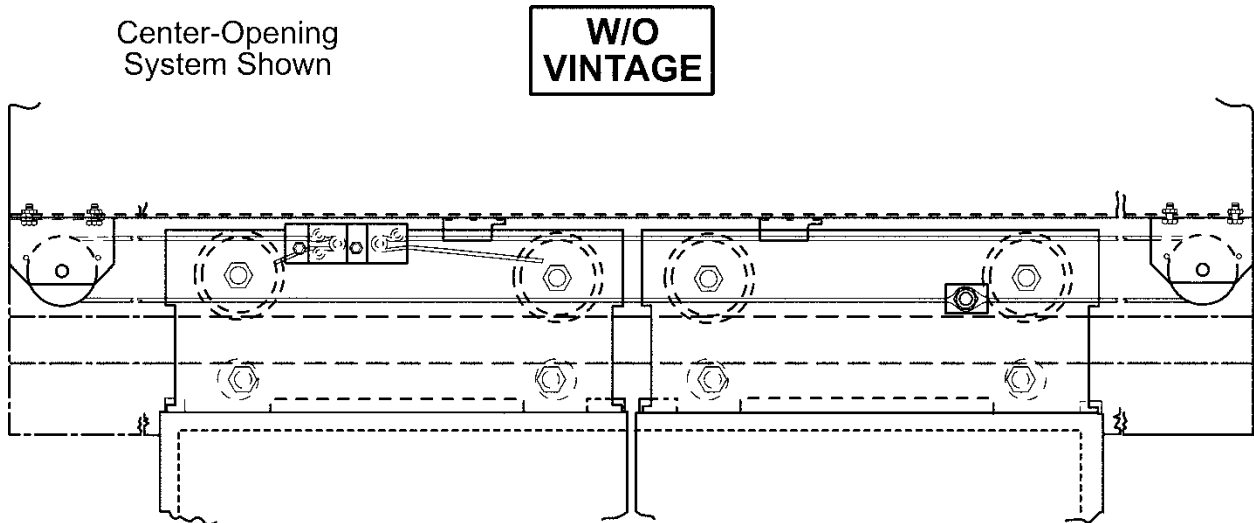


Integral Hanger
Hoistway Door Systems:
Center-Opening, Single-
Slide, Two-Speed

Spare Parts Leaflet
25-6178R

November 27, 2019 / Page 1 of 19



OTIS

This document does not contain any
technical data subject to EAR or ITAR

SERVICE ENGINEERING
Otis Elevator Company
Bloomfield, Connecticut USA

Unpublished Work—© Otis Elevator Co.; 2019

Leaflet Description

This SPL is a consolidation of integral hanger hoistway door and entrance systems, which were not covered in detail since the end of the production vintage of 1962 (corresponding with the September 1962 release of SPL C-1019A). SPLs C-1019A and C-3042 covered many major parts, but much information (especially on entrance parts) was omitted.

This SPL now covers production vintages approximately between 1957 and the mid-1990s.

This SPL also covers parts typically called out on entrance assembly drawings (types 6920AS, AT, AW and 6920EG, EH, EJ). The latter set of three still appeared on Bloomington O-forms as late as 1990.

Many of the part descriptions within the SPL include their approximate (~) vintage period of manufacture where it aids identification. It is suggested that you consult your Building Record Card to determine the elevator's date of manufacture vintage and the elevator's Summary of Contract Data (2020 Forms) for part verification.

The most significant production changes during this 43-year span of production are as follows:

- 1) Change from 2-1/4 in. diameter steel rollers to 3-1/4 in. diameter aluminum die-cast rollers in approximately 1962.
- 2) Change in entrance drawings used. The first set (types 6920AS, AT, AW) used between 1957 & 1975. The second set (types 6920EG, EH, EJ) used between 1976 & ~1990. It is thought (but not confirmed) that this change somewhat coincided with production end of entrances in Harrison, NJ and production start in Bloomington (other design changes may have also contributed to the major change in entrance drawings).

As reference only, the next vintage entrance drawings used post 1990 on hydraulic, geared and gearless models are found under drawing series: AAA23100AA(A–F), AAA23100(G–J), and AAA23100(P–S).



any entrance SPLs with those base numbers for post 1990 equipment.

Leaflet Revisions

Date Revised	Subject Matter Expert	Reason for Revision
September 1, 2001	Duane Stupienski	New leaflet, initial release (to supersede SPLs C-3042 dated September 1994 [in part], and C-1019A dated September 1962)
July 28, 2005	Jeff Smith	Page 2: updated production dates; Page 15: updated Entrance Width criteria.
June 3, 2008	Troy Chicoine	Added parts 283DP1, 316CVF1, and 316CVF2 on pages 18 and 19.
February 18, 2015	Brian Regan	Corrected ref. 3 on p. 13
November 27, 2019	Peter Kelley	Revised history page

(Continued on next page)

History (Continued)

25-6178R

Related Drawings

Drawing No.	Title	Drawing No.	Title
6178R (all versions)	Integral Hanger Arrangement, 1-1/4 Thick Two-Speed Hoistway Doors.	6920EH (all versions)	Arrangement, Passenger Entrance, Two-Speed
6178T (all versions)	Integral Hanger Arrangement, 1-1/4 Thick Center-Opening Hoistway Doors.	6920EJ (all versions)	Arrangement, Passenger Entrance, Center-Opening
6178Y (all versions)	Integral Hanger Arrangement, 1-1/4 Thick Single-Slide Hoistway Doors.	6920AS (all versions)	Arrangement, Passenger Entrance, Two-Speed
6920EG (all versions)	Arrangement, Passenger Entrance, Two-Speed	6920AT (all versions)	Arrangement, Passenger Entrance, Center-Opening
6920AW (all versions)	Arrangement, Passenger Entrance, Single-Slide	---	---

Related Documents

Document ID	Title
SPL 19-6178CH	Applied Hanger Car Door Systems
SPL 19-AAA6178CS	Integral Hanger Car Door Systems (Post 2000)
SPL 19-AAA6178CT	Applied Hanger Car Door Systems (Post 2000)
SPL 25-AAA24479AAA	Door Guides
TIP 21.2-4	Replacements for 456CX4 Door Hanger Roller
TIP 23.3-3	Door Hanger Rollers—Roller Profile Squeaking Roller Problem
TIP 21.2-5	Welded Aircord Sheave Bracket Replacement
O-1110-08	Specifying Order Form
O-1110-09	Specifying Order Form

Subject Matter Expert

Name	Department
Peter Kelley	OSC Service Engineering

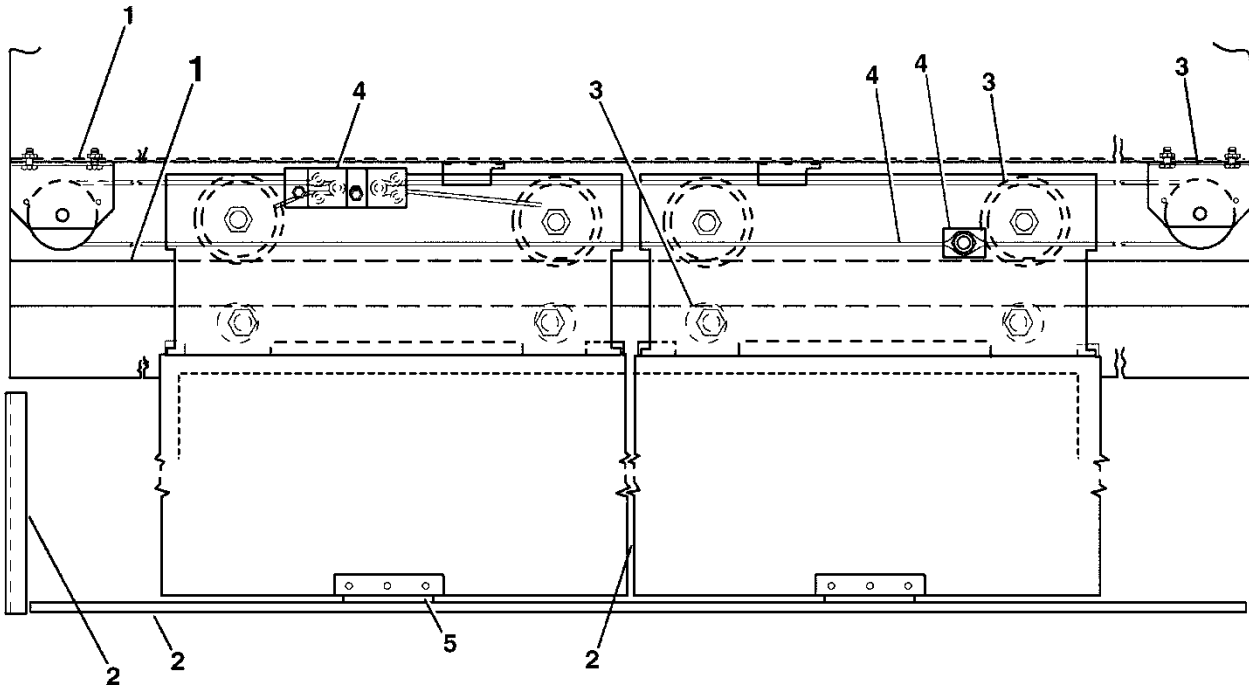
About Spare Parts Leaflets...


