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Procedure for Repair of FM Approvals Approved Rolling Steel Type Fire Doors

A. General

1. All repairs to fire doors must be made with components from the original door manufacturer of the fire door. If that company is no longer in existence, it is recommended that the complete fire door be replaced.
2. Modifications of any fire door are not subject solely to the authority of FM Approvals. Such modifications should be arranged with the door manufacturer, and with the authority having jurisdiction, i.e. the organization, office, or individual responsible for approving equipment, an installation or a procedure (refer to NFPA 80.)
3. All fire doors that are repaired shall be drop tested to ensure the repairs have been completed properly. The building owner should retain a record of the drop testing results, including the names of witnesses. Refer to Installation Manual or Drop Test Procedures provided by the door manufacturer.
4. When slat repair of a fire door curtain is required, all slats shall be from the original door manufacturer and be the same shape and gauge. **DO NOT REPLACE** damaged slats using slats from another supplier.
5. When a guide repair is required, the guide angles shall be replaced. The new angles must exactly duplicate the original angles. If this cannot be done, the complete guide must be replaced. Expansion clearances are critical on fire doors and slot/hole match may not occur if only one or two angles are replaced. Attach new guide assembly to jambs with jamb fasteners located in the slots as shown on the manufacturer's instructions because the old jamb fastener locations may not allow for proper expansion of the guides during a fire.
6. If counterbalance spring tension is released while the door is in the closed position, the door shall be inspected for damaged parts by a trained door systems technician. Any damaged parts shall be restored to original condition. **DO NOT** modify the installation in any way to compensate for damaged parts.
7. FM Approvals can be contracted for field site approval of repairs if required by local authorities. Request for Field Inspection by FM Approvals should be set up through original door manufacturer.
8. Replacement bottom bars will be made in accordance with the manufacturer's approved procedure. The replacement bottom bar along with instructions for installation and drop testing will be sent to a local door company. A trained door systems technician should accomplish repair and testing. Coordination with the local authority having jurisdiction is recommended.

Note: Technical Data Sheets are information tools only and should not be used as substitutes for instructions from individual manufacturers. Always consult with individual manufacturers for specific recommendations for their products and check the applicable local regulations.

This Technical Data Sheet was prepared by the members of DASMA's Rolling Door Division Technical Committee. DASMA is a trade association comprising manufacturers of rolling doors, fire doors, grilles, counter shutters, sheet doors, and related products; upward-acting residential and commercial garage doors; operating devices for garage doors and gates, sensing devices, and electronic remote controls for garage doors and gate operators; as well as companies that manufacture or supply either raw materials or significant components used in the manufacture and installation of the Active Members' products.

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B. Rolling Steel Fire Door Bottom Bar Replacement Procedure

A replacement bottom bar must be ordered from the original fire door manufacturer. The label denoting FM Approval on the damaged bottom bar should be returned to the original manufacturer along with the manufacturer's serial number. If the original bottom bar did not contain a label denoting FM Approval, the door is ineligible for the Bottom Bar Replacement Procedure.

1. When the label denoting FM Approval is returned to the door manufacturer:

- The door manufacturer will make a replacement bottom bar and attach a new label denoting FM Approval.
- The door manufacturer will ship the bottom bar, along with instructions for installation and drop testing, to a qualified local door company to complete the repair.

2. When the original bottom bar included a label denoting FM Approval, and the label from the damaged bottom bar is either not available or not returned to the original door manufacturer:

- The door manufacturer must receive confirmation that the label denoting FM Approval was destroyed.
- The door manufacturer will make a replacement bottom bar with a new label denoting FM Approval applied to the bottom bar.
- The door manufacturer will ship the bottom bar, along with instructions for installation and drop testing, to a qualified local door company to complete the repair.

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