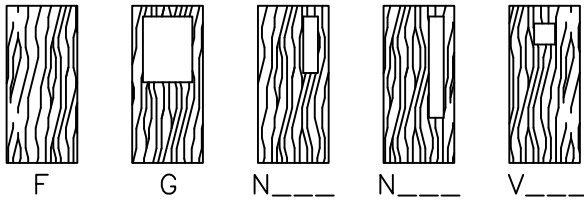
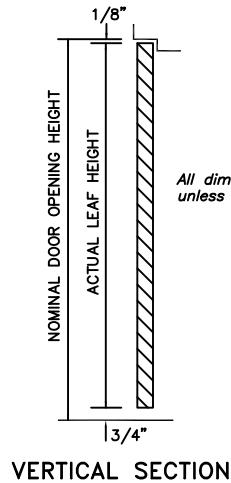
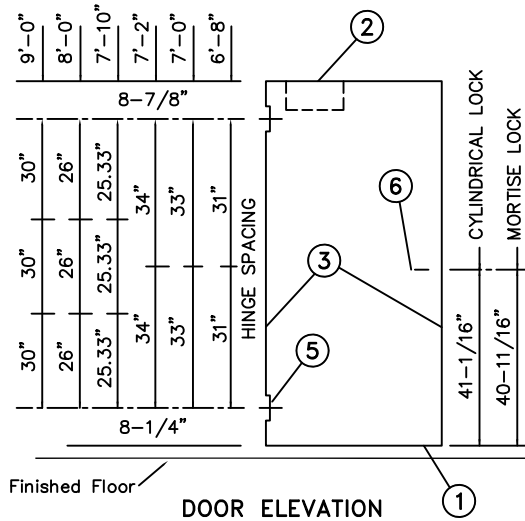
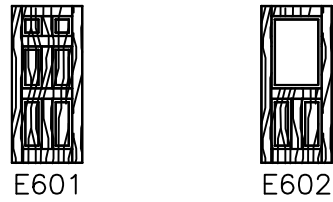


FLUSH DESIGNS



EMBOSSED PANEL DESIGNS



SIZE LIMITS  
DESIGNS/MATERIAL

	FLUSH DESIGN 16, 18 ga.	6 PANEL 18 ga.
MAX.	4'0"X9'0"	3'0"X7'0"
MIN.	2'0"X6'8"	2'8"X6'8"

All dimensioning in inches unless noted otherwise

FIRE DOORS

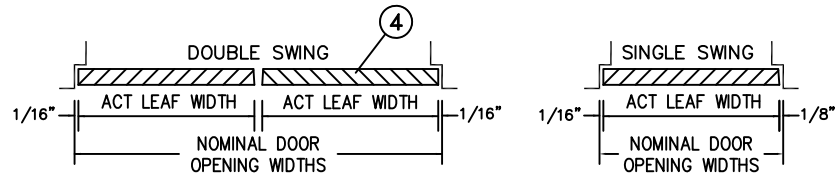
TESTS:  
UL10B, UL10C, NFPA 252 & UL1784  
UL LLC  
WARNOCK HERSEY  
RATINGS: 20 MIN, 3/4 HR,  
1-1/2 HR, OR 3 HR  
MAX. SIZES: SINGLE - 4'0"X8'0"  
PAIR - 8'0"X8'0"  
DESIGNS: SEE ABOVE

GLAZING TRIM

STEEL WOOD GRAIN LITE KIT  
Glass thickness options,  
1/4", 1/2", 3/4", & 1"  
Glass & Glazing by others

ASTRAGAL

STEEL WOOD GRAIN (A4471M)

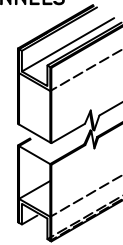


HORIZONTAL SECTIONS

1-3/4" MADERA® WOOD GRAIN STEEL DOOR  
EMBOSSED PANEL DESIGNS: 18 GAGE A40 GALVANNEALED STEEL  
FULL FLUSH DESIGNS: 18 or 16 GAGE A40 GALVANNEALED STEEL