This document lists the lowest replaceable units (LRUs) for the standard version of the product. The LRUs are chosen by a team of Otis associates representing engineering and manufacturing.

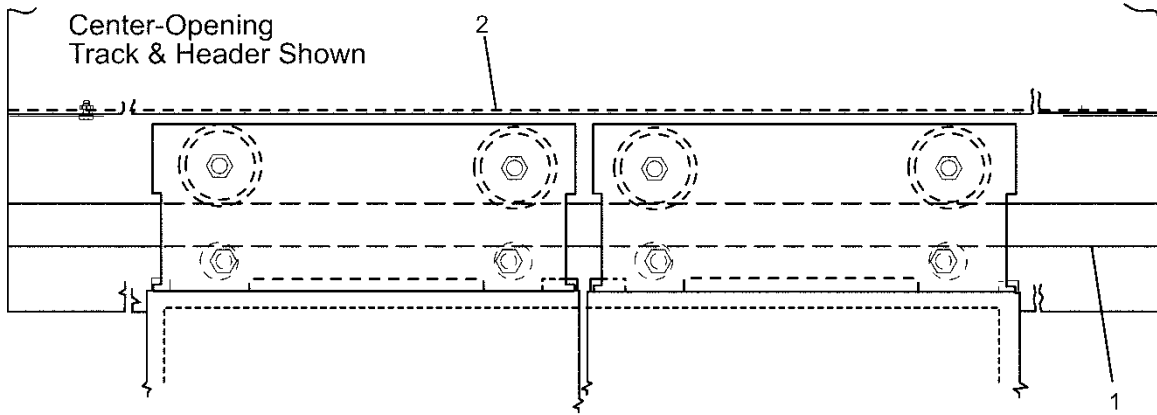
While goal of this document is to make parts identification as easy as possible, the document cannot be all-inclusive. Elevator and escalator contracts classified as “special” or “custom” are not addressed here. For such contracts, please refer to specified information, the contract folder, TIPs, Field Education Articles, Construction Letters, etc. for further information.




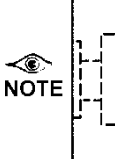


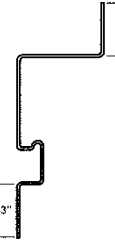

If you have any suggestions about this document, please contact the subject matter expert listed on this page.

Center-Opening System Shown

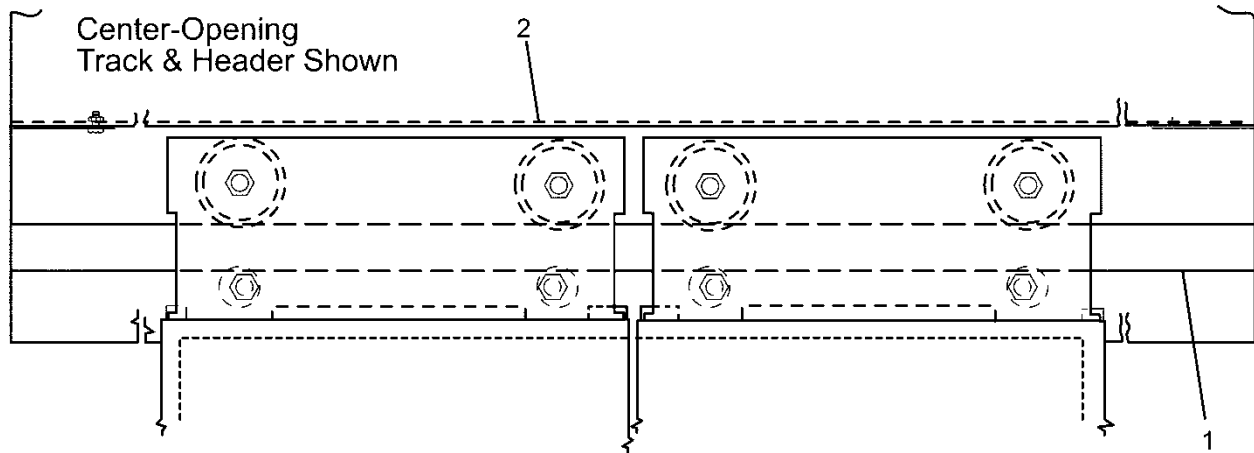


REF. No.	PAGE No.	DESCRIPTION
1	pp. 5-8	Headers and Tracks
2	pp. 9-12	Entrance Frame Parts: Bumpers, Astragals, and Sills
3	pp. 13 and 14	Integral Door Hanger Parts
4	pp. 15 and 16	Aircord Drive, Two-Speed Door Systems
	pp. 17-19	Related Cable Assembly, Center-Opening Door System
5	---	 SPL 25-AAA24479AAA for Bottom Door Guides



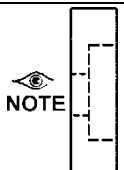


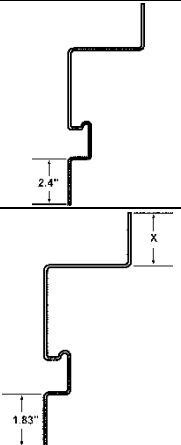



W/O VINTAGE					
REF. No.	PART No.	DESCRIPTION	VINTAGE (approx.)	HEADER TYPE (ref.)	CROSS-SECTION VIEW (TRACK)
1	50ADF1-162	Track, Solid, 13 ft. 6 in. L x 2.0 in. H x 0.5 in. W (shape only), ( & Drill as Needed)	~1957-65	409AT A409AT	
	483LC3	Track, Finished, 89.5 in. L	~1957-62	409AT	
	483LC6	Track, Finished, 77.0 in. L			
	483LC10	Track, Finished, 89.0 in. L			
	483MJ8	Track, Finished, 77.0 in. L	~1963-65	409BR	
	483MJ9	Track, Finished, 80.0 in. L			
	483MJ10	Track, Finished, 86.0 in. L			
	483MJ11	Track, Finished, 92.0 in. L			
	483MJ12	Track, Finished, 96.0 in. L			
	2	50AEV-106	Header Shape w/Formed Track, L = 106.0 in., ( & Drill as Needed)	~1965-71	409BV
~1972-75				409CK	
~1976-78				409BS	
1S-A50AEV-106		Header Shape w/Formed Track, L = 106.0 in., ( & Drill as Needed), X = 3.88 in.	~1979-87	A,B,& C409CK	
1S-B50AEV-106	Header Shape w/Formed Track, L = 106.0 in., ( & drill as Needed), X = 2.25 in.	~1988-94			

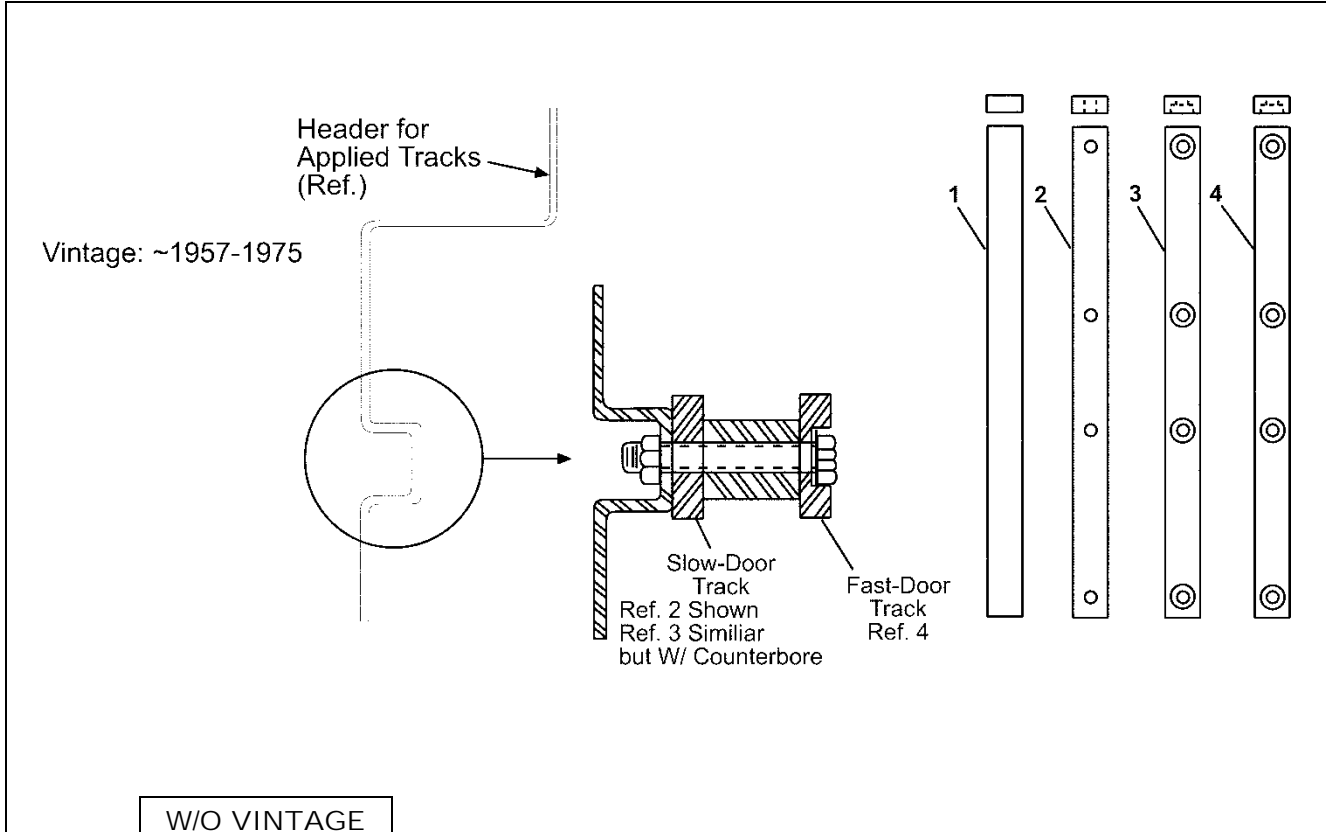
NOTE: Hole spacing + counterboring is best done by machine shop. Track lengths are not the only defining feature for proper replacement part. Number of holes and hole spacing is critical. Contact OSC with contract information for assistance.




