DOORMERICA®
Products

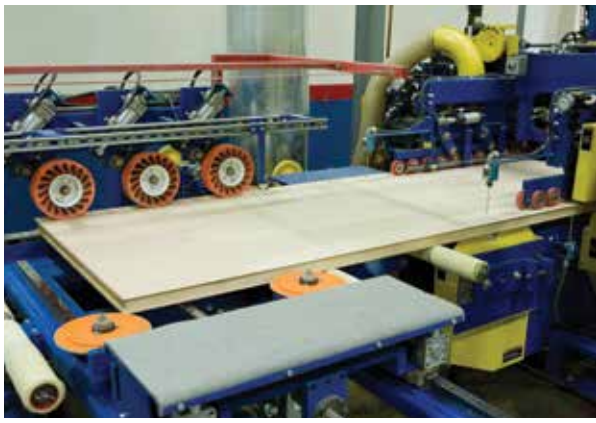
American Series®

ARCHITECTURAL FLUSH AND MOLDED WOOD DOORS

DOORMERICA®
Products

State-of-the-Art Manufacturing

DOORMERICA produces American Series commercial, residential flush, and molded doors in two state-of-the-art manufacturing facilities located in Stockton, California and Atlanta, Georgia. Serving the entire nation with reliable, high-quality products and dependable lead times. Providing an array of door products in hardwood, paint grade, molded panel, and five-ply, including factory pre-finished architectural doors in various species. We are LEED certified and feature many products to meet green building initiatives. DOORMERICA is your full-service commercial and residential door supplier. Building quality products since 1989.



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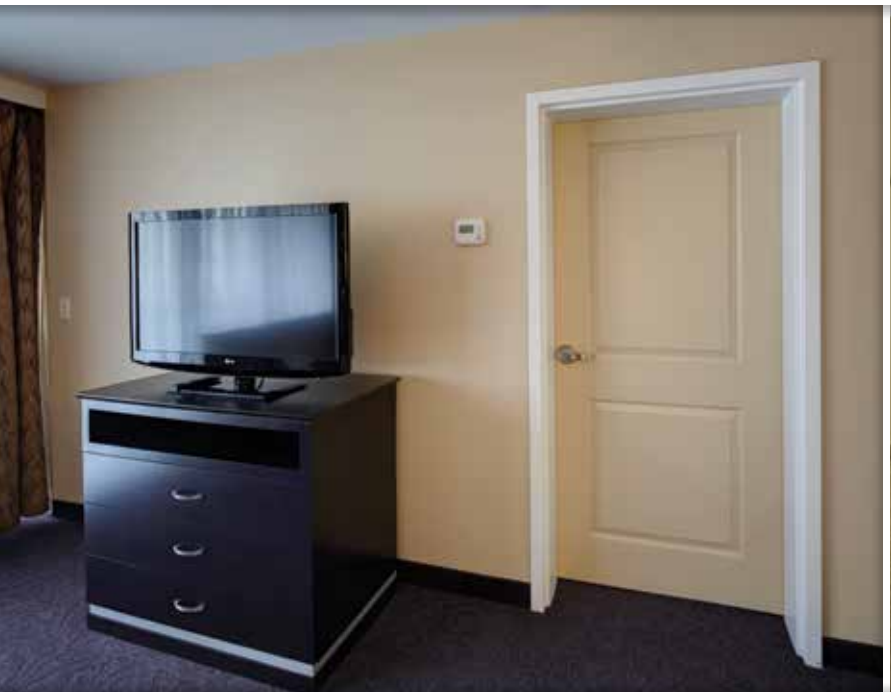


Flush Doors

Flush Doors

ECONOMY CONSTRUCTION

This Particleboard construction offers a wide variety of 2-ply light commercial wood veneers, molded panel, MDF, and Legacy skins with softwood edges for both residential and light commercial projects.

Flush "Economy" Particleboard Core

- **Specifications**: 3 & 5 Ply construction. Meets or exceeds industry standards of WDMA I.S.1; All 20 Minute doors have been tested in conformance to the following standards. ASTM-E-152, CSFM-43.7, CAN4-S104,NFPA-252, UBC-7-2-97, UL-10C
- **Lay Up Method**: Loose
- **Maximum Sizes**: Width - 4/0; Length - Depends on faces (See faces below for available length)
- **Thickness**: 1-3/8" and 1-3/4" ONLY
- **Stiles**: Softwood (Fir, Pine, Spruce, Basswood, SCL) Mill option Width = 1" Nominal, 13/16" Minimum after prefit size.
- **Rails**: 1-3/8" Thickness = MDF, 1-5/8" Nominal, 1" Minimum after undercut
  1-3/4" Thickness = MDF, 2-1/4" Nominal, 1" Minimum after undercut
- **Core**: 28-30lb Particleboard, ANSI A208.1 Grade LD-1
- **Fire Rating**: 1-3/4" Thickness 20 Minute Rated*
- **Faces**: Raw only Lauan (Okuome) 2 Ply, 8/0 Max length.
  Raw only RN Birch 2 Ply, MDF Back, 1/64" Face Veneer, 8/0 Max length
  Raw only PS Red Oak 2 Ply, MDF Back, 1/64" Face Veneer, 8/0 Max length
  Raw MDF Single Ply, 10/0 Max length
  Primed MDF Single Ply, 10/0 Max length
  Embossed Primed MDF Single Ply, 8/0 Max length
  Embossed Prefinished MDF (Legacy) Single Ply, 8/0 Max length
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: To Specification
- **Louvers**: To Specification
- **Acoustical Rating**: 32 STC Operable - See www.doormerica for seal information
- **Warranty**: Standard two year. See limited warranty for details.
- **Description Abreviations**: E-1-3/8 = 1-3/8" Thick PBC
  E-20NL = 1-3/4" Thick PBC, Non Rated
  E-20B = 1-3/4" Thick PBC, 20 Minute Category B
  E-20A = 1-3/4" Thick PBC, 20 Minute Category A
- **Recommended Use**: Residential and Light Commercial

**See fire door specifications section in catalogue for details on sizes, hardware and construction limitations.*

Flush Doors

STANDARD CONSTRUCTION

The Standard Construction is a particleboard core featuring either light commercial commodity wood veneers, plastic laminate, and 2-ply wood veneers with matching hardwood edges suited for both residential and light commercial projects.

