



American Series

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 concave 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.

CLAIMS PROCEDURE

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.