W/O VINTAGE

REF. No.	PART No.	DESCRIPTION	VINTAGE (approx.)	HEADER TYPE (ref.)	CROSS-SECTION VIEW (TRACK)
1	50ADF1-162	Track, Solid, 13 ft. 6 in. L x 2.0 in. H (shape only), ( & Drill as Needed)	~1959-65	409BA 409BN A409BN	
	483LC9	Track, Finished, 89.5 in. L	~1959-62	409BA	
	483MJ4	Track, Finished, 80.0 in. L	~1963-65	409BN A409BN	
2	50AEV-106	Header Shape w/Formed Track, L=106.0 in., ( & Drill as Needed)	1965-76	409BS	
	1S-A50AEV-106	Header Shape w/Formed Track, L = 106.0 in., ( & Drill as Needed), X = 3.88 in.	1976-84	A409BS	
	1S-B50AEV-106	X = 2.25 in.	1985-86	A409BS C409BS	
			1986-88	D409BS	
		1988-90			

NOTE: Hole spacing + counterboring is best done by machine shop. Track lengths are not the only defining feature for proper replacement part. Number of holes and hole spacing is critical. Contact OSC with contract information for assistance.

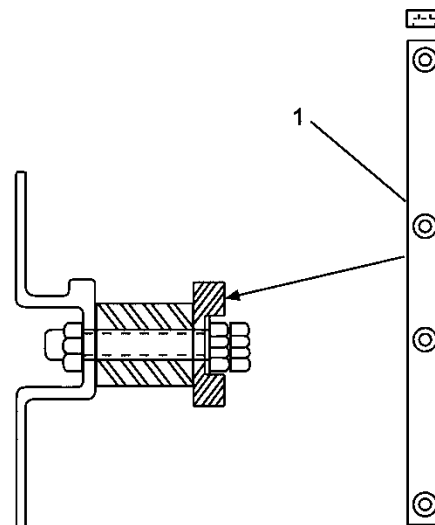
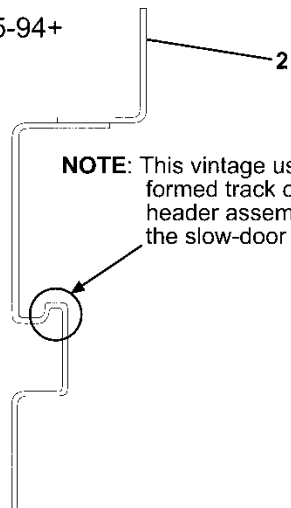


REF. No.	W/O VINTAGE		VINTAGE (approx.)	HEADER TYPE (ref.)
	PART No.	DESCRIPTION		
1	50ADF1-162	Track, Solid, 13 ft. 6 in. L x 2.0 in. H (shape only), ( & Drill as Needed)	1957-75	409AV
2	483LC1	Track, Finished, 71.75 in. L (slow-door)	~1957-62	
	483LC4	Track, Finished, 80.25 in. L (slow-door)		
	483LC7	Track, Finished, 62.75 in. L (slow-door)		
3	483MJ16	Track, Finished, 60.5 in. L (slow-door)	~1963-75	(A)409BP 409CJ
	483MJ17	Track, Finished, 65.0 in. L (slow-door)		
	483MJ18	Track, Finished, 69.5 in. L (slow-door)		
	483MJ19	Track, Finished, 74.0 in. L (slow-door)		
	483MJ20	Track, Finished, 78.5 in. L (slow-door)		
4	483LC2	Track, Finished, 71.75 in. L (fast-door)	~1957-62	409AV
	483LC5	Track, Finished, 80.75 in. L (fast-door)		
	483LC8	Track, Finished, 62.75 in. L (fast-door)		
	483MJ24	Track, Finished, 60.5 in. L (fast-door)	~1963-75	(A)409BP 409CJ
	483MJ25	Track, Finished, 65.0 in. L (fast-door)		
	483MJ26	Track, Finished, 69.5 in. L (fast-door)		
	483MJ27	Track, Finished, 74.0 in. L (fast-door)		
	483MJ28	Track, Finished, 78.5 in. L (fast-door)		

NOTE: Hole spacing + counterboring is best done by machine shop. Track lengths are not the only defining feature for proper replacement part. Number of holes and hole spacing is critical. Contact OSC with contract information for assistance.

(Continued on next page)

Vintage: ~1975-94+

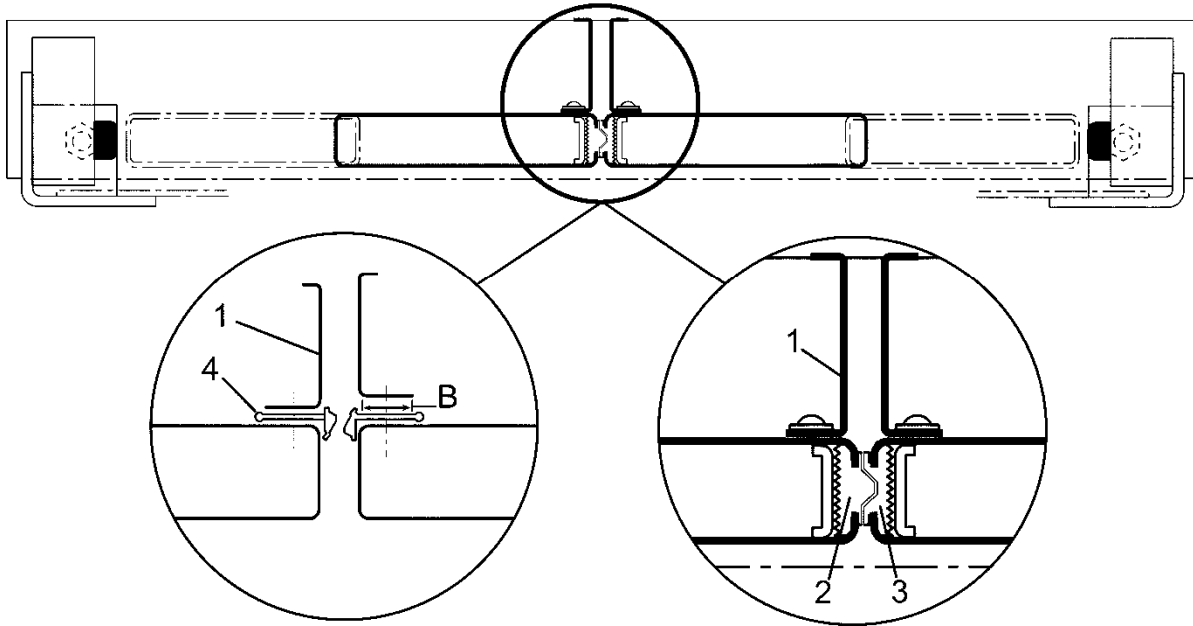


W/O VINTAGE

REF. No.	PART No.	DESCRIPTION	VINTAGE (approx.)	HEADER TYPE (ref.)	CROSS-SECTION VIEW (TRACK)
1	483MJ24	Track, Finished, 60.5 in. (fast-door)	~1976-94+	409DE B409DE C409DE	
	483MJ25	Track, Finished, 65.0 in. (fast-door)			
	483MJ26	Track, Finished, 69.5 in. (fast-door)			
	483MJ27	Track, Finished, 74.0 in. (fast-door)			
	483MJ28	Track, Finished, 78.5 in. (fast-door)			
2	50AEV1-106	Header Shape w/Formed Track, L = 106.0 in., (& Drill as Needed), A = 2.37 in., H = 5.5 in., X = 3.89 in.	~1976-84	409DE	
	2S-A50AEV-106	Header Shape w/Formed Track, L = 106.0 in., (& Drill as Needed), A = 1.83 in., H = 5.5 in., X = 3.88 in.	~1985-94+	B409DE C409DE	
	2S-B50AEV-106	Header Shape w/Formed Track, L = 106.0 in., (& Drill as Needed), A = 1.83 in., H=5.5 in., X = 2.25 in.	~1985-94+	B409DE C409DE	

NOTE: Hole spacing + counterboring is best done by machine shop. Track lengths are not the only defining feature for proper replacement part. Number of holes and hole spacing is critical. Contact OSC with contract information for assistance.