Flush "Standard" Particleboard Core

- **Specifications**: 3 & 5 Ply construction. Meets or exceeds industry standards of WDMA I.S.1; All 20 Minute doors have been tested in conformance to the following standards. ASTM-E-152,CSFM-43.7,CAN4-S104,NFPA-252, UBC-7-2-97, UL-10C
- **Lay Up Method**: Loose
- **Maximum Sizes**: Width - 4/0; Length - Depends on faces (See faces below for available length)
- **Thickness**: 1-3/8" and 1-3/4" ONLY
- **Stiles**: Paint Grade = FJ Hardwood, Raw Stain Grade = Matching Hardwood
  Prefinished = Matching Hardwood
  P-lam = SCL with matching edge banding over
  CAT-A = Special CAT-A Stile with matching edge banding over
  Width = 1" Nominal, 13/16" Minimum after prefit size.
- **Rails**: 1-3/8" Thickness = MDF, 1-5/8" Nominal, 1" Minimum after undercut
  1-3/4" Thickness = MDF, 2-1/4" Nominal, 1" Minimum after undercut
- **Core**: 28-30lb Particleboard, ANSI A208.1 Grade LD-1
- **Fire Rating**: 1-3/4" Thickness 20 Minute Rated*
- **Faces**: RN Birch 2 Ply, MDF Back, 1/64" Face Veneer, 8/0 Max length
  PS Red Oak 2 Ply, MDF Back, 1/64" Face Veneer, 8/0 Max length
  Raw MDF Single Ply, 10/0 Max length
  Primed MDF Single Ply, 10/0 Max length
  Primed MDO 2 Ply HDF Back, 10/0 Max length
  Select Species Raw & Prefinished 2 Ply, 1/42" Face, 10/0 Max length
  Plastic Laminate 2 Ply, 1/50" Face, 10/0 Max length. All laminates meet or exceeds NEMA standards.
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: To Specification
- **Louvers**: To Specification
- **Acoustical Rating**: 32 STC Operable - See www.doormerica for seal information
- **Warranty**: Standard two year. See limited warranty for details.
- **Description Abreviations**: S-1-3/8 = Standard 1-3/8" Thick PBC
  S-20NL = Standard 1-3/4" Thick PBC, Non Rated
  S-20B = Standard 1-3/4" Thick PBC, 20 Minute Category B
  S-20A = Standard 1-3/4" Thick PBC, 20 Minute Category A
- **Recommended Use**: Residential and Light Commercial

**See fire door specifications section in catalogue for details on sizes, hardware and construction limitations.*

Flush Doors

HEAVY DUTY CONSTRUCTION

This bonded and sanded particleboard core construction features either plastic laminate, or 2-ply wood veneers with 1-3/8" matching hardwood stiles and wood rails perfect for any architectural use.

Flush "Heavy Duty" Particleboard Core

- **Specifications**: 5 Ply construction. Meets or exceeds industry standards of WDMA I.S.1-A, WI Section 12, AWI Section 1300 Custom Grade (A Grade Faces), AWI Section 1300 Premium Grade (AA Grade Faces). All 20 Minute doors have been tested in conformance to the following standards. ASTM-E-152, CSFM-43.7, CAN4-S104, NFPA-252, UBC-7-2-97, UL-10C
- **Lay Up Method**: Bonded and Sand
- **Maximum Sizes**: Width - 4/0
  Length - Depends on faces (See faces below for available length)
- **Thickness**: 1-3/8" and 1-3/4" ONLY
- **Stiles**: Paint Grade = FJ Hardwood, Raw Stain Grade = Matching Hardwood
  Prefinished = Matching Hardwood
  P-lam = SCL with matching edge banding over
  CAT-A = Special CAT-A Stile with matching edge banding over
  Width = 1-3/8" Minimum
- **Rails**: 1-3/8" Thickness = Wood or SCL 1-1/8" Minimum 1-3/4" Thickness = Wood or SCL 1-1/8" Minimum
- **Core**: 34lb Particleboard, ANSI A208.1 Grade LD-2
- **Fire Rating**: 1-3/4" Thickness 20 Minute Rated*
- **Faces**: Primed MDO 2 Ply HDF Back, 10/0 Max length
  Select Species Raw & Prefinished 2 Ply, 1/42" Face, 10/0 Max length
  Plastic Laminate 2 Ply, 1/50" Face, 10/0 Max length. All laminates meet or exceed NEMA standards.
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: To Specification
- **Louvers**: To Specification
- **Acoustical Rating**: 33 STC Operable - See www.doormerica for seal information
- **Warranty**: Lifetime. See limited warranty for details.
- **Description Abreviations**: HD-1-3/8 = Heavy Duty 1-3/8" Thick PBC
  HD-20NL = Heavy Duty 1-3/4" Thick PBC, Non Rated
  HD-20B = Heavy Duty 1-3/4" Thick PBC, 20 Minute Category B
  HD-20A = Heavy Duty 1-3/4" Thick PBC, 20 Minute Category A
- **Recommended Use**: Architectural

**See fire door specifications section in catalogue for details on sizes, hardware and construction limitations.*

Flush Doors

EXTRA HEAVY DUTY CONSTRUCTION

Our Extra Heavy Duty Construction features a bonded and sanded structural composite lumber core with either plastic laminate, or 2-ply wood veneers with 1-3/8" matching hardwood stiles and wood rails. Great for any architectural or institutional project.

Flush "Extra Heavy Duty" Structural Composite Lumber Core

- **Specifications**: 5 Ply construction. Meets or exceeds industry standards of WDMA I.S.1-A, WI Section 12, AWI Section 1300 Custom Grade(A Grade faces), AWI Section 1300 Premium Grade (AA Grade Faces). All 20 and 45 Minute doors have been tested in conformance to the following standards. ASTM-E-152 CSFM-43.7, CAN4-S104, NFPA-252;UBC-7-2-97, UL-10C
- **Lay Up Method**: Bond and Sand
- **Maximum Sizes**: Width - 4/0; Length - Depends on faces (See faces below for available length)
- **Thickness**: 1-3/8" and 1-3/4" ONLY
- **Stiles**: Paint Grade = FJ Hardwood, Raw Stain Grade = Matching Hardwood
  Prefinished = Matching Hardwood
  P-lam = SCL with matching edge banding over
  CAT-A = Special CAT-A Stile with matching edge banding over
  Width = 1-3/8" Minimum
- **Rails**: 1-3/8" Thickness = Wood or SCL 1-1/8" Minimum 1-3/4" Thickness = Wood or SCL 1-1/8" Minimum
- **Core**: Structural Composite Lumber (Engineered), Grade LD-2
- **Fire Rating**: 1-3/4" Thickness 20 Minute Rated*; 1-3/4" Single Swing 45 Minute rated**
- **Faces**: Primed MDO 2 Ply HDF Back, 10/0 Max length
  Select Species Raw & Prefinished 2 Ply, 1/42" Face, 10/0 Max length
  Plastic Laminate 2 Ply, 1/50" Face, 10/0 Max length. All laminates meet or exceed NEMA standards.
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: To Specification
- **Louvers**: To Specification
- **Acoustical Rating**: 34 STC Operable - See www.doormerica for seal information
- **Warranty**: Lifetime. See limited warranty for details.
- **Description Abreviations**: EHD-1-3/8 = Extra Heavy Duty 1-3/8" Thick SCL
  EHD-20NL = Extra Heavy Duty 1-3/4" Thick SCL, Non Rated
  EHD-20B = Extra Heavy Duty 1-3/4" Thick SCL, 20 Minute Category B
  EHD-20A = Extra Heavy Duty 1-3/4" Thick SCL, 20 Minute Category A
  EHD-45B = Extra Heavy Duty 1-3/4" Thick SCL, 45 Minute Category B **
  EHD-45A = Extra Heavy Duty 1-3/4" Thick SCL, 45 Minute Category A **
- **Recommended Use**: Architectural, Institutional

