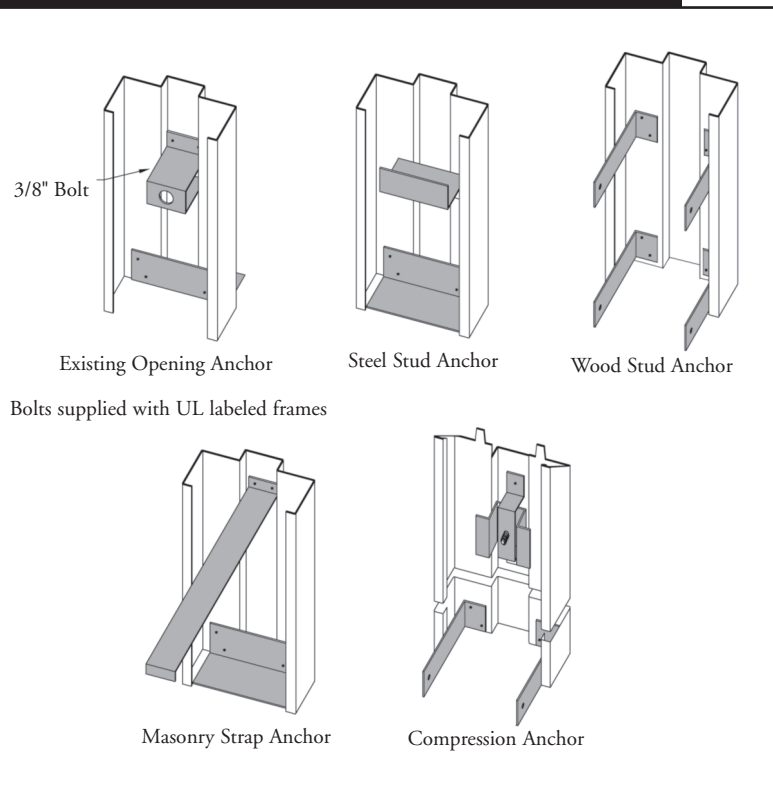
HARDWARE

- Hinges:
 - 4 1/2" or 5" standard or heavy weight hinges. Hinges can be at any location and any quantity.
 - Continuous hinges
 - Surface double acting hinges
- Closer reinforced – all frames for doors are reinforced for PA and regular arm closers
- Strikes:
 - ASA, 2 3/4", lipped or DL strikes
 - Rim panic (singles)
 - Surface VR or flush bolts (pairs)
- Silencers – If you need silencer holes, tell us; there's no up-charge, but they're not automatically provided

WELDED VERSUS KD

There is no add for us to weld the frames. Freight is typically less expensive for KD frames if you have your own welding shop.

TYPICAL FRAME ANCHORS (OTHERS AVAILABLE)



YOUR CUSTOM PROFILE HERE

WE DO CUSTOM WORK.

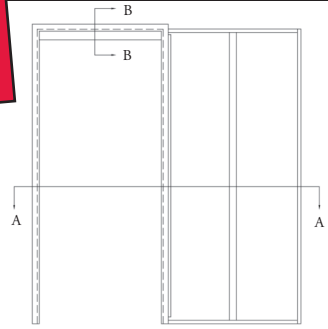
Karpen Steel can manufacture customized frame elevations to suit your unique designs, including Corner Posts, Angled Borrowed Lights and Round-Top Frames. See a photo gallery on our website.

KARPEN STEEL CUSTOM DOORS & FRAMES

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EASY TO INSTALL

POCKET DOOR FRAMES



Pocket Door Frame With Attached Hollow Metal Pocket.

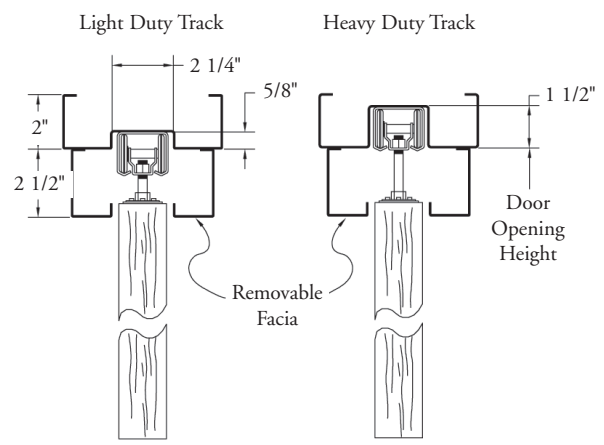
- Minimum Jamb Width is 4 1/2"
- For Single or Double Sliding Pocket Doors
- 16-Gauge, CRS, Standard
- Attached Hollow Metal Pocket(s) supplied with frame.
- Track by others

TYPICAL USES

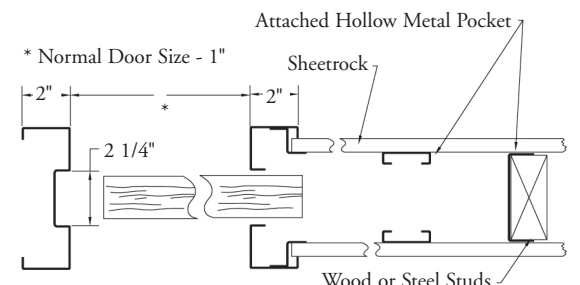
- Medical offices
- Hotel rooms
- Areas where limited space is available

OPTIONS

- Lead lined
- ADA accessible
- KD frame with welded pocket
- Different wall conditions on each side of pocket