Type 402EG & 402EH
Astragals Shown in Plan View



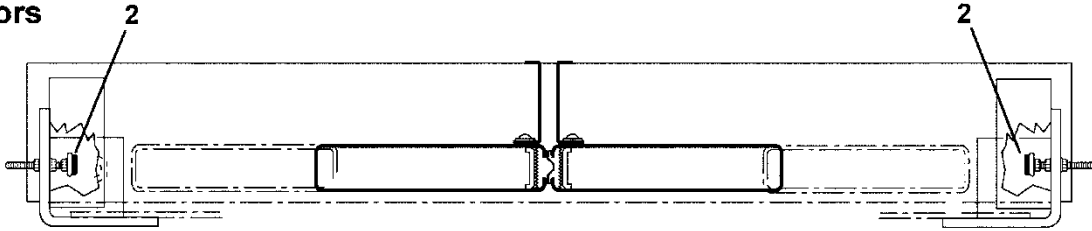
W/O VINTAGE		
REF. No.	PART No.	DESCRIPTION
1	384JM1 <COLOR>	Guard, Sight, Steel, 83.5 in. L, B = 0.88 in. (NOTE 1)
	384JM8	Guard, Sight, Steel, w/Primer Finish, 83.5 in. L, B = 1.18 in.
	384JM2 <FINISH>	Guard, Sight, 83.5 in. L, B = 0.88 in. (NOTE 1)
	---	Guard, Sight, Type 384JM9, 83.5 in. L, B = 1.18 in. (NOTE 3)
	384JM10	Guard, Sight, Steel w/Primer Finish, 95.5 in. L, B = 1.18 in.
	---	Guard, Sight, Type 384JM11, 95.5 in. L, B = 1.18 in. (NOTE 3)
	---	Assembly, Type 384PK Sight Guard w/Glued Astragal (NOTE 2)
2	402EG1	Astragal, Male, L = 90 in. L, Vintage: ~1959-70
3	402EH1	Astragal, Female, L = 90 in. L, Vintage: ~1959-70
4	402FA1 AAA402ZW1	Astragal, 181.5 in. L, Vintage: ~1970-present
	402FA3 AAA402ZW2	Astragal, 101.5 in. L, Vintage ~ 1970-present
	50AGK1	Astragal, Shape by Foot-Length, Vintage: >1970

NOTE: 1) All guards have six mount slots (0.25 x 0.38). Superseded parts use 20.0 inch on-center spacing between slots. Drill new door mounting-holes or use self-drilling screws as needed. Should special circumstances require exact original hole match, contact OSC for special order.

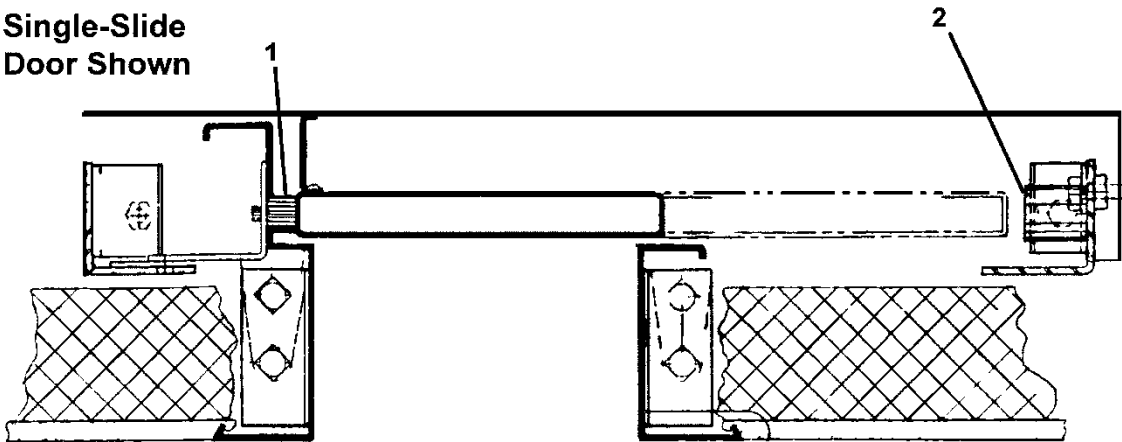
2) Replace the assembly as component parts using type 384JM sight guard and AAA402ZW astragal and fit as needed.

3) Specify the complete p/n as: 384JM(9 or 11) -SS4 (Stainless Steel Satin) or -SS8 (Stainless Steel Mirror) or -BR7 (Brass Satin) or -BR8 (Brass Mirror) finishes.

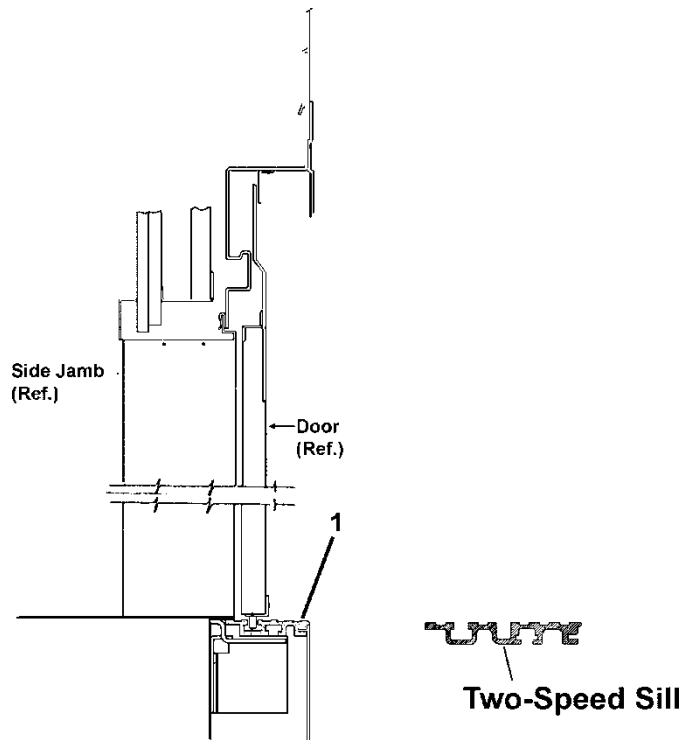
Center-Opening Doors



Single-Slide Door Shown



REF. No.	PART No.	DESCRIPTION	VINTAGE
		W/O VINTAGE	
1	320CC2	Bumper, Strike, 1.0 in. \varnothing , 0.75 in. Square Face x 0.75 in. W, W Single-Slide & Two-Speed Doors	1966–70
	320AP2	Bumper, Strike, 1.0 in. \varnothing , 1.375 in. L, W Single-Slide & Two-Speed Doors	1959–66
	320AP3	Bumper, Strike, 1.0 in. \varnothing , 0.9375 in. L, W Single-Slide & Two-Speed Doors	1970–
2	320AP1	Bumper, Return, 1.0 in. \varnothing , 1.125 in. L, W All Door Systems	1959–62
	320BS1	Bumper, Return, 1.5 in. \varnothing , 1.4375 in. L, W All Door Systems	1962–75
	477EE1	Bumper, Return, W/Round-Head Screw, 1.5 in. \varnothing , 4.0 in. L, W All Door Systems	1976–present
	477EE3 A477FH3	Bumper, Shouldered, 3.05 in. L, W Single-Slide & Center Opening Doors	1984–present