**See fire door specifications section in catalogue for details on sizes, hardware and construction limitations.*
*** Single Swing only on 45 Minte Fire Rated; Max size 4/0 8/0*

Flush Doors

MINERAL CORE CONSTRUCTION

Flush Mineral Core Construction is a bonded and sanded gypsum core with either light commercial veneers, plastic laminate, or 2-ply wood veneers with laminated fire composite stiles and rails. Filling any fire rated requirements on any architectural or light commercial project.

Maximum Sizes	PP Cat-B	PP Cat-A
Single Swing	4/0 X 9/0	4/0 X 9/0
2 Point Reg. Pair	8/0 X 9/0	8/0 X 9/0
3 Point Reg. Pair	8/0 X 9/0	8/0 X 9/0
4 Point Reg. Pair	8/0 X 9/0	8/0 X 9/0
2 & 4 Point Reg. CVR Pair	8/0 X 9/0	8/0 X 9/0
2 Point DE Pair	8/0 X 8/0	8/0 X 8/0
4 Point DE Pair	8/0 X 8/0	8/0 X 8/0
2 & 4 Point DE CVR Pair	8/0 X 8/0	8/0 X 8/0
Door & Transom Single	4/0 X 9/0	4/0 X 9/0
Transom Panel	4/0 X 3/4	4/0 X 3/4
Dutch Door Single	N/A	N/A
Dutch Door Pair	N/A	N/A

Flush Mineral Core 45-60-90

- **Specifications**: 3 & 5 Ply construction. Meets or exceeds industry standards of WDMA I.S.1-A, WI Section 12, AWI Section 1300. Testing Standards ASTM-E-152, CSFM 43.7 CAN4-S104, NFPA-252, UBC-7-2-97, UL10C
- **Lay Up Method**: Bond and Sand
- **Maximum Sizes**: Width - 4/0
  Length - Depends on faces (See faces below for available length)
- **Thickness**: 1-3/4" Only
- **Stiles**: Laminated Composite to wood (Georgia Pacific), Specific to rating*
  Edge banding veneer or plastic when matching edges required
- **Rails**: Laminated Composite to wood (Georgia Pacific), Specific to rating*
  Width = 1" Minimum
- **Core**: Gypsum Mineral
- **Fire Rating**: 45-60-90 Minute Rated*
- **Faces Light Commercial**: RN Birch 2 Ply, MDF Back, 1/64" Face Veneer, 8/0 Max length.
  PS Red Oak 2 Ply, MDF Back, 1/64" Face Veneer, 8/0 Max length.
  Raw MDF Single Ply, 10/0 Max length
  Primed MDF Single Ply, 10/0 Max length
  Embossed Primed MDF Single Ply, 8/0 Max length
  Embossed Prefinished MDF (Legacy) Single Ply, 8/0 Max length
- **Faces Architectural**: Primed MDO 2 Ply HDF Back, 10/0 Max length
  Select Species Raw & Prefinished 2 Ply, 1/42" Face, 10/0 Max length
  Plastic Laminate 2 Ply, 1/50" Face, 10/0 Max length. All laminates meet or exceed NEMA standards.
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: To Specification
- **Louvers**: To Specification
- **Temp Rise**: 30 Minutes 250 Degrees maximum.
- **Acoustical Rating**: 30 STC Operable - See www.doormerica for seal information
- **Warranty**: Lifetime. See limited warranty for details.
- **Description Abreviations**: MC-45B = Mineral Core 45 Minute, Category B
  MC-45A = Mineral Core 45 Minute, Category A
  MC-60B = Mineral Core 60 Minute, Category B
  MC-60A = Mineral Core 60 Minute, Category A
  MC-90B = Mineral Core 90 Minute, Category B
  MC-90A = Mineral Core 90 Minute, Category A
- **Recommended Use**: Architectural, Light Commercial

**See fire door specifications section in catalogue for details on sizes, hardware and construction limitations.*

Flush Doors

Wood Skin Technical Data

All Architectural wood skin species are manufactured under conformance to the following industry standards: WDMA I.S. 1-A, W.I.C. Section 12, A.W.I. 1300 "Premium" and "Custom" Grade. All Architectural wood skins are 2-ply construction with 1/42" face veneer. All stocking skins used are "Book Running Match A-Grade" faces.

DOORMERICA®
Products

Architectural Prefinished Hardwood Doors

- UV Technology cured system that provides the highest level of quality and durability.
- Eliminates the issues of a field finished door.
- Environmentally friendly with zero VOC emissions.
- LEED compliant with no added Urea Formaldehyde.
- Meets or exceeds AWI section 1500 and WDMA I.S. 1-A specifications.
- Nine standard colors available.
- Supplied with 5-mil peelcoat protective film.