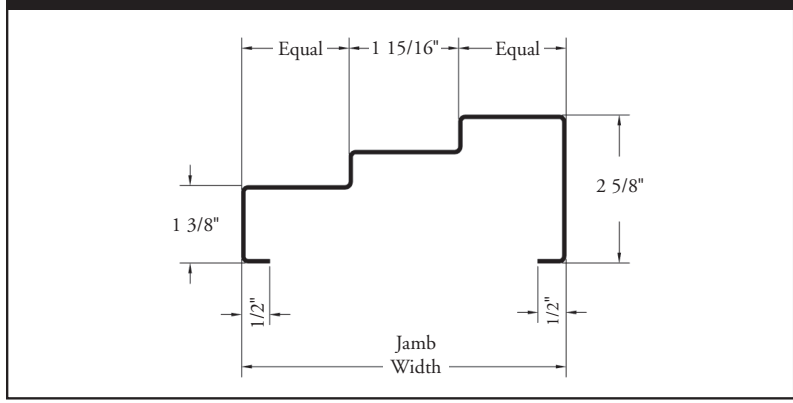


HEADER SECTION B-B



JAMBS SECTION A-A

DOUBLE EGRESS



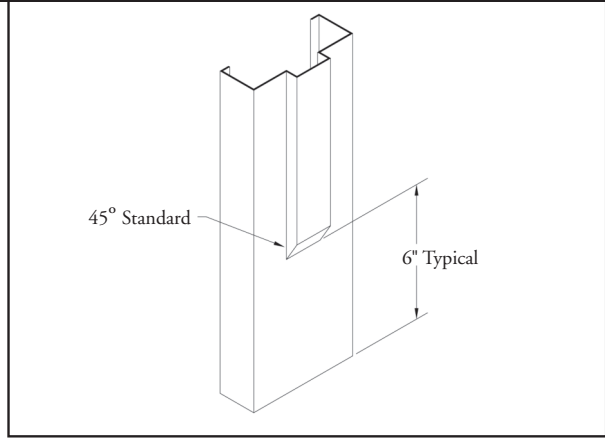
DOUBLE EGRESS FRAMES

- Jamb Width: 4 1/2" Min.
- Jambs: Double Egress Profile, 1 3/8" x 2 5/8" faces
- Head: Single Rabbet
- UL Label available

KNOCKED DOWN:

- Jamb width: 4 1/2" min.
- Jambs and heads: double egress profile

CUT-OFF STOPS



CUT-OFF STOPS

- Frame stop cut off at 45° angle and filled
- UL Label: 6" max.
- Specify desired height when ordering

TYPICAL USES:

- Hospitals
- Clean rooms

SIDELIGHT, BORROWED LIGHT AND TRANSOM FRAMES

UL LABEL CONFIGURATIONS

- Corner Post Frames
- Round Top Frames
- Transom and Sidelight Frames with Fixed Mullions
- A variety of configurations are available based on glazing material to be used. Send us a drawing of your specific requirements and we will work with you to provide a UL label for your opening.
- Note: Lights exceeding the rating or size limitations in NFPA 80 must be approved by the Authority Having Jurisdiction.

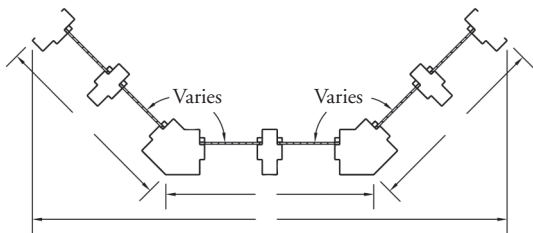


Round Top Window



Segmented Window Wall

EXAMPLE OF UL LABELED FRAMES WITH CORNER POSTS



YOUR CUSTOM ELEVATION HERE

SPLIT JAMB FRAMES

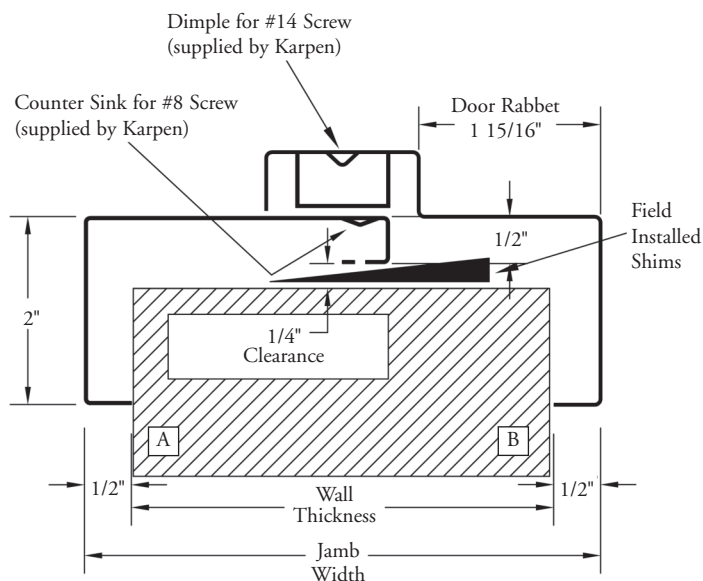
- These frames are used in applications where the exact wall thickness cannot be determined until the old frame is removed.
- With a 6" JW, adjustability is 1" from 5 3/4" to 6 3/4" JW (4 3/4" to 5 3/4" throat).
- Available as:
 - 3-sided door frame
 - Sidelight frame
 - 4-sided door frame
 - Transom frame

SIZING OF 3-SIDED SPLIT JAMB:

- Door Opening Width = Rough Opening - 1 1/2"
- Door Opening Height = Rough Opening - 3/4"

Note: All sizing based on 2" face. Double rabbet profile only.

