



Honeycomb Doors – Built to exact specifications to provide years of maintenance free performance....



Product Features

- Available in 16, 18 and 20 gauge Cold rolled steel and Galvanized
- Honeycomb Core provides excellent impact resistance and a high strength to weight ratio
- Uniform core thickness + thermal pressing yield an exceptionally flat surface
- Square edge non-handed design minimizes inventory
- Inverted bottom channel allows for modification to meet floor conditions
- Seamless welded edge construction provides structural integrity and long lasting durability
- Flush top channel as standard
- Closer reinforcing bonded to each skin, internally reinforced as standard
- Available in Cylindrical prep (161), Mortise prep (86) and Rim panic preps.

Corrosion Resistance

- Doors are chemically treated to insure paint adhesion
- Doors are painted with a baked on two component epoxy rust inhibitive primer
- All products meet or exceed ANSI A250.1-1998
- Salt Spray resistance: Acceptance Criteria for Prime Painted Steel Doors and Frames

Standards & Codes

- Meets or exceeds ANSI/SDI A250.6 – 2003 “Recommended Practice for Hardware Reinforcing on Standard Steel Doors and Frames”
- Hardware preparations and reinforcements are in accordance with ANSI A250.6-2003
- Locations are in accordance with ANSI/DHI A115
- Meets the requirements of ANSI A250.8-2003 (Commonly known as SDI-100)
- Listed for fire door installations requiring positive or negative pressure testing (UBC-7-2-97, UL 10B, and UL 10C) in sizes to 4080 singles and 8080 pairs



Polystyrene Doors – Our P Series doors hot pressed for consistent product quality, the full surface, continually bonded core insures no oil canning, waves or imperfections throughout the product...



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6 Panel Embossed Doors – *Our embossed doors hot pressed for consistent product quality, no buckles or imperfections around emboss patterns...*



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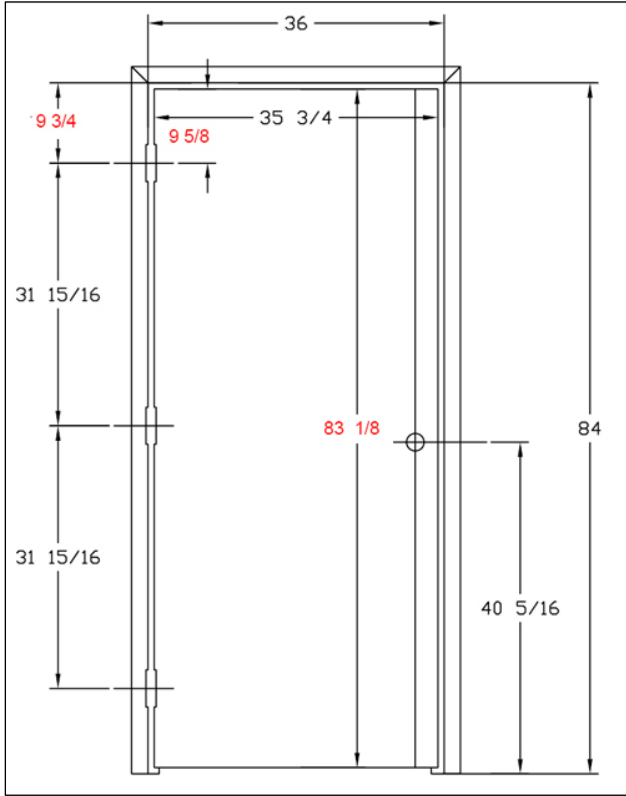
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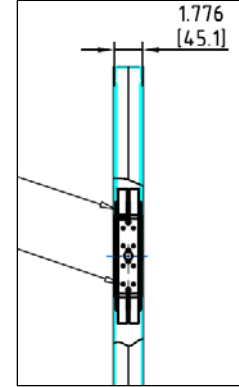
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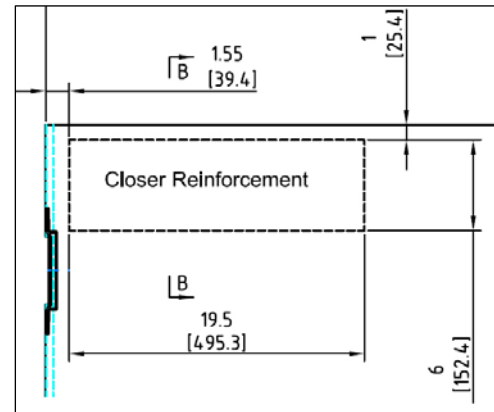
opening Solutions group



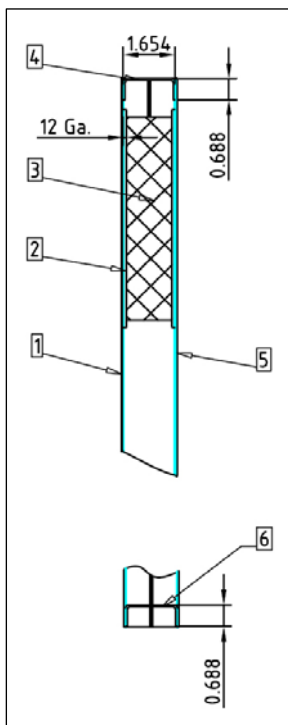
3070 Door with Frame (standard hinge locations)