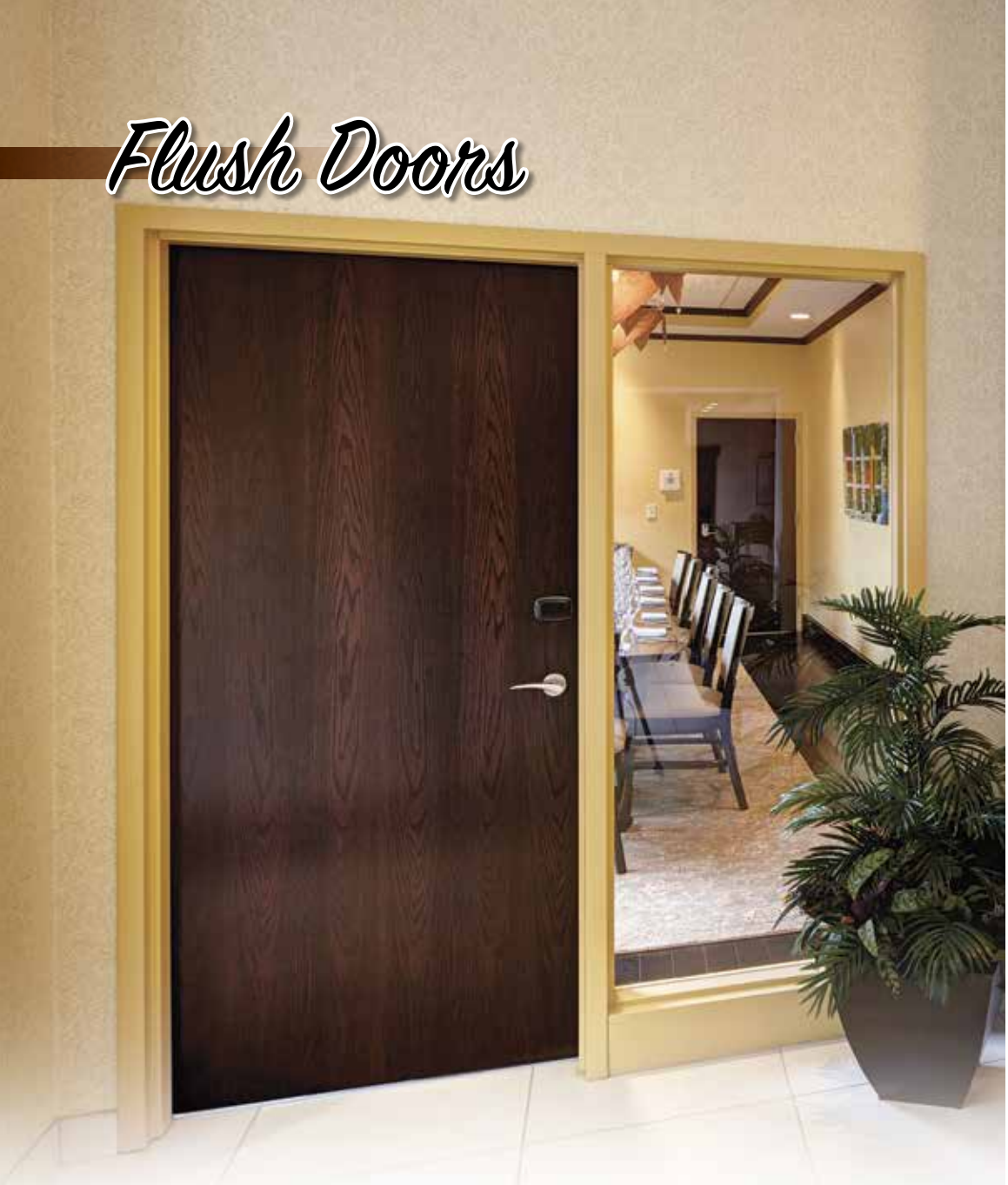
Flush Doors

Rotary White Birch	P/S Red Oak	P/S White Maple	P/S Cherry
Clear			
Nevada			
Arizona			
Oregon			
California			
Florida			
Virginia			
Georgia			
Alabama			

These photographic swatch samples are not intended to be used for final color selection; they are merely a display of colors available. Please contact Doormerica for an actual face veneer sample to determine your final color selection.

Custom colors are available. Minimums apply.

Flush Doors



HARDWOOD PREFINISH TECHNICAL DATA

The Ultra Violet (UV) coating system supplied by Doormerica is a full, complete UV cured system. This system is in direct compliance of A.W.I. Section 1500 "UV curable coating item A #5610". The performance number is 33, which compares to the very best of any coating systems. The coating process is as follows:

1. Sand
2. 1st coat = UV filler
3. Sand
4. 2nd coat = UV filler
5. Buff
6. 3rd coat = UV Epoxy Acrylic Topcoat
7. Buff
8. 4th coat = UV Epoxy Acrylic Topcoat

The total dry film is 1.2-1.6 mils dry.

PREFINISH TOUCH UP INFORMATION

- Sherwin Williams Product
- Water White Conversion Varnish, Satin Sheen #V84
- Ken Var Catalist #V66V21
- Scuff sand prior to application

ColledgeGuard Prestained Doors

ColledgeGuard Prestained door skins are made from industrial grade HDF board developed and finished in a variety of colors and grain variations. These fully finished doors offer a deeper and bolder grain branding process for a unique and superior upscale appearance. Built with traditional solid core construction components, *ColledgeGuard Prestained Doors* can be adapted to many popular applications.

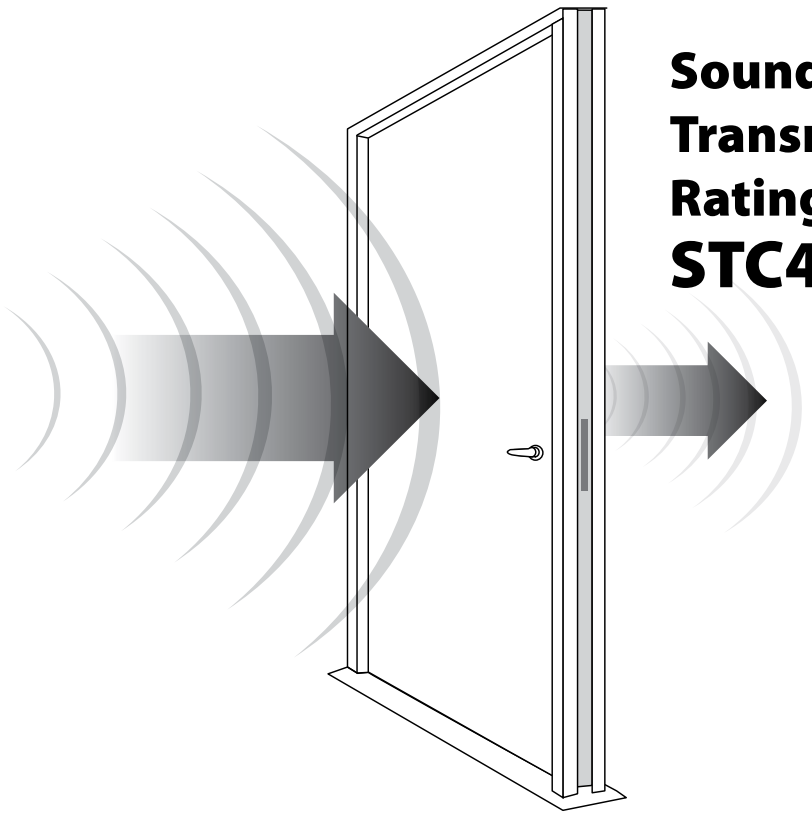
Perfect for light commercial applications where a prefinished surface is desirable. *ColledgeGuard Prestained Doors* have a color coordinated pre-painted wood edge and are available in a variety of fire ratings. Made from environmentally friendly materials that are CARB II compliant as well as recognized by FSC, SCS that can help with LEED credits for MR4 Recycled Content.