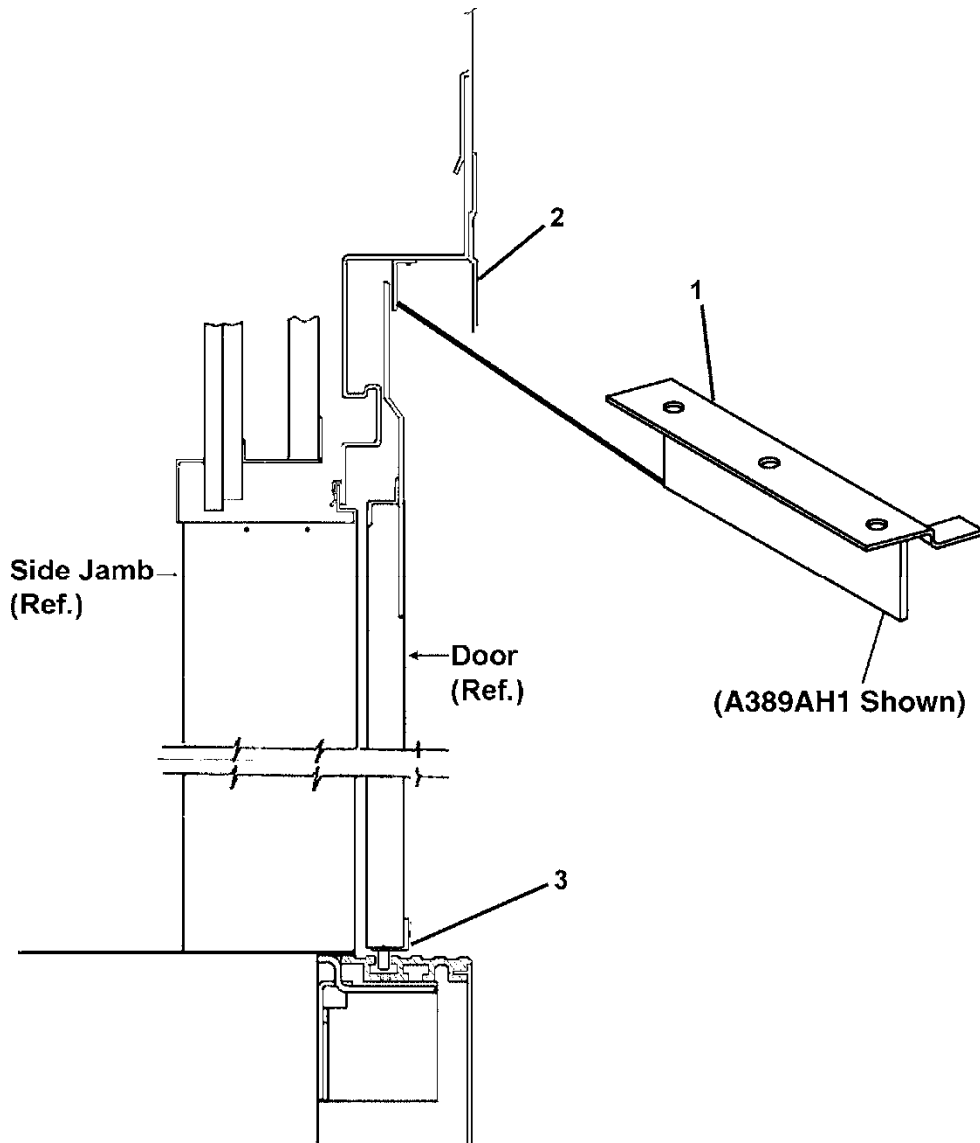



REF. No.	W/O VINTAGE PART No.	DESCRIPTION	VINTAGE
1	AAA50ANN-AL-104	Sill, Extruded Shape, Aluminum, 104.0 in. L, W Single-Slide & Center-Opening Doors	NOTE
	AAA50ANN-AL-104 AAA50ANP-AL-120	Sill, Extruded Shape, Aluminum, 104.0 in. L, W Two-Speed Doors	
	AAA50ANN-7-120	Sill, Extruded Shape, Bronze Finish, 120.0 in. L, W Single-Slide & Center-Opening Doors	
	AAA50ANP-7-120	Sill, Extruded Shape, Bronze Finish, 120.0 in. L, W Two-Speed Doors	
	AAA50ANN-NS-96	Sill, Extruded Shape, Nickel-Silver Finish, 96.0 in. L, W Single-Slide & Center-Opening Doors	
	AAA50ANP-NS-96	Sill, Extruded Shape, Nickel-Silver Finish, 96.0 in. L, W Two-Speed Doors	

NOTE: to length and drill mount holes as needed.

The above listed sill shapes are suitable to replace any previous vintage of sills as may be listed in other replacement parts documents such as the 2020 Forms. This includes finished sill parts of types: 426AE, A426AE, 426AJ, and A426AJ and the unfinished sill shape types: 50ABM, A50ABM, 50AFJ, and 50AFK.

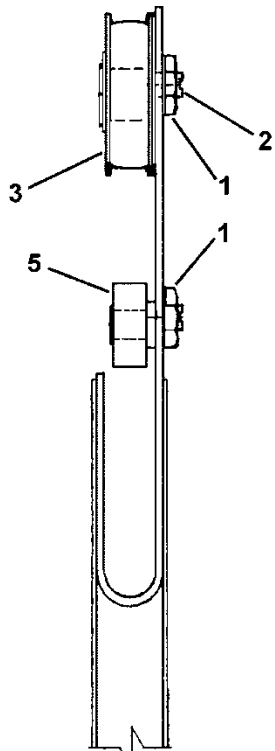
In special cases where a hole pattern is critical, contact the Otis Service Center to special order a finished sill of original equipment.



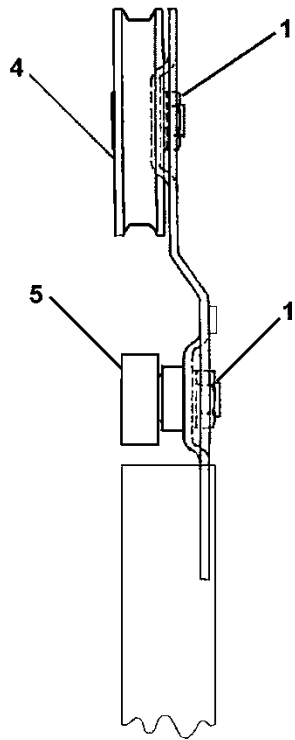
W/O VINTAGE			
REF. No.	PART No.	DESCRIPTION	VINTAGE
1	283LY1	Angle, Retaining, w/ Two Mounting Holes, 1.5 in. L, 1.625 (1-5/8)–2.0 in. H	1970–78
	A283LY1	Angle, Retaining, w/ Four Mounting Holes, 1.5 in. L, 1.375 (1-3/8) in. H	1979–94
	A389AH1	Angle, Retaining, w/ Upthrust Leg, 5.0 in. L	1986–
2	---	Cover, Dust, Type 410F (special order only)	1976–
3	---	Door Guide and Gib,  SPL 25-AAA24479AAA	---