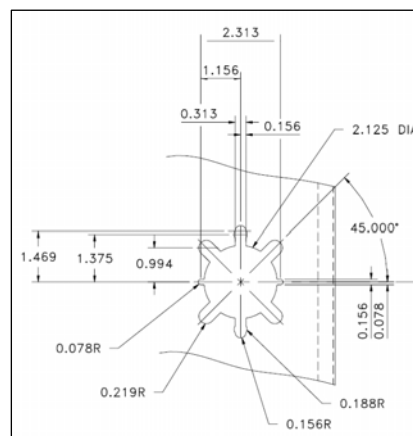
10 ga Hinge reinforcement



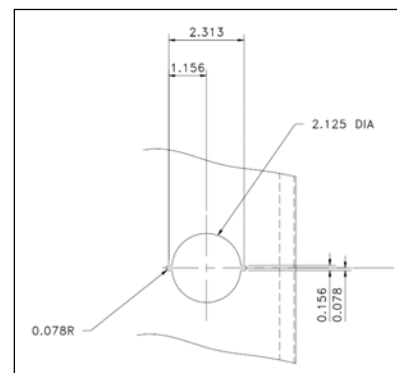
Closer reinforcement location



1. 18ga Steel
2. 12ga closer reinforcement (standard)
3. Honeycomb core filler between closer reinforcement plates
4. 16ga Top flush cap
5. 2 component epoxy prime paint
6. 16ga inverted bottom channel



Turtle prep for lever locks



Cylindrical prep (161)



HOLLOW METAL DOORS

Materials

1.1.1 Cold-Rolled steel doors shall comply with ASTM A366 cold-rolled carbon steel sheet.

1.1.2 Galvanized doors shall comply with ASTM A924 general requirements for steel sheet metallic coated by hot dip process.

1.1.3 Doors shall be free of scale, pitting or other surface defects. Face sheets for interior doors shall be no less than 20 gauge. Face sheets for exterior doors shall be not less than 18 gage and shall be zinc coated, and chemically treated for paint adhesion.

1.1.4 All parts, reinforcements and components shall be made of steel unless otherwise indicated.

Design and Construction

1.2.1 All doors shall have welded joints and shall be seamless construction with no visible seams or joints on the faces or vertical edges. Minimum door thickness shall be 1-3/4".

1.2.2 All doors shall be strong, rigid and neat in appearance, free from warpage or buckle. Corner bends shall be true and straight and of minimum radius for the gage metal being used.

1.2.3 Face sheets shall be stiffened by the use of 1 lb./cubic ft. density pre-cured rigid polystyrene core or paper honeycomb bonded to both panels.

1.2.4 Doors shall have square edges and be non-handed. Hinge mortises shall extend through both door faces and filler plates will be provided to permit the use of left hand or right hand swing.

1.2.5 Door faces shall be joined at their vertical edges by welds on 2 inch centers. All welds shall be ground, filled and dressed smooth to make them invisible and provide a smooth flush surface.

1.2.6 The top and bottom edges shall be closed with a recessed steel channel not less than 16 gage, welded to both panels. Welds shall occur on approximately 2" on center.

1.2.7 Openings shall be provided in the bottom closure to permit the escape of entrapped moisture. The bottom channel of all doors shall be galvanized steel for additional protection against rust due to the escape of such moisture.

1.2.8 All doors shall have a 12 Gage steel closer reinforcement welded to each door panel as standard.



Hardware

1.3.1 Doors shall be mortised, reinforced, drilled and tapped at the factory for fully template hardware only in accordance with ANSI/DHI A115.1 (Mortise) or A115.2 (Bored). Where surface-mounted hardware is to be applied, doors shall have reinforcing plates only. All drilling and tapping shall be a field operation by installation personnel.

1.3.2 Minimum gauges for hardware shall be in accordance with ANSI/SDI A250.6-2003.

1.3.3 Hinge Reinforcements 10 Gage

1.3.4 Reinforcements for locks, flush bolts 14 Gage

1.3.5 Reinforcements for surface mounted closers 14 Gage Door Finish

1.4.1 After fabrication, all tool marks and surface imperfections shall be dressed clean by grinding, filling and sanding as necessary to make all faces and vertical edges smooth and free of irregularities.

1.4.2 Doors shall be chemically treated to insure maximum paint adhesion.

1.4.3 Doors shall be coated on all exposed surfaces with a rust inhibitive primer which will be baked on.

1.4.4 Primer materials shall comply with ANSI A250.10 Test Procedures and Acceptance Criteria for Prime Painted Steel Surfaces for Steel Doors and Frames.