ColledgeGuard Prestained HDF Doors

Flush "Sound Retardant Doors"

- **Specifications**: 3 & 5 Ply construction. Meets or exceeds industry standards of WDMA I.S.1-A, WI Section 12, AWI Section 1300 Custom Grade(A Grade faces), AWI Section 1300 Premium Grade (AA Grade Faces).
- **Lay Up Method**: Bond and Sand
- **Maximum Sizes**: Width - 4/0; Length - 8/0
- **Thickness**: 1-3/4" ONLY
- **Stiles**: Paint Grade = FJ Hardwood, Raw Stain Grade = Matching Hardwood, Prefinished = SCL with matching edge banding over P-lam = SCL with matching edge banding over Width = 1-3/8" Minimum.
- **Rails**: 1-3/4" Thickness = Wood, SCL 1-1/8" Minimum
- **Core**: STC 42: RIGICOREGP, STC 45: RIGICOREEX
- **Fire Rating**: N/A
- **Faces**: Primed MDO 2 Ply HDF Back, Select Species Raw & Prefinished 2 Ply, 1/42" Face, Plastic Laminate 2 Ply, 1/50" Face, . All laminates meet or exceed NEMA standards.
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: STC 39 Max Lite kit 22x36 - See www.doormerica.com for kit and glass details
- **Louvers**: N/A
- **Acoustical Rating**: 43 STC Operable - nonrated and 20 Min Fire
  45 STC Operable - nonrated, 20 Min Fire, and 45 Min Fire
- **Warranty**: Lifetime. See limited warranty for details.
- **STC Opening Components**: See www.doormerica.com for seal information
- **Recommended Use**: Architectural, Institutional

**See fire door specifications section in catalogue for details on sizes, hardware and construction limitations.*



Sound Transmission Ratings up to STC45

Sound Transmission Class (STC Ratings)

Sound transmission is the movement of sound through a medium. Preventing the transfer of sound through door openings involves both specialized door construction as well as controlling gaps and tolerances around a door. These require special products and techniques. The higher the STC value the better the performance.

Flush Doors

HOLLOW CORE CONSTRUCTION

Flush Hollow Core

- **Specifications**: 3 & 5 Ply construction. Meets or exceeds industry standards of WDMA I.S.1.
- **Lay Up Method**: Loose
- **Maximum Sizes**: Width - 4/0. Length depends on face (See faces below for available length)
- **Thickness**: 1-3/8" and 1-3/4" ONLY
- **Stiles**: MDF available on MDF type skins, Only 1-3/8" Thickness & 6/8 Length; Softwood available on all skin types 1-3/8" and 1-3/4" Thickness; Width = 1" Nominal, 13/16" Minimum after prefit size.
- **Rails**: 1-3/8" Thickness = MDF, 1-5/8" Nominal, 1" Minimum after undercut
  1-3/4" Thickness = MDF, 2-1/4" Nominal, 1" Minimum after undercut
- **Core**: Cellular Honeycomb with 5" Hexagonal cells.
- **Lock Blocks**: Double 3" x 20" Particleboard (28lb) as standard.
- **Faces**: Lauan (Okoume) - Raw, 8/0 Maximum; RN Birch - Raw, 2 ply, 1/64" Face veneer thickness, 8/0 Maximum; PS Red Oak - Raw, 2 ply, 1/64" face veneer thickness, 8/0 Maximum; MDF - Primed and Raw, Single Ply, 10/0 Maximum; Embossed MDF - Primed and Prefinished, Single Ply, 8/0 Maximum.
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: To specification. Blocking only upon request.
- **Louvers**: To specification. Blocking only upon request.
- **Acoustical Rating**: N/A
- **Warranty**: Standard two year. See limited warranty for details.
  No warranty for Telegraphing
- **Description Abbreviations**: (FP-1-3/8) = 1-3/8" Thick, MDF Stiles; (FJ-1-3/8) = 1-3/8" Thick, FJ Softwood Stiles; (SWE-1-3/8) = 1-3/8" Thick, Clear Softwood Stiles; (FJ-1-3/4) = 1-3/4" Thick, FJ Softwood Stiles; (SWE-1-3/4) = 1-3/4" Thick, Clear Softwood Stiles
- **Recommended Use**: Residential and Light Commercial

LITES

Wood Lite Beading Non-Rated

Use	For use with non-rated 1-3/4" thick doors only. For more details see catalog. W-7 Lip Molding and W-9 Flush Molding.
Species Available	Birch, Cherry, Mahogany, Maple, Red Oak, Walnut and White Oak. For more details see catalog.
Sizes	Various sizes available in full-inch increments up to maximum area/ size listed below. For more details see catalog.
Listed	N/A
Glass Size	Glass should be cut 1/16" less in length and width than wood beaded lite size ordered . For more details see catalog.
Maximum Visible Glass Size	1238 sq. inches. For more details see catalog.
Parts List	(1) one instruction sheet. (8) eight prefit wood beads with nails prefitted into the opening. (1) one piece of 1/4" glass. Note: Glass should be cut 1/16" less in length and width than the lite opening size and measure 1/4" in thickness. For more details see catalog.