Door Hanger Rollers

25-6178R

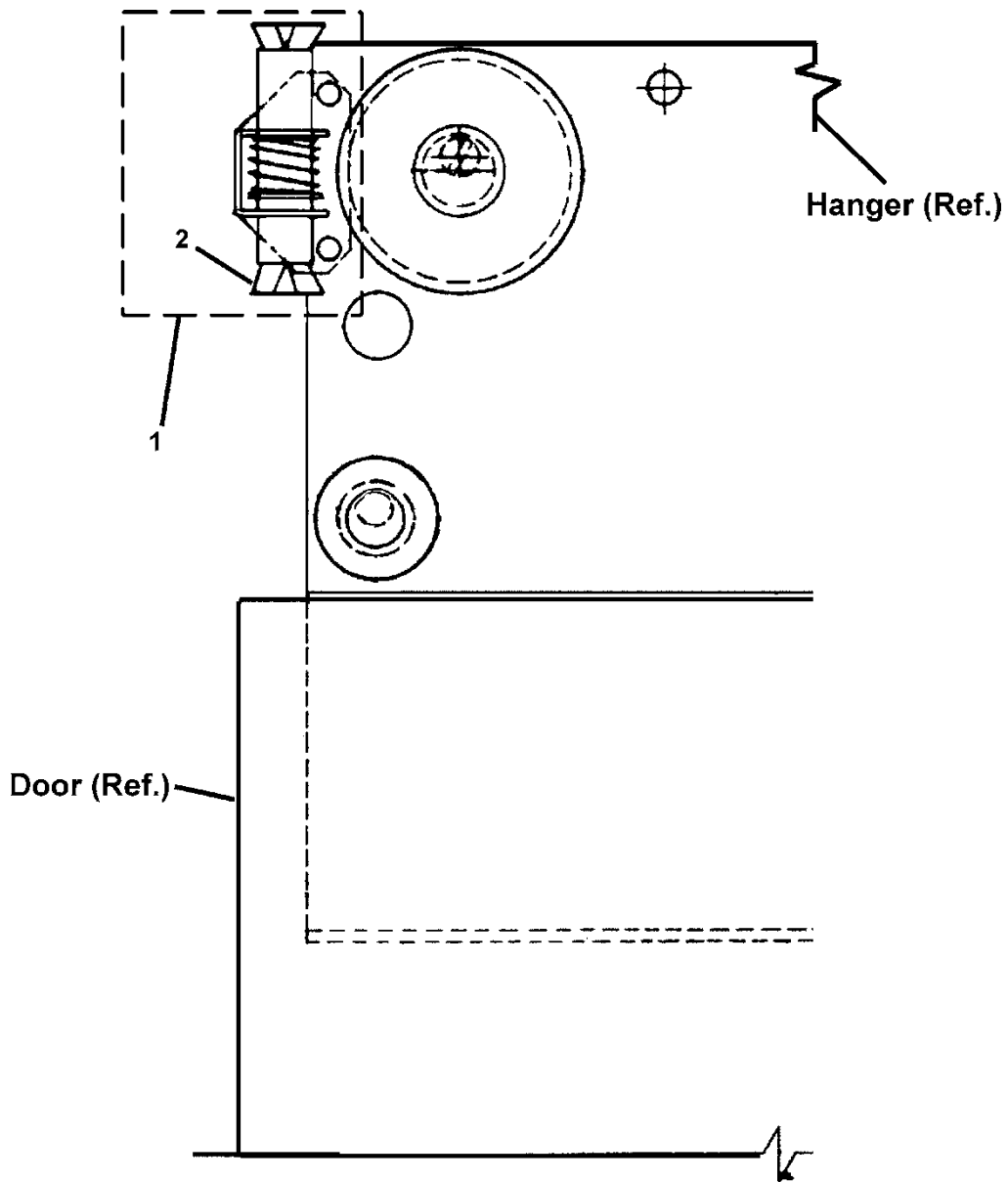




Vintage: 1959-1962



Vintage: 1962-Present

REF. No.	PART No.	DESCRIPTION
	W/O VINTAGE	
1	72AF2	Nut
2	77RK1	Pin, Type 456CC Rollers
3	456CC1	Roller, Steel, 2.75 in. \varnothing , Vintage 1959-62
	456CC2	Roller, Polyurethane, 2.75 in. \varnothing , Vintage 1959-62
4	456CY2	Roller
	456DH1	Roller, Spot-Welded Construction, 3.375 in. \varnothing
	456EW1	Roller, w/Integral Eccentric Pin, Polyurethane Tire, 3.375 in. \varnothing
	456GX4	Roller, 3.375 in. \varnothing , Poly Tire w/Removable Pin (TIP 21.2-4, use p/n 456EW2)
	456EW2	Roller, w/Reversible Eccentric Pin, Polyurethane Tire, 3.375 in. \varnothing , TIP 21.2-4
5	207Z4	Roller, Upthrust, Vintage 1959-1962
	456CP1	Roller, Upthrust, Eccentric, 1.625 in. L, Single-Slide, Center-Opening, and Two-Speed (Slow) Doors, Vintage 1986-present
	456CP2	Roller, Upthrust, Eccentric, 1.375 in. L, Single-Slide, Center-Opening, and Two-Speed (Slow) Doors, Vintage 1962-1986
	456EK1	Roller, Upthrust, Two-Speed (Fast) Door (shallow clearance for passing door)

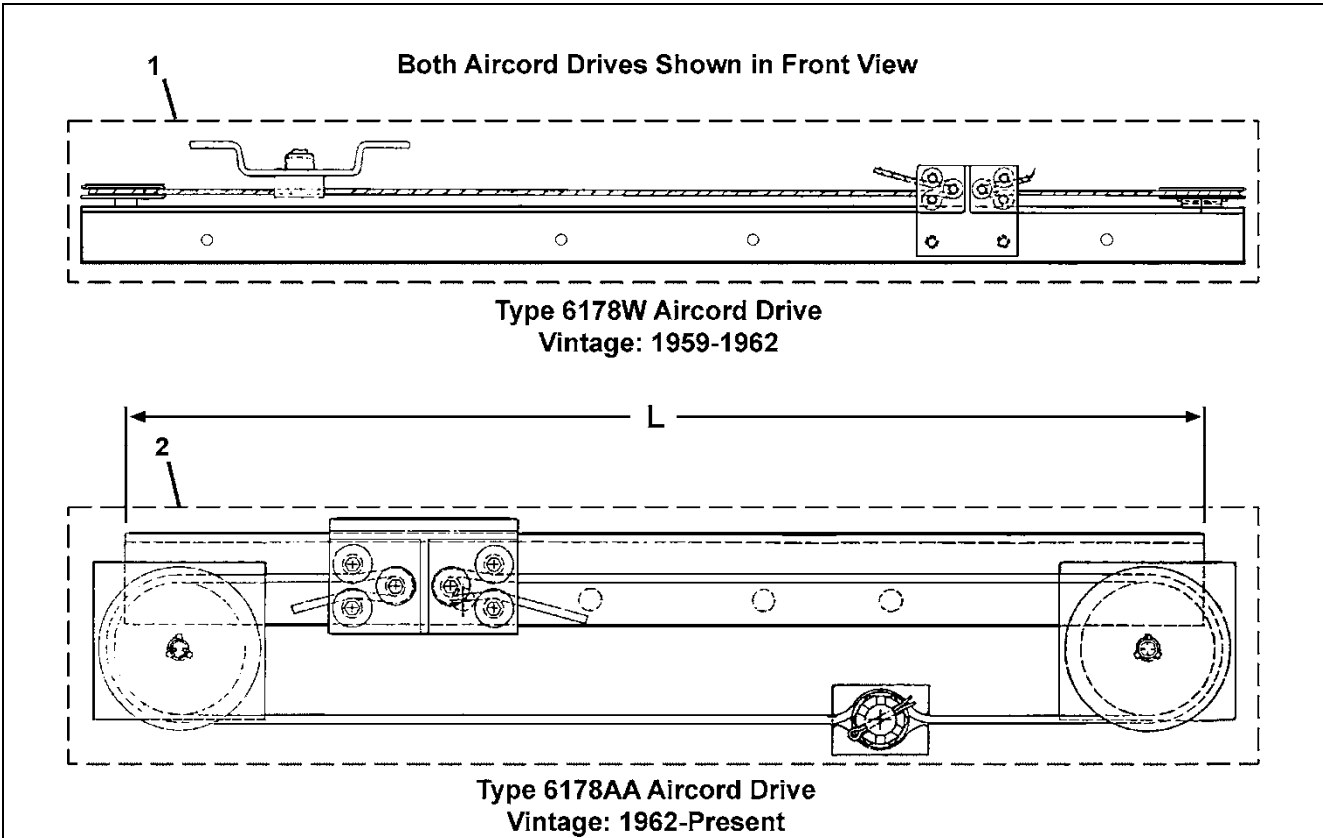


W/O VINTAGE		
REF. No.	PART No.	DESCRIPTION
1	A180AT2 180AT3	Lubricator, 
	A180AT3 180AT2	Lubricator, 
2	AAA488M1	Wick, Lubricator