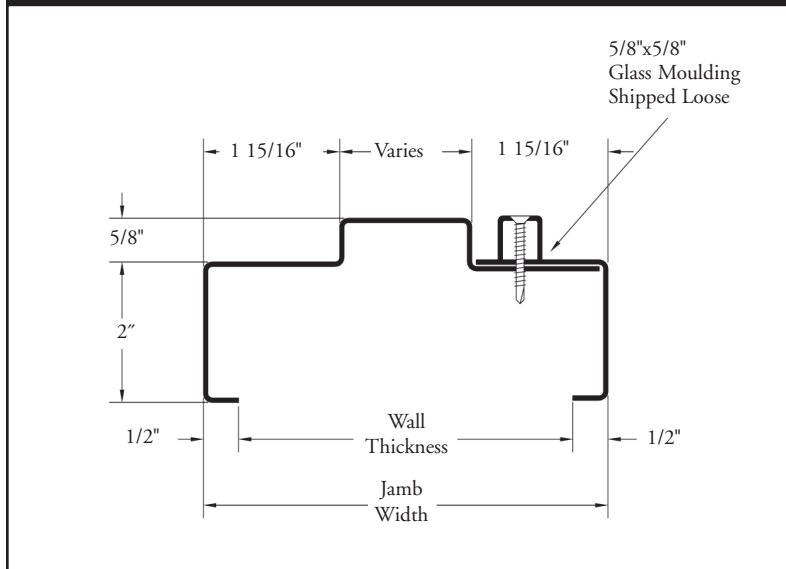
Contact factory for 4-sided Split Jamb sizing.



INSTALLATION INSTRUCTIONS:

1. Install Piece A (without stop) into existing opening using #8 screws. Shim as necessary to plumb and square the opening. This piece is installed on opposite side of the door side.
2. Place Piece B into opening. Using Piece B as a guide, drill clearance holes in Part A. Secure to wall using #14 screws.
3. Secure floor knees.

2-PIECE SLIP FRAMES FOR BORROWED LIGHTS



BIG SELLER

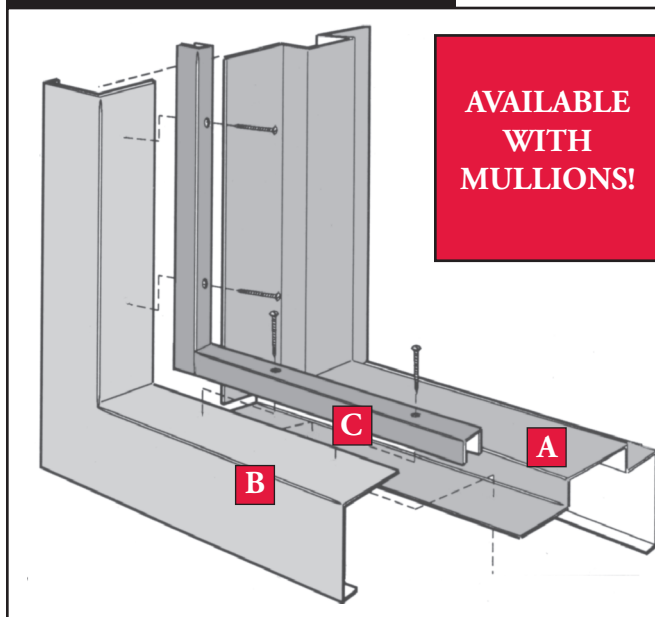
A fully-welded window frame for use in existing stud-walls. No anchors required. Just cut a hole in the wall, insert the frame from both sides of the opening, install the glass, and that's it!

SIZING

Cut the hole in the wall, give us the rough opening size, and we will size the 2-piece slip frame to fit. Or, give us your required overall dimensions, and we will advise the rough opening to fit.

- Available in cased open profile for sliding window units.
- Most sizes available in an economical 18-gage option.

INSTALLATION DRAWING



INSTALLATION INSTRUCTIONS

1. Mount larger half of frame (A) in existing opening on opposite side of wall than glass side.
 2. Slide smaller half of frame (B) onto the glass side of frame. Piece (B) will overlap piece (A).
 3. To hold frame together before glazing, use clamps to apply pressure from both sides of the wall. Then use at least one pop rivet per head, sill, and jambs in the overlapping rabbet to hold the frame in opening. Keep track of glass moulding and package of screws.
 4. When ready to mount glass, moulding (C) will secure the glass while the sheet metal screws for the bead will also penetrate the overlap of (A) and (B) thus holding the unit in the opening.
- Mullions are welded to part (A).

OUR PROMISE TO YOU

At Karpen Steel, we pledge to back each sale with a level of customer service that raises the bar throughout the industry. From the moment you contact us, our team will provide quick, attentive and accurate service throughout the quoting and ordering process. We'll do more than simply meet your expectations...we'll exceed them. It's part of our commitment to being *The Custom Quick-Ship Professionals*.

PYRO-VIEW®*: A UL LABELED 2-PIECE SLIP FRAME



FIRE RATING

- "C" Label (45 min.)
- Max. Exposed Glass: 1156 sq. in. 34"x 34"
- Max. Glass Opening: 1296 sq. in. 36"x 36"
- Jamb Width: 4" Min. 14" Max.
- Jamb, Head, and Sill: 2" Face
- Stop Height: 1"
- 16 GA minimum

GLAZING BEAD

- 16 GA, 1"x 1"

* Patent # 5, 711, 120

KD FRAME

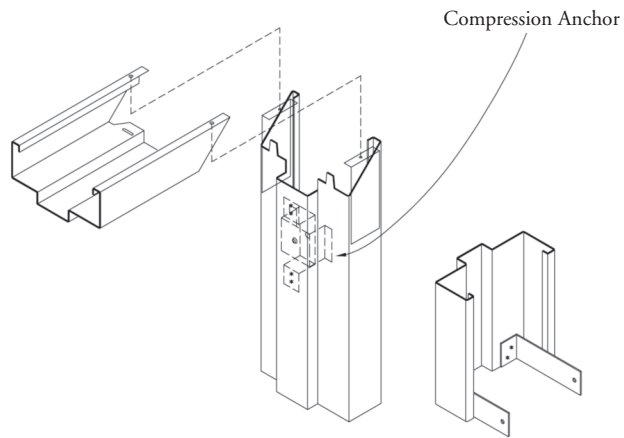
SIZING

Sizing of rough openings for double rabbet KD frames using 2" face material:

- **WIDTH**
Door opening size plus 1 1/2" to 2 1/4"
- **HEIGHT**
Door opening size plus 3/4" to 1 1/2"

We can accommodate other existing rough opening sizes if your conditions are different than noted above.