DOORMERICA®
Products

Molded Panel Doors

Molded Panel Doors

HOLLOW CORE CONSTRUCTION

Molded Panel Hollow Core

- **Specifications**: 3 Ply construction. Meets or exceeds industry standards of WDMA I.S.1.
- **Lay Up Method**: Loose
- **Maximum Sizes**: Width - 3/0; Length - 8/0 *Certain styles only*
- **Thickness**: 1-3/8" and 1-3/4" ONLY
- **Stiles**: MDF on only 1-3/8" Thickness & 6/8 Length; FJ Softwood option on 1-3/8" and 1-3/4" Thickness, to 8/0 length; Width = 1" Nominal, 13/16" Minimum after prefit size.
- **Rails**: 1-3/8" Thickness = MDF, 1-5/8" Nominal, 1" Minimum after undercut
  1-3/4" Thickness = MDF, 2-1/4" Nominal, 1" Minimum after undercut
  2" Nominal Bottom rail available on 1-3/8 Thickness (DBR)
- **Core**: Cellular Honeycomb build up pads.
- **Lock Blocks**: Double 3" x 10" Particleboard (28lb) as standard.
- **Faces**: Primed MDF Molded Panel, Single ply
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: N/A
- **Louvers**: N/A
- **Acoustical Rating**: N/A
- **Warranty**: Standard two year. See limited warranty for details.
  No warranty for Telegraphing
- **Description Abbreviations**: (FP-1-3/8) = 1-3/8" Thick, MDF Stiles; (FJ-1-3/8) = 1-3/8" Thick, FJ Softwood Stiles; (FJ-1-3/4) = 1-3/4" Thick, FJ Softwood Stiles
- **Recommended Use**: Residential and Light Commercial

**See molded skin selection guide for all panel elevation designs.*

PARTICLEBOARD CORE CONSTRUCTION

Molded Panel "Economy" Particleboard Core

- **Specifications**: 3 Ply construction. Meets or exceeds industry standards of WDMA I.S.1.
- **Lay Up Method**: Loose
- **Maximum Sizes**: Width - 3/0
  Length - 8/0 *Certain styles only*
- **Thickness**: 1-3/8" and 1-3/4" ONLY
- **Stiles**: FJ Softwood; Width = 1" Nominal, 13/16" Minimum after prefit size.
- **Rails**: 1-3/8" Thickness = MDF, 1-5/8" Nominal, 1" Minimum after undercut
  1-3/4" Thickness = MDF, 2-1/4" Nominal, 1" Minimum after undercut
- **Core**: 28-30lb Particleboard, ANSI A208.1 Grade LD-1, Profiled
- **Fire Rating**: 1-3/4" Thickness 20 Minute Rated**
- **Faces**: Primed MDF Molded Panel, Single ply
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: N/A
- **Louvers**: N/A
- **Acoustical Rating**: 33 STC Inoperable
- **Warranty**: Standard two year. See limited warranty for details.
- **Description Abbreviations**: E-1-3/8 = 1-3/8" Thick PBC Molded Panel
  E-20NL = 1-3/4" Thick PBC Molded Panel (Non-rated)
  E-20B = 1-3/4" Thick PBC Molded Panel, 20 Minute Category B
  E-20A = 1-3/4" Thick PBC Molded Panel, 20 Minute Category A
- **Recommended Use**: Residential and Light Commercial

** See molded skin selection guide for all panel elevation designs.*
***See fire door specifications section in catalogue for details on sizes, hardware and construction limitations.*

Molded Panel Doors

MINERAL CORE CONSTRUCTION

Molded Panel Mineral Core

- **Specifications**: 3 Ply construction. Meets or exceeds industry standards of WDMA I.S.1 Testing Standards ASTM-E-152, CSFM 43.7, CAN4-S104, NFPA-252, UBC-7-2-97, UL10C
- **Lay Up Method**: Bond and Sand
- **Maximum Sizes**: Width - 3/0
  Length - 7/0
- **Thickness**: 1-3/4" ONLY
- **Stiles**: Laminated Composite to wood (Georgia Pacific), Specific to rating*
- **Rails**: Laminated Composite to wood (Georgia Pacific), Specific to rating*
  Width = 1" Minimum
- **Core**: Gypsum Mineral
- **Fire Rating**: 45-60 Minute Rated*
- **Faces**: Primed Molded Panel Single Ply
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: To Specification
- **Lites**: N/A
- **Louvers**: N/A
- **Temp Rise**: 30 Minutes 250 Degrees maximum.
- **Acoustical Rating**: 29 STC Operable See www.doormerica.com for seal information
- **Warranty**: Standard Two year. See limited warranty for details.
- **Description Abbreviations**: MC-45B = Mineral Core 45 Minute, Category B
  MC-45A = Mineral Core 45 Minute, Category A
  MC-60B = Mineral Core 60 Minute, Category B
  MC-60A = Mineral Core 60 Minute, Category A
- **Recommended Use**: Light Commercial

**See fire door specifications section in catalogue for details on sizes, hardware and construction limitations.*

Maximum Sizes	PP Cat-B	PP Cat-A
Single Swing	3/0 X 7/0	3/0 X 7/0
3 Point Reg. Pair	6/0 X 7/0	6/0 X 7/0
4 Point Reg. Pair	6/0 X 7/0	6/0 X 7/0

Molded Panel Designs

SMOOTH SURFACE PANEL DESIGNS

Ovolo Sticking Profile

Cove & Bead Sticking Profile

Patented INP Sticking

**Consult factory for design availability.*

PRIN-22 • Princeton Smooth Cove & Bead Sticking

CBG-22 • Cambridge Smooth Ovolo Sticking

CON-22 • Continental Smooth Ovolo Sticking

ROCK-55 • Rockport Smooth Modified Cove & Bead Sticking

SF-22 • SanteFe Smooth Ovolo Sticking

COLSM-66 • Colonist Smooth Patented INP Sticking

Molded Panel Doors

SMOOTH SURFACE PANEL DESIGNS

CAIMAN-22 • Caiman Smooth
Patented INP Sticking

CARR-22 • Carrara Smooth
Patented INP Sticking

CONV-44 • Coventry Smooth
Patented INP Sticking

Patented INP Sticking

TEXTURED SURFACE PANEL DESIGN

AV-33 • Avalon Textured
Cove & Bead Sticking

COLON-66 • Colonist Textured
Cove & Bead Sticking

CAM-22 • Camden Textured
Cove & Bead Sticking

Cove & Bead Sticking Profile

**Consult factory for design availability.*

Bifolding Doors

Bifolding Doors

- **Specifications**: Bifolding doors are available in the following door types. Hollow Core Flush, Hollow Core Molded Panel, Molded Panel Economy Particleboard Core, Flush Economy Particleboard Core, Flush Standard Particleboard Core
- **Maximum Sizes**: See Specific Door Type.
- **Thickness**: See Specific Door Type.
- **Stiles**: See Specific Door Type.
- **Rails**: 1-5/8"Wood on 1-3/8"Thickness; 2-1/4"Wood on 1-3/4"Thickness.
- **Core**: See Specific Door Type.
- **Lock Blocks**: See Specific Door Type.
- **Faces**: See Specific Door Type.
- **Adhesive**: Type-1 PVA, Interior installation only.
- **Machining**: N/A
- **Lites**: N/A
- **Louvers**: N/A
- **Acoustical Rating**: N/A
- **Warranty**: Standard two year. See limited warranty for details. (See Specific Door Type)
- **Description Abbreviations**: See Specific Door Type.
- **Recommended Use**: Residential and Light Commercial
- **Standard Duty Hardware**: Hinges - Edge Mount window hinge; Standard Duty Track & Hardware.
- **Heavy Duty Hardware**: Hinges - Full mortise 3.5" radius corner; Heavy Duty Track & Hardware.