① 16 GAGE STEEL END CHANNELS

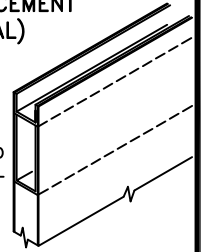
INVERTED TOP AND BOTTOM CHANNELS



WELDED TO BOTH FACE SHEETS

② CLOSER REINFORCEMENT (OPTIONAL)

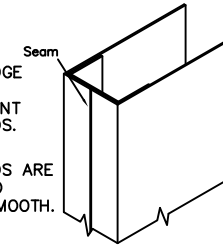
14 GAGE STEEL CHANNEL WELDED TO END CHANNEL



③ VERTICAL EDGES

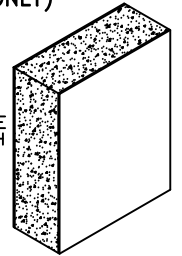
CENTER EDGE SEAM WITH INTERMITTENT SPOT WELDS.

SPOT WELDS ARE FILLED AND GROUND SMOOTH.



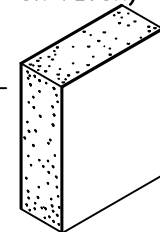
④ MINERAL CORE (FLUSH ONLY)

PERMANENTLY BONDED TO THE INSIDE OF BOTH FACE SHEETS.



④ POLYSTYRENE FOAM CORE (EMBOSSED OR FLUSH)

SOLID SLAB OF EXPANDED \*POLYSTYRENE FOAM PERMANENTLY BONDED TO THE INSIDE OF EACH FACE SKIN.



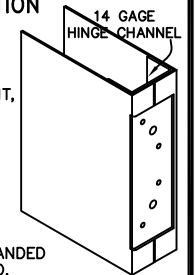
\*OPTIONAL - POLYURETHANE CORE (FLUSH ONLY)

⑤ HINGE PREPARATION

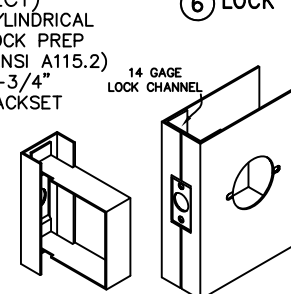
4-1/2 OR 5 IN. HIGH, STANDARD OR HEAVY WEIGHT, FULL MORTISE HINGES

ANSI A156.7 TEMPLATE

HINGE EDGE IS HANDED AND NOT BEVELED.



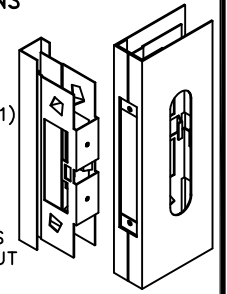
(LC1)  
CYLINDRICAL LOCK PREP (ANSI A115.2)  
2-3/4" BACKSET



⑥ LOCK PREPARATIONS

(LM1)  
MORTISE LOCK PREP (ANSI A115.1)  
2-3/4" BACKSET

(LM0)  
SIMILAR TO DETAIL LESS FACE CUTOUT



CecoDoor (Conversion: 1" = 25.4 mm, e.g., 1-3/4" = 44.45 mm)

ASSA ABLOY

DRAWN BY \_\_\_\_\_ DATE \_\_\_\_\_  
CHK'D BY \_\_\_\_\_ DATE \_\_\_\_\_

SHT \_\_\_\_\_ CONTRACT NO. \_\_\_\_\_  
OF \_\_\_\_\_

ISSUE DATE

REVISIONS

BY

FOR HAND & SWING

SEE DOOR SCHEDULE

NOTE: FOR GLAZING TRIM OR ASTRAGALS REQUIRED, SEE DOOR SCHEDULE & ACCESSORY SHEET

CORE THERMAL INSULATION

DOOR SOUND TRANSMISSION

PHYSICAL ENDURANCE TEST DATA

MINERAL CORE

NA

POLYSTYRENE

CALCULATED R VALUE = 6.35 (ASTM C518)

STC 24 (18 GAGE)  
ASTM E90 & E413 (FULLY OPERABLE)

18 GAGE: LEVEL A (1,000,000 CYCLES)  
16 GAGE: LEVEL A (1,000,000 CYCLES)

POLYURETHANE

CALCULATED R VALUE = 10.04 (ASTM C518)

NA

NA