Knocked down frames are available with or without drywall returns.



Installation instructions available online.

LEAD LINED FRAMES AND DOORS

LEAD THICKNESSES AVAILABLE

1/32"	1/16" (standard)	3/32"
1/8"	5/32"	3/16"

Typically frames, borrowed lights and doors supplied with 1/16" thick lead.

FRAMES

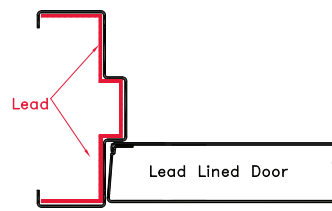
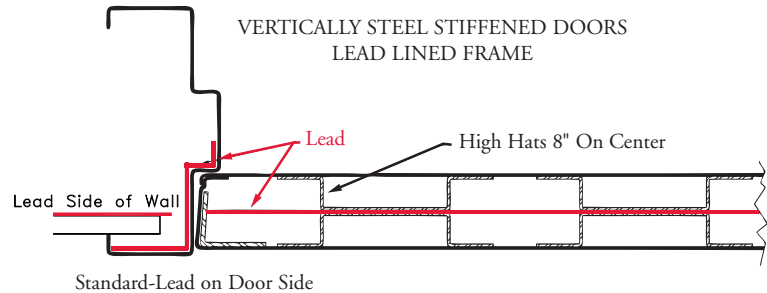
- The lead shall be formed into the profile of the frame on the door side rabbet and stop.
- Fully leadlined frames available.
- UL Label available.

BORROWED LIGHTS

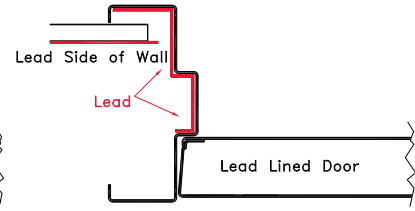
- 4-sided borrowed lights.
- 2-piece slip frames for borrowed lights
- Mullions can be leadlined in borrowed light and sidelight frames.
- Typically leadlined similar to door frame with glazing bead shipping loose.

DOORS

- 20-minute UL Label without hose stream available.
- Lead lined astragal available for pairs of doors.
- Vision lite kits available.



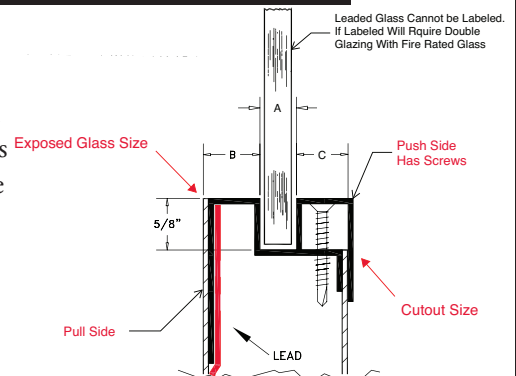
Optional - Fully Lead Lined



Optional - Lead on Opposite Door Side

VISION LITE KITS

- Available for 1/4" and 1/2" leaded glass.
- All vision lites for lead lined doors have screws on the push side of the door.



KARPEN STEEL CUSTOM DOORS & FRAMES

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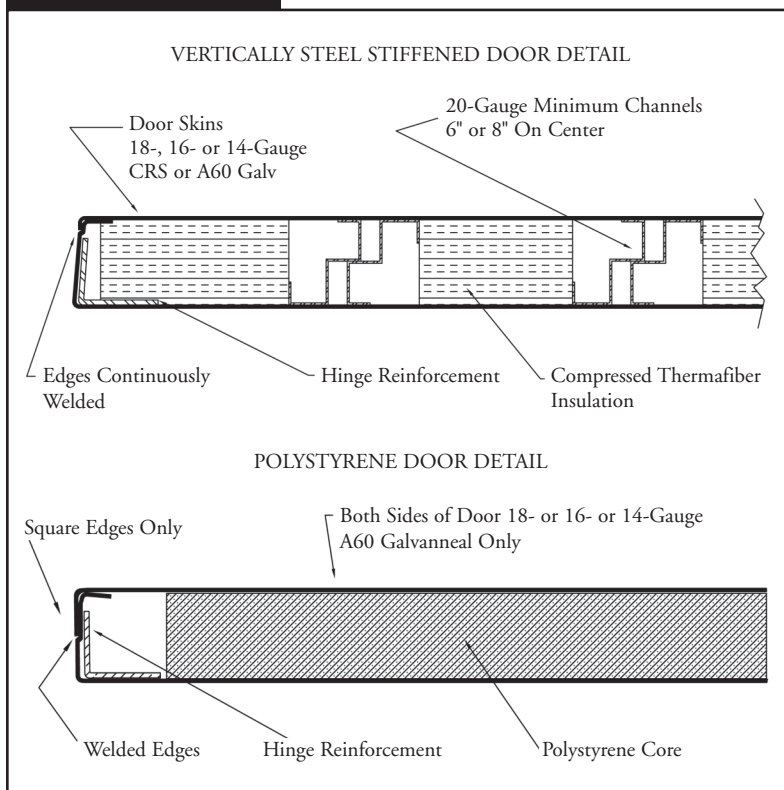
Door SPECIFICATIONS

Karpen Steel fabricates Seamless Edge, Vertically Steel Stiffened and Polystyrene Core Doors.