DOORMERICA® Products

Natural, Sustainable, Responsible.

One pillar of a sustainable strategy is the selection of proper building materials.

Sustainable materials such as MDF (medium density fiberboard) are a good environmental choice. The base material of all Doormerica products is MDF, made from the byproducts of the lumber industry.

We applaud projects designed for sustainability and welcome a chance to contribute. Please send your project specifics and available credits to Doormerica group at www.doormerica.com or call (888) 454-2888.

The LEED (Leadership in Energy and Environmental Design) Green Building Rating System was originally developed by the U.S. Green Building Council (USGBC) to provide a recognized standard for the construction industry to assess the environmental sustainability of building designs.

Doormerica is committed to engineering our manufacturing processes so that we may assist our customers in achieving their LEED certification rating.

Doormerica is focused on being a good global partner in environmental stewardship. All Doormerica products are certified by a nationally recognized third party certification service. Please contact us or visit www.doormerica.com for further information.

LIMITED WARRANTY

This warranty applies only to the ABS Manufacturing doors described. Should any doors manufactured by ABS Manufacturing fail to conform to this written warranty, ABS Manufacturing will, at our option, either

1. Replace the doors to the distributor or the person making the warranty claim. The doors will only be replaced in the exact same manner in which the doors were originally sold.
2. Repair the doors.
3. Refund the original purchase price paid to ABS Manufacturing for the doors. In no claim situation will ABS Manufacturing pay for ANY labor and materials for the finishing or installation of the replacement doors, or any other costs associated to the replacement of the doors.

See claims procedure form for exact details on any claim situation.

Warranty Periods:

Flush Hollow Core	2 Years
Molded Panel Hollow Core	2 Years
Bifold Doors	2 Years
Flush Economy Particleboard Core	2 Years
Molded Economy Particleboard Core	2 Years
Flush Standard Particleboard Core	2 Years
Flush Heavy Duty Particleboard Core	Life
Flush Extra Heavy Duty SCL Core	Life
Flush Mineral Core	Life
Molded Mineral Core	2 Years

Tolerances:

1. Size Tolerance:
   a. Thickness + or - 1/16"
   b. Width + or - 1/16"
   c. Height + or - 1/16"
   d. Hardware preparation + or - 1/32"
2. Squareness Tolerance:
   a. Diagonal measurement will not exceed 1/8"
3. Telegraphing Tolerance:

Hollow Core	No Warranty
Economy	2/100th in 3" span
Standard	2/100th in 3" span
Heavy Duty	1/100th in 3" span
Extra Heavy Duty	1/100th in 3" span
Mineral Core	1/100th in 3" span

4. Warp Tolerance:
   Warp will be measured with a straight edge along the concaved face of the door. If the measurement is 1/4" or less the door will not be considered as defective. Top doors in stacks will have a tendency to pull upward due to some moisture loss. This is a very common occurrence especially in hot dry climates. To correct this warpage re-stack the doors in the opposite direction and the doors will straighten out. Any door warped due to improper storage or handling will not be warranted.

Storage & Handling: (WDMA I.S.1-A)

1. Store doors flat on a level surface in a dry, well ventilated building. Doors should be kept at least 3-1/2" off the floor and should have protective coverings under the bottom door and over the top. Covering should protect doors from dirt, water and abuse but allow air circulation under and around the stack. Avoid exposure to any sunlight or artificial light.
2. Certain species (e.g., Cherry, Mahogany, Walnut, Teak) are more susceptible to discoloration if exposed to either sunlight or some forms of artificial light. To protect doors from light damage after delivery, opaque plastic wrapping is recommended.
3. Do not subject interior doors to extremes of heat and or humidity. Prolonged exposure may cause damage. Buildings where humidity and temperature are controlled provide the best storage facilities. (Recommended conditions 30% - 50% RH and 50 to 90 degrees F.)
4. Do not install doors in buildings that have wet plaster or cement. Do not store doors in buildings with excessive moisture content. HVAC should be in operation and balanced.
5. Doors should always be handled with clean hands or while wearing clean gloves.
6. Doors should be lifted and carried when being moved, not dragged across one another.

Finishing Instructions: (WDMA I.S.1-A)

1. Wood is a hygroscopic and dimensionally influenced by changes in moisture content caused by changes within its surrounding environment. To assure uniform moisture exposure and dimensional control all surfaces must be finished equally.
2. Doors may not be ready for finishing when initially received. Before finishing, remove all handling marks, raised grain, scuffs, burnishes and other un-desirable blemishes by block sanding all surfaces in a horizontal position with sandpaper. To avoid cross grain scratches, sand with the grain.
3. Certain species of wood, particularly oak, contain chemicals which react unfavorably with foreign materials in the finishing system. Eliminate the use of steel wool on bare wood, rusty containers or any other contaminate in the finishing system.
4. A thin coat of sanding sealer must be applied prior to sanding to promote a uniform appearance and avoid sharp contrasts in color or a blotchy appearance.
5. All exposed surfaces must be sealed including top and bottom rails. Cut outs for hardware in doors must be sealed prior to installation of hardware.
6. Dark colored finishes should be avoided on all surfaces if the door is exposed to direct sunlight, in order to reduce the chance of warping or veneer checking.
7. Oil based sealers or prime coats provide the best base coat for finishing. If a water-based primer is used it should be an exterior grade product. Note: Water based coatings on un-finished wood may cause veneer splits, highlight joints and raise wood grain. If a water based primer is desired, please contact the finishing supplier regarding the correct application and use of these products.
8. Be sure that the door surface being finished is satisfactory in both smoothness and color after each coat. Allow adequate drying time between coats. Desired results are best achieved by following the finish manufacturer's recommendations. Do not finish the doors until a sample of the finish has been approved in writing.
9. On factory primed hardboard faced doors and molded faced doors a water-based all acrylic latex finish is most compatible with the primers used and is recommended. Always obtain and follow paint manufactures recommendations. Never attempt to paint hardboard or molded faced doors in moist cold conditions for water-based paints will not dry quick enough and penetrate into the door skins and cause lineal expansion or other irregularity.

