

GOLD SERIES
7-Ply Architectural Flush Doors
MFD1-7
Mohawk 60-Minute Mineral Core B-Label
7-Ply Construction

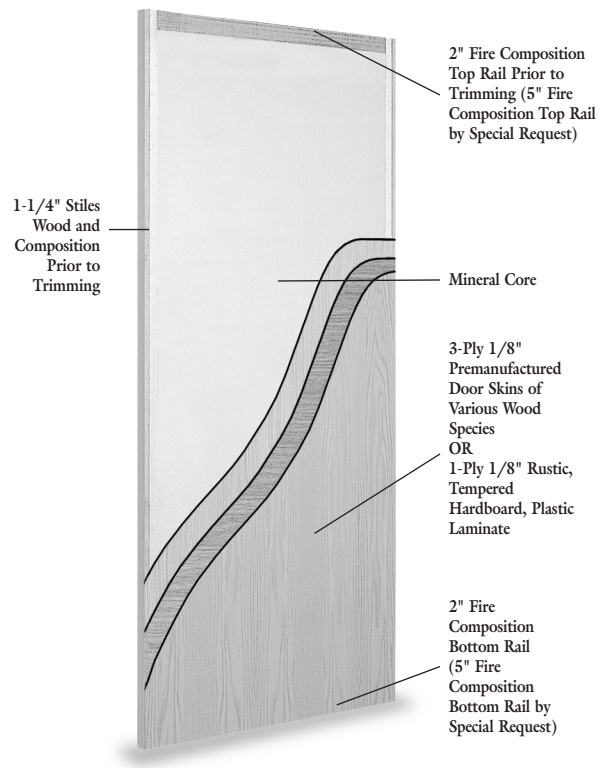
QUALITY ASSURANCES: All Mohawk 60-Minute Fire doors comply with UBC standard 7-2-97 Positive Pressure requirements, meet or exceed the latest edition of W.D.M.A. I.S. 1A-97 and AWI 1300 Quality Standards, and are labeled under Warnock Hersey International program.

APPLICATIONS: Used in commercial and architectural openings when a 60-minute label is required by building codes.

MAXIMUM SIZE:

SIZE	NEGATIVE PRESSURE	POSITIVE PRESSURE
SINGLE	4/0 X 10/0	4/0 X 9/0
PAIR (STANDARD)	8/0 X 10/0	8/0 X 8/0
PAIR (DOUBLE EGRESS)	8/0 X 10/0	8/0 X 8/0
DOOR/TRANSOM COMBINED	4/0 X 10/0	4/0 X 9/0
PROFILED CORE	3/6 x 7/0	3/6 x 7/0
PROFILED CORE (PAIRS)	7/0 x 7/0	7/0 x 7/0
DUTCH DOOR	4/0 x 8/0	No
FULL LITE	See Maximum Size Openings	See Maximum Size Openings

*Please contact our customer service department for the latest revisions on Positive Pressure requirements.



Our doors can be manufactured to comply with UBC Standard 7-2-97 Positive Pressure requirements. If Positive Pressure is required, an outline of each category is listed below.

CATEGORY A Intumescent concealed in stiles and top rail of door with Firestop II stiles and Firestop I rails, installed in an 18-gauge frame: (Single) 4/0 x 8/0; (Paired and Double Egress) 8/0 x 8/0.

CATEGORY B Intumescent installed on frame only. Intumescent not allowed to be installed on both door and frame. (Single) 4/0 x 8/0; (Paired) 8/0 x 8/0; Paired applications must have concealed intumescent at the meeting edges. Sizes through 8/0 x 8/0. No intumescent required in door for single swing applications, but must have 18-gauge frame and approved Category G gasket system.

S-SMOKE LABEL AVAILABLE WITH AN APPROVED CATEGORY H GASKET SYSTEM.

THICKNESS: 1-3/4".

CONSTRUCTION: Typical 7-ply face architectural-grade construction. Face construction utilizes state-of-the-art PVA technology.

FACES: 3-ply wood veneers in Premium (A and AA), Good (B), book or slip matched for balanced, center, and running assemblies. Door skins are 1/8" and face veneers are minimum 1/50" thick. 3-ply veneer premanufactured door skins are hot-pressed.

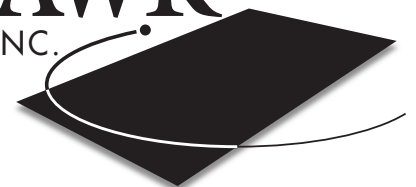
GRADES:

Custom—standard.

Premium—available by special request, extended lead times for AA faces.

Stock species for immediate manufacturing: Rotary Natural Birch, Rotary Select White Birch, Plain Sliced Red and White Oak, Plain Sliced Natural Maple, Plain Sliced Select White Maple, Plain Sliced American Black Cherry, Quarter Sliced African Mahogany, Plain Sliced Honduras Mahogany, and Medium Density Overlay. **Special order species extended lead-time:** Rotary Select Red Birch, Plain Sliced Walnut, Plain Sliced American Beech, Plain Sliced Natural Ash, Plain Sliced Red and White Birch, Rotary Maple, Bird's Eye Maple, Rotary Oak, Plain Sliced Poplar, Plain Sliced Sapele, Rotary White Oak, and Santos (Rosewood). Other species available by special request.