Two-Speed Doors

Aircord Drive Assembly

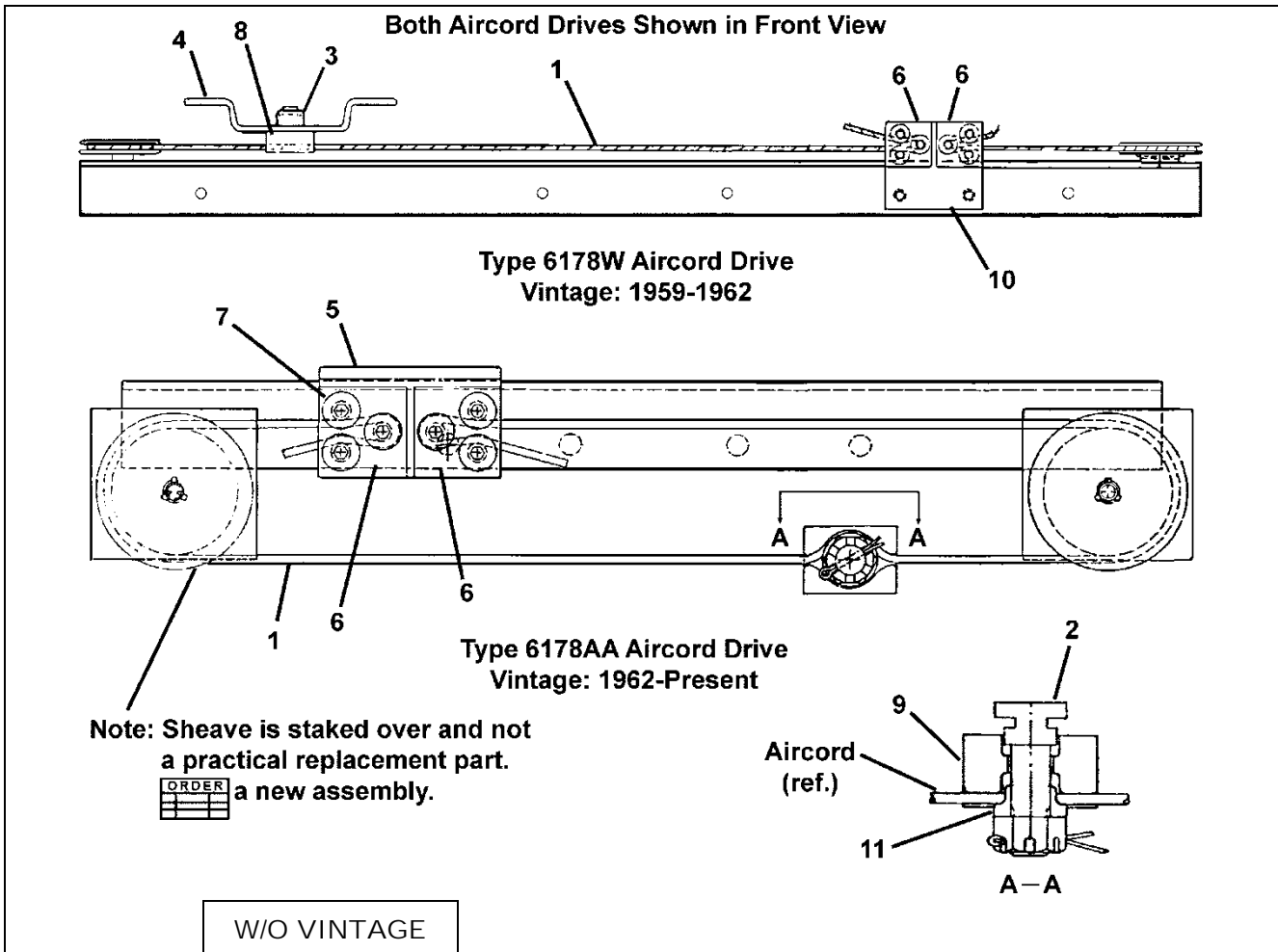
25-6178R



REF. No.	PART No.	DESCRIPTION	ENTRANCE WIDTH (in.)
1	6178W3	Assembly, Aircord, Complete, L = 32.125 in.	---
	6178W1	Assembly, Aircord, Complete, L = 36.625 in.	---
	6178W2	Assembly, Aircord, Complete, L = 41.125 in.	---
2	B6178AA1	Assembly, Aircord, Complete, L = 25.5 in.	31-33
	B6178AA2	Assembly, Aircord, Complete, L = 27.25 in.	Over 33-36
	B6178AA3	Assembly, Aircord, Complete, L = 28.5 in.	36-39
	B6178AA4	Assembly, Aircord, Complete, L = 30.0 in.	Over 39-42
	B6178AA5	Assembly, Aircord, Complete, L = 31.5 in.	42-45
	B6178AA6	Assembly, Aircord, Complete, L = 33.0 in.	Over 45-48
	B6178AA7	Assembly, Aircord, Complete, L = 34.5 in.	48-51
	B6178AA8	Assembly, Aircord, Complete, L = 36.0 in.	Over 51-54
	B6178AA20	Assembly, Aircord, Complete, L = 37.5 in.	54-57
	B6178AA21	Assembly, Aircord, Complete, L = 39.0 in.	Over 57-60

25-6178R

Two-Speed Doors Aircord Drive Parts



Note: Sheave is staked over and not a practical replacement part. a new assembly.

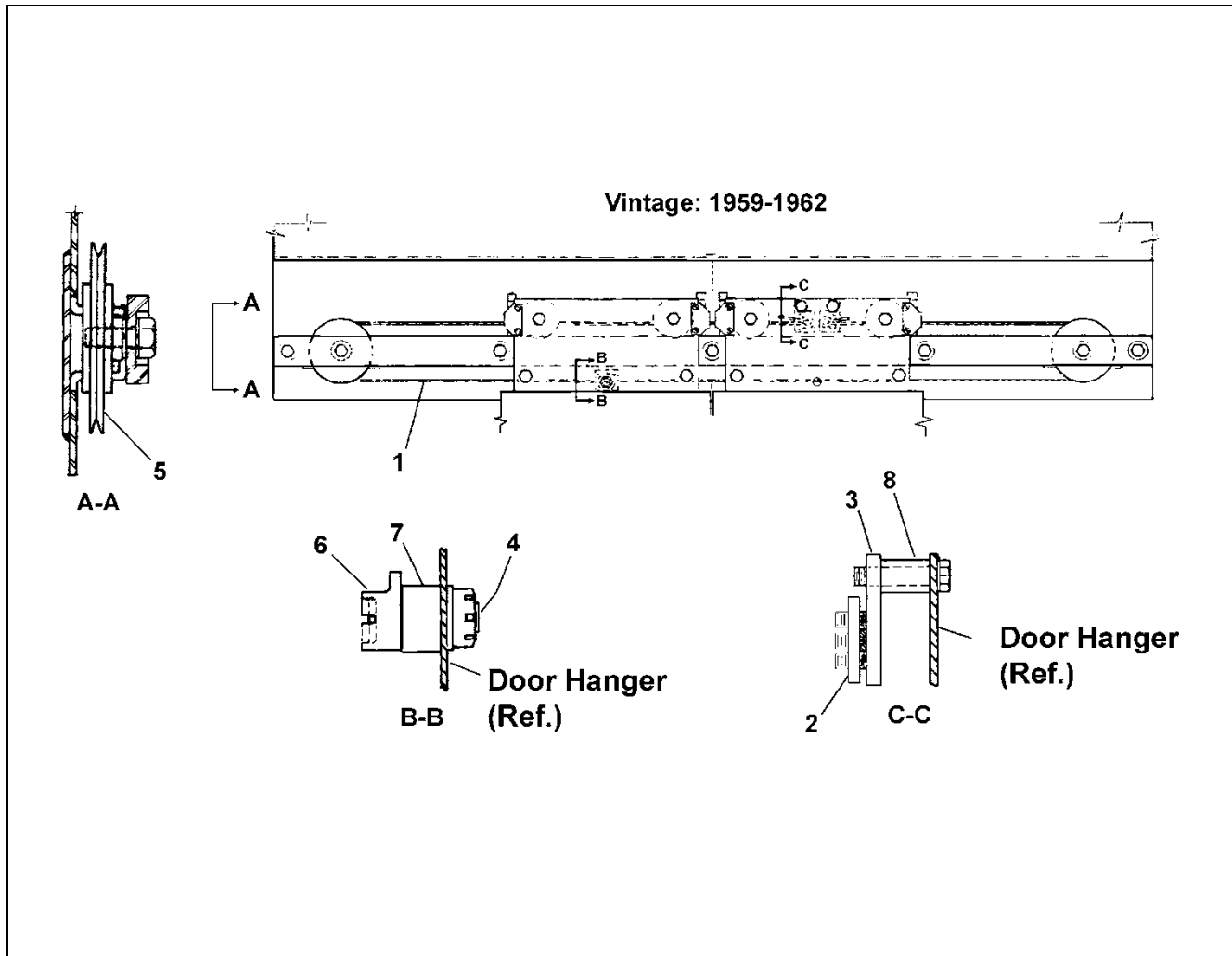
ORDER

ORDER

REF. No.	PART No.	DESCRIPTION			
1	174AS995	Aircord, <table border="1"><tr><td>ORDER</td></tr><tr><td> </td></tr><tr><td> </td></tr></table> Per Foot	ORDER		
ORDER					
2	65CN1 65CN3	Bolt, T-Slotted			
3	124CH1	Bolt			
4	316BTG2	Bracket			
5	316BEE5	Bracket Angle w/Holes (for mounting 1-5/8 x 1-3/4 in.)			
	316BEE6	Bracket Angle w/Slots (for mounting 1-5/8 x 1-1/4 in.)			
6	386AKS1	Plate, Clamp (two per assembly)			
7	---	Screw, Flat Head, Hex Socket, 5/16-18 x 0.5 in. (obtain locally)			
8	231D1	Socket, Rope, 0.6875 (11/16) in. W.			
9	231E1	Socket, Rope, 0.86 (55/64) in. W, (1/4 in. recess on backside)			
	231F2	Socket, Rope, Vintage: >7/2001, (1/8 in. recess on backside)			
10	298FM1	Strip, Anchor, 3.0 x 3.125 in.			
11	133BC1	Washer, Spring Seat			