Installation: (WDMA I.S.1-A)

1. The utility or structural strength of the doors must not be impaired in fitting to the opening, in applying hardware, in preparing for lites, louvers, plant-ons or other detailing.
2. Use two hinges for solid core doors up to 60" in height, three hinges for doors up to 90" in height and an additional hinge for every additional 30" of door height or portion thereof. Interior hollow core doors weighing less than 50 pounds and not over 7/6 in height may be hung on two hinges. Use heavy weight hinges on doors over 175 pounds. All molded panel doors are recommended to have three hinges to 7/0 in height.]
3. Clearances between door edges and door frame should be a minimum of 1/16" on hinge edge. For latch edge and top rail the clearance should be 1/8".
4. All hardware locations, preparations for hardware and methods of hardware attachment must be appropriate for the specific door construction. Templates for specific hardware preparation are available from hardware manufacturers or their distributors.
5. When lite or louver cutouts are made for exterior doors they must be protected in order to prevent water from entering the door core. Metal flashing on cut outs is recommended.

6. Pilot holes must be drilled for all screws that act as hardware attachments. Threaded to the head screws, are preferable for fastening hardware to non rated doors and are required on fire rated doors.
7. In fitting for height, do not trim top or bottom edge by more than 3/4" unless accommodated by additional blocking. Do not trim top edge of fire doors.
8. Doors and door frames must be installed plumb, square and level.
9. For installation of any rated fire door see "Fire Door Installation Requirements."

Cleaning and Touch-up: (WDMA I.S.1-A)

1. Inspect all doors prior to hanging them on the job. Repair noticeable marks or defects that may have occurred from improper storage and handling.
2. Field touchup shall include the filling of exposed nail or screw holes, re-finishing raw surfaces resulting from job fitting, repair of job inflicted scratches and mars, and final cleaning of finished surfaces. Field repairs and touch ups are the responsibility of the installing contractor.
3. When cleaning door surfaces, use a non-abrasive commercial cleaner designed for cleaning wood door or paneling surfaces, that do not leave a film residue that would build up or effect the surface gloss of the door finish.

Adjustment and Maintenance: (WDMA I.S.1-A)

1. Review with the owner/owners representative how to periodically inspect all doors for wear, damage and natural deterioration.
2. Review with the owner/owners representative how to periodically inspect and adjust all hardware to insure that it continues to function as it was originally intended.

Limitations and Exclusions: *This warranty will not cover any of the following*

1. Exterior doors.
2. Doors stained or painted with dark colors for warpage and telegraphing
3. The performance of surface mounted hardware, or doors ordered without adequate blocking for hardware.
4. The natural variations in color, texture or grain in wood faced doors.
5. Warpage when two different types of faces are used on each side of the door.
6. The appearance of a high sheen finish on painted, stained, or plastic laminate faced doors.
7. When any lite or louver cut out is closer than 5" inches to any edge of the door or hardware prep.
8. Warpage on doors greater than 8/0 in height or greater than 3/6 in width.
9. Doors which are over 7/0 in height, or wider than 3/0 hung with three or fewer hinges.
10. The appearance of field finished or painted doors. Once a door is finished this constitutes acceptance of the product.
11. If the door has been altered or machined in any way when a defect was present prior to machining.
12. Doors left un-finished at the job site and doors which are not sealed and painted on all six sides for more than 15 days.
13. Natural color variations in prefinished wood doors.
14. Workmanship that is not performed by ABS Manufacturing.
15. Telegraphing when internal blocking is used.
16. Unauthorized work performed on any door. Any repairs needed must be notified to ABS Manufacturing and a reasonable solution will be determined only by ABS Manufacturing.
17. Hollow core doors with hardwood faces for telegraph, cup, warp, or twisting.

This warranty represents the maximum liability for all doors manufactured by ABS Manufacturing. No other warranty, expressed or implied will serve the purpose of this warranty. No dealer has authority to modify this limited warranty in any way. In no situation shall ABS Manufacturing be held responsible for indirect damages.

All doors manufactured by ABS Manufacturing are warranted to be free from defects in materials and workmanship. Although our stringent quality control system and our utilization of modern packaging and shipping methods assure that virtually all doors arrive at their destination in perfect condition, occasionally a problem does occur. To comply with the terms of our sales agreement, and to assure the most expedient resolution of any problem, the following steps must be followed.

Transportation Related Damage:

ABS Manufacturing does not guarantee safe delivery of goods. Our responsibility ceases with issuance of the bill of lading showing delivery in good order to the transportation company. **All claims for shortages, loss, delay or damage from any cause must be filed by the consignee upon the transportation company.**

Notice Requirement:

Since ABS Manufacturing Can not control the handling or exposure of doors following receipt, a specific duty of inspection is imposed upon the purchaser as a condition precedent to any claim. Such inspection must be made upon receipt of goods. Should a manufacturing defect be discovered, a written notice of the claim must be received by ABS Manufacturing within 15 days of receipt of the goods or, in the event of a latent defect, from the date that such defect was, or should have been discovered. It will be the responsibility of ABS Manufacturing to determine the most efficient method to remedy such defect. Any repairs authorized or performed by any party, other than ABS Manufacturing are not covered by our sales agreement and are not the financial responsibility of ABS Manufacturing. **No claim will be honored unless the proper notification, as outlined above, has been received**.

Information Requirement:

The written claim notice must include:

1. Invoice number
2. Date of purchase
3. Purchase order number
4. All pertinent information on the original order
5. Detailed explanation of defect.

Inspection Requirement:

Doors that are pre-machined at our factory should be checked against the frame, in which they are to be installed, for correct hinge placement and lock location. All other hardware preparation should be checked with the physical hardware to assure that the machining is correct prior to any installation. Doors that are pre-finished should be checked against approved finish sample prior to any installation.
Installation of any pre-machined or pre-finished door shall constitute acceptance.

WARNING - Field Finished or Painted Doors:

All doors that are to be field finished or painted must be checked thoroughly. It is the responsibility of the finisher to prepare the doors by either hand sanding or power sanding each door to remove all handling marks. Sand paper grit and duration of preparation time depends on the finish that is required. If problems occur the finishing process must stop and ABS Manufacturing must be contacted.
Finishing or painting of any doors shall constitute acceptance. And at no time will finishing or painting expenses be the responsibility of ABS Manufacturing when a problem was present prior to.

DOORMERICA®
Products

American Series®

ARCHITECTURAL FLUSH AND MOLDED WOOD DOORS

DAS-318