DOOR MATERIALS

MATERIAL TYPE	GAUGES	MAX SIZE
Cold Rolled Steel (CRS)	14, 16, 18	4' 7" x 10' 0"
Hot Rolled Pickled & Oiled (HRPO)	12	4' 7" x 10' 0"
A60 Galvannealed (A60 GALV)	12, 14, 16, 18	4' 7" x 10' 0"

DOOR CORE



BASE DOOR PRICING

Karpen Steel's base door pricing is designed to allow you to give us the minimum amount of information in order to get your quote. Don't know if the hinges are standard or heavyweight? It doesn't matter. Don't know if you'll be using surface VR or flush bolts? That also doesn't matter.

CORE

- Standard Core:
 - Doors shall have continuous vertical interlocking steel stiffeners of 20-gauge and shall be spaced no further than 8" on center.
 - Doors shall be filled with mineral rock wool.
- Alternate Core:
 - Polystyrene Core with a density of 1 lb/cubic foot for 1 3/4" thick doors.
 - Face Sheets for Polystyrene Core: A60 Galvanneal

THICKNESS

- 1 3/4" and 1 3/8" standard thicknesses.
- Other thicknesses available from 1" up.

REINFORCEMENTS

- Top and bottom of doors shall be reinforced with continuous 16-gauge steel channels, spot welded to both sides of doors.
- Hinge reinforcements shall be 11-gauge steel angle, 12" long.
- Cylindrical lock and 8" mortise lock reinforcements shall be 16-gauge with 11-gauge thread depth.
- Other lock and closer reinforcements shall be 12-gauge.
- Doors shall be reinforced for all surface type hardware. Drilling and tapping of surface hardware to be done in the field by the installer.
- Edges of door shall be continuously seam welded, ground, and filled to ensure a smooth finish.

HINGE BACKSET

(1 3/4" Thick doors)

- 1/4" standard, 3/16" or 1/8" available

FINISH

- Doors shall be thoroughly cleaned after assembly and given a prime coat of rust inhibiting paint. The primer shall be air dried.
- Low gloss oil base trim paints (max. gloss 25) are recommended as a finish paint.

BEVEL

- 1/8" in 2" standard (18-, 16- and 14-gauge steel-stiffened doors). Square edge available.
- Square edge only (polystyrene core).

UNDERCUT

- 3/4" standard. Other undercuts as specified.

ASTRAGALS

- Flat 14-gauge astragals are provided with pairs of doors as needed and are shipped loose for field mounting.



*Note: Positive Pressure Labels apply to all UL doors.
Vision lights available. Doors are 16- or 14-gauge vertically steel stiffened unless otherwise specified in table.

UL LABELS - DOORS		
RATING & LABEL	TYPE	MAX NOMINAL DOOR SIZE
3-Hour ("A")	1 3/4" Doors 2" Doors	4' 0" x 8' 0" (Single) 8' 0" x 8' 0" (Pair)
1 1/2-Hour ("B") 45 Min ("C") 20 Minute	1 3/4" Doors 2" Doors	4' 0" x 10' 0" (Single) 8' 0" x 10' 0" (Pair) 8' 0" x 10' 0" (Pair) VR x VR 8' 0" x 8' 0" Double Egress Pairs, VR x VR
3-Hour ("A") 1 1/2-Hour ("B") 45 Min ("C") 20 Minute	1 3/4" Door 18-Gauge	3' 8" x 7' 0" (Single) 7' 4" x 7' 0" (Pair)
3-Hour ("A")	Double Egress Pair	8' 0" x 8' 0" Karpen Steel must also supply the frame
3-Hour ("A") 1 1/2-Hour ("B") 45 Min ("C")	Dutch Door - Single	4' 0" x 7' 2"
1 1/2-Hour ("B") 45 Min ("C")	1 3/8" Thick Door Available in 18-Gauge	3' 0" x 7' 0"
20 Minute (without hose stream)	Lead Lined Door	4' 0" x 8' 0" (Single) 8' 0" x 8' 0" (Pair)
1 1/2-Hour ("B")	STC 47 Acoustical Assembly. 14 Gauge Door and Frame. Sold as unit with sound seals, threshold, and 3 cam lift hinges.	3' 0" x 7' 0"
250 Degree 1 1/2-Hour ("B")	Temperature rise, typical in stairwells. Core: mineral coreboard	4' 0" x 8' 0" (Single) 8' 0" x 8' 0" (Pair)

12-GAUGE DOOR

MATERIAL

- 12-Gauge face sheets of HRPO or A60 Galvanized Steel

THICKNESS

- Actual door thickness: 1 7/8"
- Other door thicknesses available, such as 1 3/4" and 2"

CORE

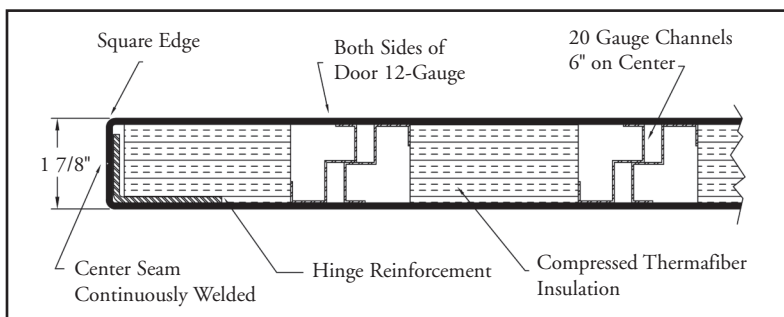
- Doors shall have continuous vertical interlocking steel stiffeners of 20-gauge and shall be spaced no further than 8" on center.
- Doors shall be filled with mineral rock wool.