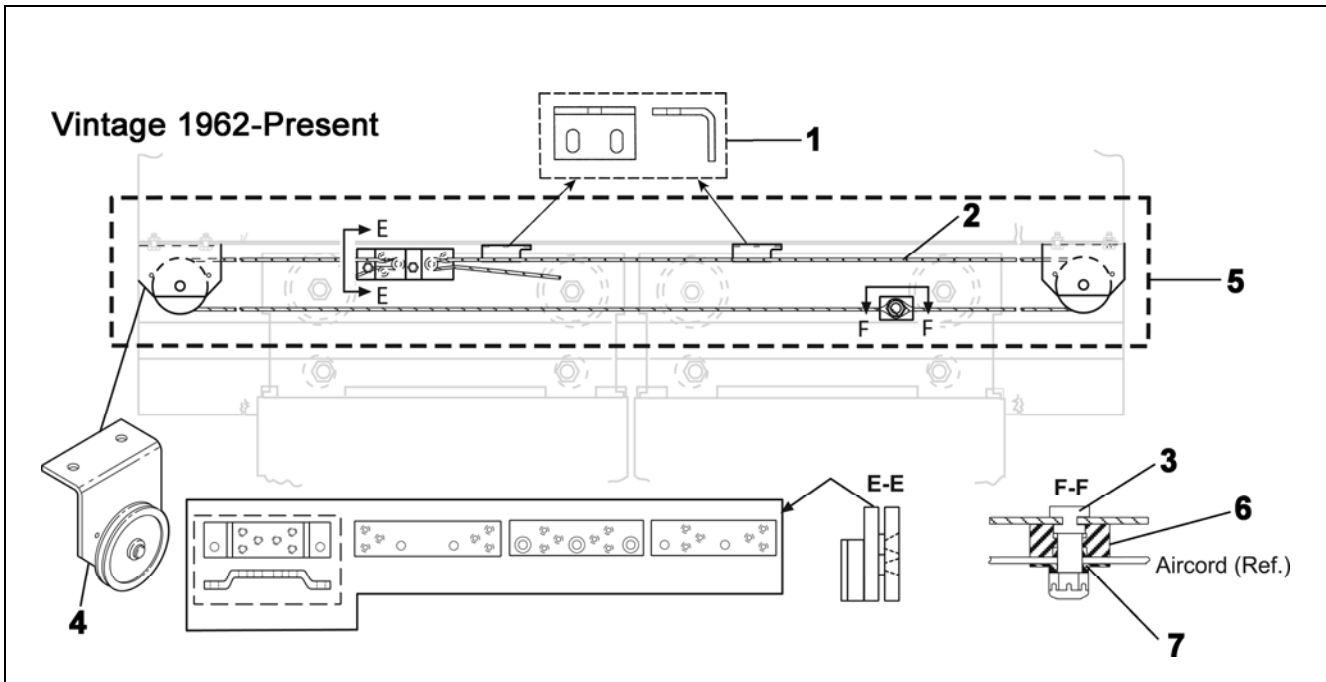
Center-Opening: Related Cable Assembly

25-6178R



W/O VINTAGE					
REF. No.	PART No.	DESCRIPTION			
1	174AS995	Aircord, <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>ORDER</td></tr><tr><td> </td></tr><tr><td> </td></tr></table> Per Foot	ORDER		
ORDER					
2	298FK1	Plate			
3	299VY1	Plate, Vintage 1959-62 Only			
4	124CH2	Screw, 1/2-13 UNC x 2.0 in.			
5	265BK2	Sheave, Vintage 1959-62 Only			
6	231C1	Socket, Rope, 0.687 in. W			
7	462HA51	Spacer, 1.125 in. \varnothing			
8	462HA52	Spacer, 0.625 in. \varnothing			

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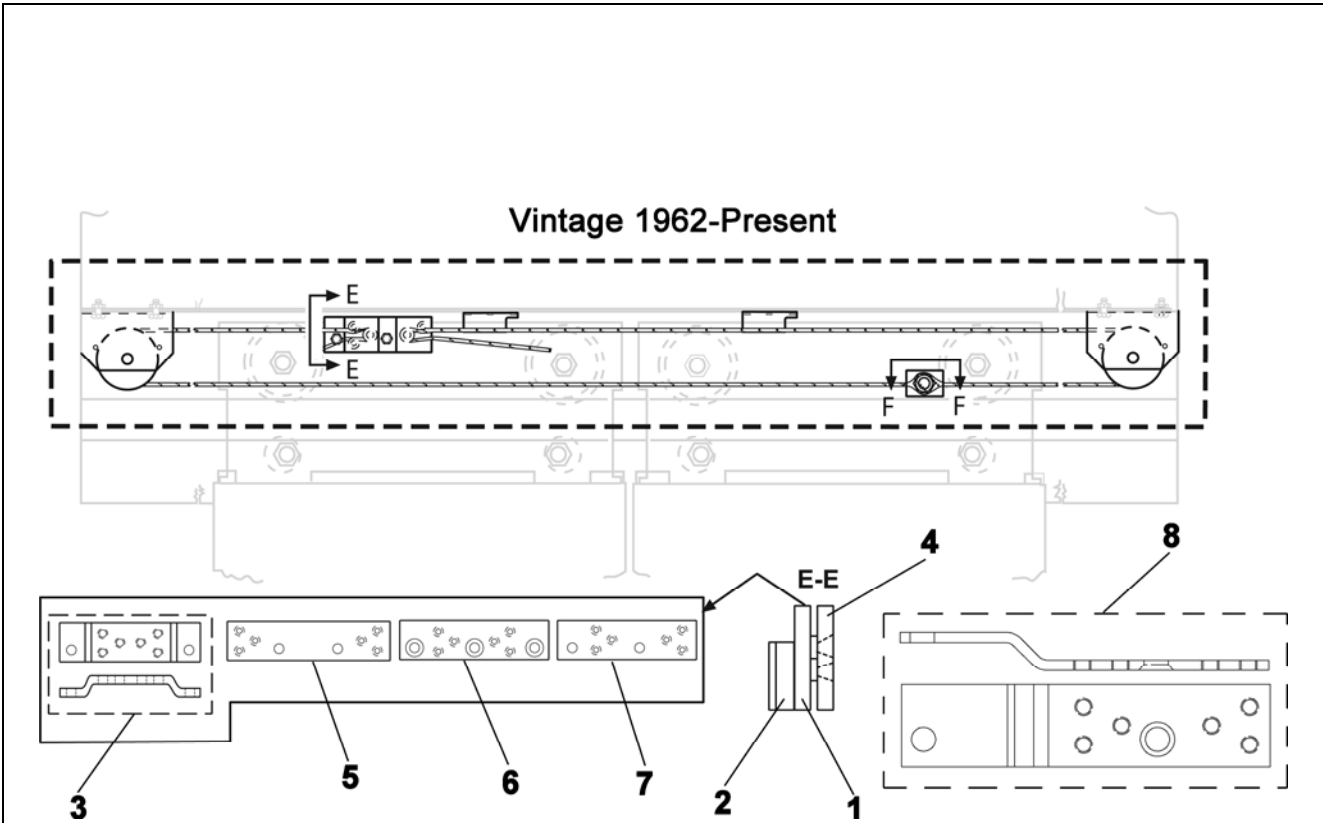
NOTE: The original equipment compatibility of the T-slotted bolt and rope socket is as follows:
 65CN1 and 231E1 (manufactured before 7/2001)
 65CN3 and 231F2 (manufactured after 7/2001)
 Service Engineering recommends that if you need to replace Ref. 4 or 12, check for the type of rope socket used. If the old style is present (recess is 1/4 in., p/n 231E1), then order both 231F2 and 65CN3.

REF. No.	PART No.	DESCRIPTION	
1	283DP1	Angle, Formed (aircord connect at header)	
2	174AS995	Aircord, <table border="1" style="display: inline-table; vertical-align: middle;"><tr><td>ORDER</td></tr></table> Per Foot	ORDER
ORDER			
3	65CN1 65CN3	Bolt, T-Slotted, NOTE	
4	B316CCB2	Bracket and Sheave Assembly	
5	F6178T400	Kit, Related Cable Repair (including Ref. 1–4, 8, 9, 12, and 13)	
6	231E1	Socket, Rope, 0.86 (55/64) in. W, (1/4 in. recess on backside), NOTE	
	231F2	Socket, Rope, Vintage: >7/2001, (1/8 in. recess on backside), NOTE	
7	133BC1	Washer, Spring Seat	

(Continued on next page)

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	W/O VINTAGE	
REF. No.	PART No.	DESCRIPTION
1	A299G41	Bar, Spacer, 3.25 in. L, 0.06 in. W
2	A299G5	Bar, Spacer, 3.25 in. L, 0.38 in W
3	316CCA1	Bracket, 5 in. L, Vintage: 8/1962–3/1967
4	386AKS1	Plate, Clamp (two per assembly)
5	386BKM1	Plate, Hitch, 4.7 in. L, Vintage: 6/1977–
6	386BCR1	Plate, Hitch, 5.5 in. L, Vintage: 6/1971–6/1977
7	392BC2	Plate, Hitch, 6 in. L, Vintage: 3/1967–6/1971
8	316CVF1	Plate, Hitch, RH (shown)
	316CVF2	Plate, Hitch, LH