



September 14, 2026

RE: Allegion Hollow Metal Swinging Fire Doors and Fire Door Frames
Field repair of unused holes and / or dents

This is to confirm that the fire rated hollow metal products supplied by Allegion hollow metal brands are manufactured to meet and / or exceed the standards and specifications set forth per the following:

- UL 10B – Standard for Fire Tests of Door Assemblies
- UL 10C – Standard for Positive Pressure Fire Tests of Door Assemblies
- UL 1784 – Standard for Air Leakage Tests of Door Assemblies and Other Opening Protectives
- UL 9 – Standard for Fire Tests of Window Assemblies
- NFPA 80 – National Fire Protection Agency - Standards for Fire Doors and Windows
- NFPA 252 – National Fire Protection Agency - Standard Methods of Fire Test of Door Assemblies
- ANSI A250.8 (SDI 100) – American National Standards Institute - Recommended Specifications
- ANSI A250.4 – American National Standards Institute - Test Procedure & Acceptance Criteria of Physical Endurance for Steel Doors & Hardware Reinforcings

Regarding filling of unused or open holes and dents in fire rated hollow metal products, NFPA 80 addresses direction for repair.
NFPA 80 (2025), Chapter 5, Section 5.5.7

When fastener holes are left in a door or frame due to changes or removal of hardware or plant-ons, the holes shall be repaired by the following methods:

- (1) Install steel fasteners that completely fill the holes.
- (2) Fill the screw or bolt holes with the same material as the door or frame.
- (3) Fill holes with material listed for this use and installed in accordance with the manufacturer's procedures.

Acceptable procedure(s) for repair of Allegion hollow metal may include usage of screw or bolt (as indicated per NFPA 80) or weld. Clean up and for aesthetic purposes, usage of filler / bondo products are allowed and addressed through HMMA 840 TN02-10, "... For fire rated openings, pending acceptance of the local authority having jurisdiction, dents in the door faces measuring no greater than 1/8 in, in depth and less than 14 inches in length can be filled with industrial automotive body filler provided that no fracturing of the door face or corrosion is present."

Supported by the above references, Allegion fire rated doors and frames may be repaired by one of, or a combination of methods shown above. Final approval / acceptance is mandated by the local authority having jurisdiction.

Thank you,

Marilyn Latham

Sr. Engineer

Codes and Standards

ALLEGION HOLLOW METAL – Steelcraft, Republic, Krieger, Next Door, DCI