REINFORCEMENTS

- Reinforcements for security and specialty hardware available.

EDGE CONSTRUCTION

- Square both sides.
- Continuously seam welded.



PANELS

Panels are available for installation in sidelite and transom frames as well as for installation in door vision light kits. The styles that are available are:

- 1 3/4" or 1 3/8" thick steel stiffened
- 1 3/4" thick with polystyrene core
- 1" thick with polystyrene core sandwich panel
- 1/4" thick sandwich panel with masonite core
- Single flat pieces of 12 gage steel

VISION LIGHTS



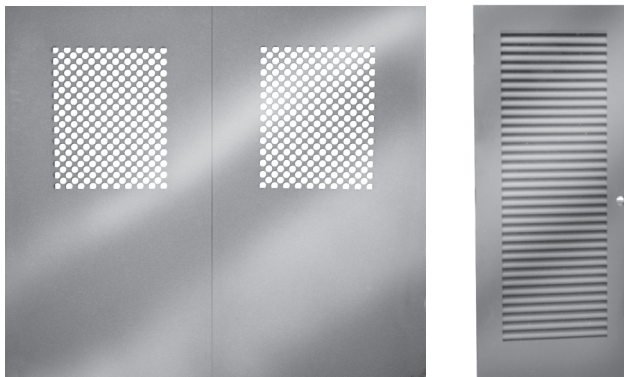
CUSTOM VISION LIGHT OPTIONS

- Thick Glass Kits
- Muntin Bars
- Custom Sizes
- Flush Kits
- Creative Designs

Karpen Steel's standard is Low Profile Vision Light Kits and Louvers.

See our website for various Vision Light and Louver Kit options and visit the door photo gallery.

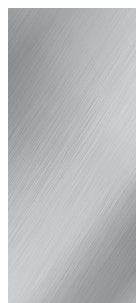
LOUVERS



SPECIALTY LOUVERS

- An integral fixed blade louver is available for custom sizes in 2" height increments.
- Louvers available in CRS or Galvanized in 16-, 14- or 12-gauge.
- Fusible Link Louvers for 1 1/2 hr. labeled doors are available up to 24" x 24"

TYPICAL DOOR DESIGNS



Flush



Square Vision Light



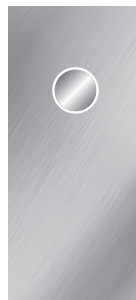
Narrow Vision Light



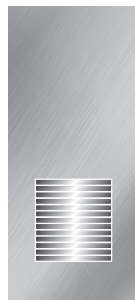
Half Glass



Full Glass



Round Vision Light



Bottom Louver



Full Louver



Half Glass w/ Bottom Louver



Half Glass w/ Muntin Bars

STC RATINGS

- Operable door tests in accordance with ASTM E90 Copies of test results are available.
- STC 47: Single: Flush
- STC 47: Single Flush
 - UL Label 1 1/2 hour
 - 3' 0" x 7' 0" Max.
- STC 41: Single: Vision Light
 - 3" x 33" exposed glass or
 - 10" diameter round
- STC 38: Pair: Flush
 - Provided with double astragals

FRAME

- 14 Gauge cased open

DOOR

- 14 Gauge
- Vertically steel stiffened, seamless edge

STANDARD FINISH

- Clear Anodized Aluminum Hardware
- All Doors and Frames are Primer Finished
- All Cam Lift Hinges are Stainless Steel

SOUND CONTROL

Acoustic DOOR AND FRAME ASSEMBLIES

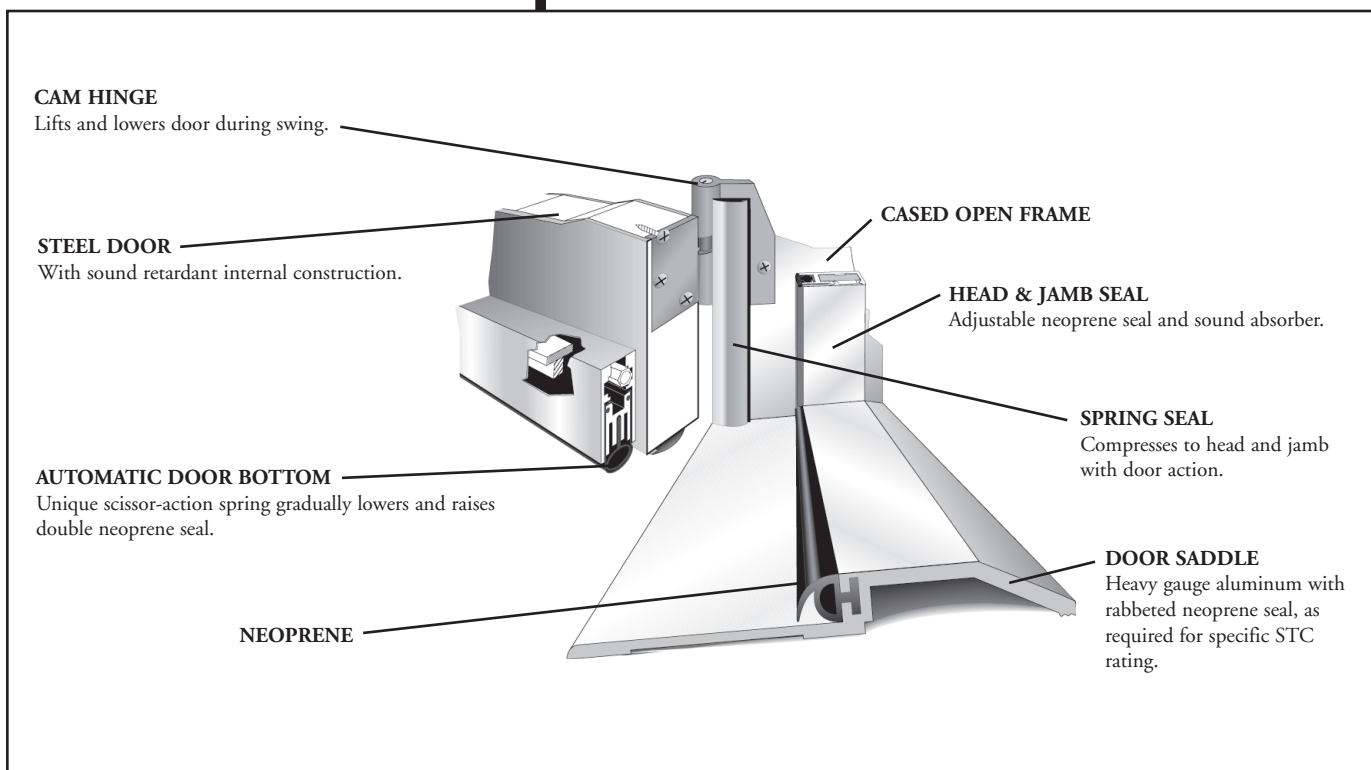
SOUND TRANSMISSION CLASS (STC) TABLE

STC VALUE	RATING	DESCRIPTION
50-60	Excellent	Loud sounds heard faintly or not at all.
40-50	Very good	Loud speech heard faintly but not understood.
35-40	Good	Loud speech heard but hardly intelligible.
30-35	Fair	Loud speech understood fairly well.
25-30	Poor	Loud speech audible.
20-25	Very poor	Normal speech understood easily and distinctly.

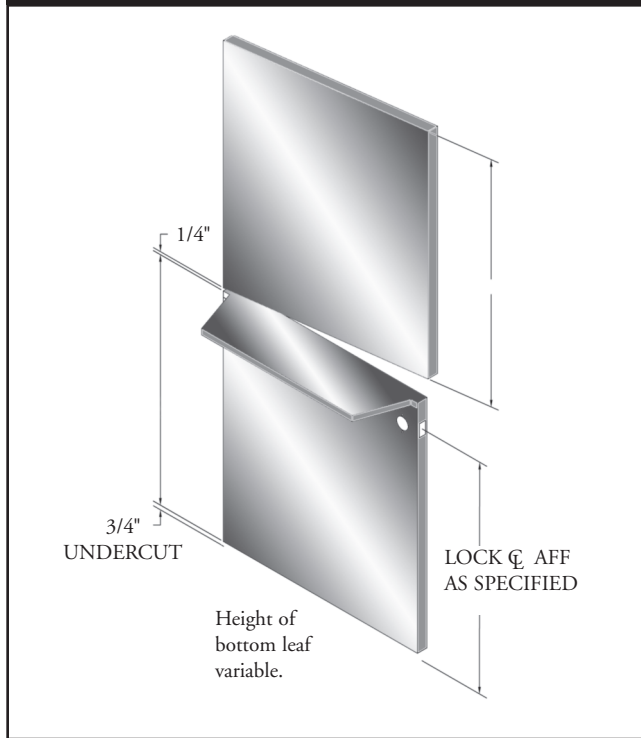
Sold as unit only.

Price includes frame, door, crate, and hardware.

Zero International sound seals and hinges are supplied. The distributor only needs to supply the lock and closer.

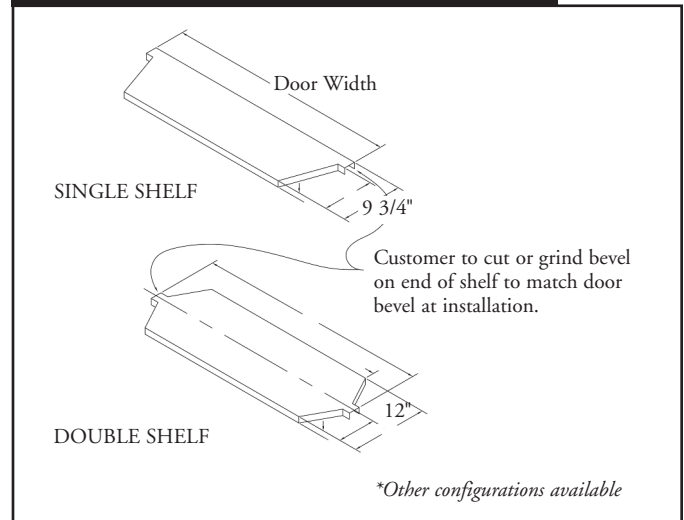


DUTCH DOORS



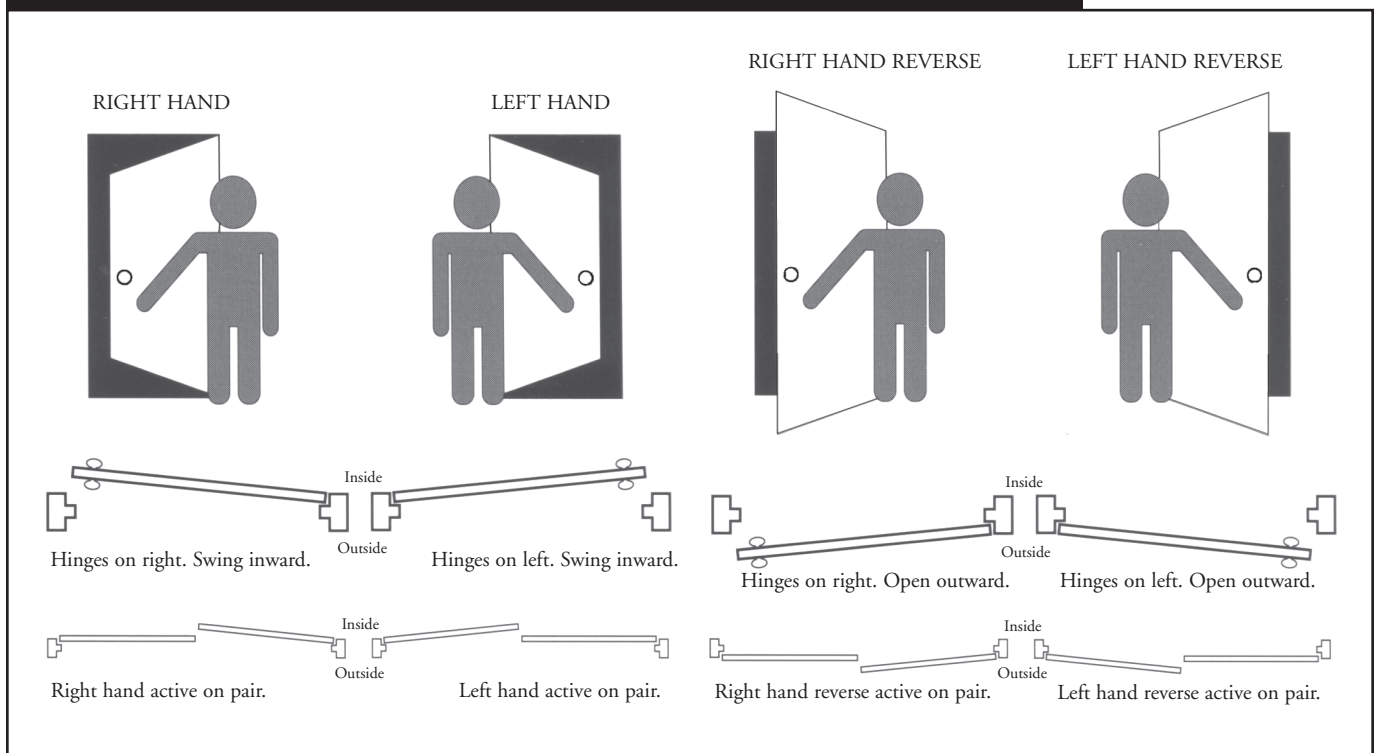
- Typically used in supply rooms
- Can be made in same gauge, size or thickness as our other doors.
- Criteria for UL Labeling:
 - 4' 0" x 7' 2" Single Door Opening
 - 1 3/4" thick door
 - Top and bottom leafs must latch into strike jamb of frame.
 - Astragal provided between leafs
 - Single shelf optional

DUTCH DOOR SHELF OPTIONS



DOOR HANDING CHART

Door hand is always determined from the outside, on key side, facing the door.



MISCELLANEOUS METAL PRODUCTS

JUNCTION BOXES:

Junction boxes are used on frames to terminate conduit at the electrified hardware preps. They are often used with Electric Power Transfer (EPT), hinges, strikes, and Door Position Switches.

The junction boxes manufactured by Karpen Steel are typically 12" long, which makes them easier to use, and they are made with a removable back. Karpen Steel can provide the boxes either as part of a frame order, or in bulk for use by a distributor.

Z ASTRAGALS

This astragal typically attaches to the inactive door overlapping the inactive on the pull side and the active on the push side. The tabs for mounting hardware (such as flush bolts and strikes) are located on the Z Astragal itself.

The astragals are 14 Gage A60 Galvanneal steel and can be made for beveled or square edge doors.

DOOR EDGE GUARDS

Door edge guards can be made either as just a channel to fit over an existing door or with a flat astragal attached. The tabs for mounting hardware are located on the door edge guard as required.

The door edge guards are 14 Gage A60 Galvanneal steel and can be made for beveled or square edge doors.

REMOVABLE STOP AND GLAZING BEAD MOULDING

Removable stops can be manufactured in order to convert a cased open frame to a frame for a door. Typically they are 5/8" high by width as required.

Special sizes of glazing bead are available either as part of a borrowed light or sidelight frame order, or by themselves.



Karpen Steel
Custom Doors & Frames
The Custom Quick Ship Professionals

PACKAGING AND SHIPPING

SHIPPING TERMS

- We typically ship freight prepaid. We select the LTL or truckload carrier that offers the best service to your area of the country.

CRATING

- Karpen Steel doors are individually crated to ensure protection during shipment. Larger shipments are palletized.
- Set-up and welded frames are crated individually or multiple units per crate depending on size. Large orders of KD frames are palletized.

AIR FREIGHT

- Need rapid delivery? Call for air freight estimates.

PACKAGE SERVICE

- Single KD frames can be shipped with a package service with some size restrictions.
- Small borrowed light frames and panels are also available to ship with a package service.
- Maximum weight for material and packaging is 90 lbs. Frames are shipped in heavy-weight corrugated boxes.

STORAGE OF MATERIALS

- Doors and frames shall be received by the contractor at the job site and handled in a manner so as not to be damaged.
- Store all materials in a dry area, under a vented tarpaulin or plastic cover.
- Do not stack material flat; store doors and frames in an upright position, preferably with heads uppermost.
- Do not permit cardboard or paper containers or wrapping to become wet. If this should occur, remove them immediately.

WARRANTY

Karpen Steel Custom Doors & Frames warrants its material for a one-year period from the date of delivery to the original direct purchaser. Karpen Steel warrants to the distributor of its doors and frames that it will at its option, either repair, replace or otherwise correct any product acknowledged by the manufacturer to be defective in materials or workmanship.

All of Karpen Steel's products are sold without any other further warranties, expressed or implied. Fitness of material for a particular purpose is hereby disclaimed.

The warranty is considered to be null and void if the products are subject to abuse, accident, misapplication, or incorrect installation.



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