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7-Ply Specifications

1-PLY PLASTIC LAMINATE: Faces from Formica, Nevamar, and Wilson-Art. Pionite available by special request (lead-time and price will vary).

1-PLY TEMPERED HARDBOARD: Modulus of rupture 8500 PSI. Meets or exceeds ANSI/AHA-135.4 1982 Standards.

1-PLY RUSTIC: Modulus of rupture 5700 PSI. Meets or exceeds ANSI/AHA-135.4 1982 Standards.

CORE: Noncombustible non-asbestos mineral core engineered to meet label requirements. Stiles and rails bonded to core using a hot-melt glue process and then sanded to ensure even thickness and minimal telegraphing of core and stile parts through veneers.

STILES: Douglas Fir or denser species standard. Hardwood or matching veneer by special request. 2-ply stile construction 9/16" untreated wood edge strip bonded to a 1" inner banding of gypsum and wood fibers. Minimum wood thickness after trimming is 3/16". Results of test data: Screw-holding capacity TM-10, 1130.4 load lbs. at failure, Split Resistance, TM-5, 847.9 load lbs. at failure, Cleavage ASTM D143-83, 931.5 load lbs. at failure, slam test 350,000 cycles no failure. Matching edge-banded veneer by special request. (Field trimming is not permitted.) All dimensions prior to factory trimming and prefitting.

RAILS: Top and Bottom rails are 2" composition material. All components bonded to core. 5" Fire Composition top and/or bottom rail by special request. All dimensions prior to factory trimming and prefitting.

OPTIONAL LOCKBLOCKS: 5" x 18" Fire Composition lockblocks by special request.

ADHESIVE: Polyvinyl Acetate (PVA) Type II is standard. Type II is a water-resistant interior glue which must withstand the bond test described in W.D.M.A. I.S. 1A-97 T.M.6 specifications. Polyvinyl Acetate Type I by special request. Type I adhesive is a waterproof glue and must withstand the bond test described in W.D.M.A. I.S. 1A-97 T.M.6 specifications.

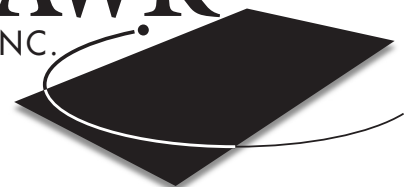
FACTORY PREFINISH: Our Premium 2000 Prefinish is a 12-step operation performed on a 540-ft. prefinish line, which is one of the most sophisticated and advanced prefinishing systems in use throughout the industry. The finish is totally environmentally safe using a combination of water-borne acrylics, ultraviolet sealers, and topcoats, all of which are formaldehyde-free. This line addresses all of the negative properties of water-borne finishes. The prefinish process is applied to all 6 sides of the door, sealing it completely. These doors are prefinished in an in-plant environment by skilled personnel, eliminating all of the field finishing problems. We offer 8 standard polyurethane stain finishes: (TR-6) Clear, Teak, Red, Brown, Dark Brown, Mahogany, Gray, and Walnut. We have 2 standard polyurethane paint finishes: (OP-6) White 2071 and L4000. If our wide color range of standard finishes does not meet your requirements, we will custom color-match your choice of stain or paint.

RUSTIC: An embossed tempered hardboard face with a modulus of Rupture of 5700 PSI. Meets or exceeds ANSI/AHA – 135.4 1982 Standards. Prefinished on our 540-ft. prefinish line with a 9-step application to capture the rich inherent beauty of Walnut and Oak veneers. Available in 8 decorator tones: Lite Oak, Oak, Golden Oak, White, Walnut, Classic Gray, Classic Mahogany, and Classic Autumn Oak. Rustic gives you a durable problem-free prefinished door at substantial savings compared to wood-veneered doors.

PRIMING: White standard color. Custom colors by special request. 3 coats of water-based acrylic materials are applied to faces. An equal application of priming material is applied to stiles. Top and bottom rails are clear-coated. Priming is not a sealer. Doors must receive paint manufacturer's recommended sealer coats applied equally to all 6 sides of doors.

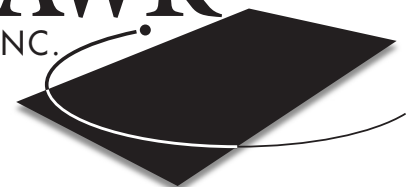
MAXIMUM SIZE OPENINGS: Negative and Positive Pressure 10" x 33". Special Light approvals for Positive Pressure is Pilkington 1/4" wire glass, maximum individual light size is 960 square inches; multiple light size is 1920 square inches. For Negative Pressure, clear glass is available—contact our customer service department for these options. Light cut-outs shall be no closer than 5-1/2" from the edge of door or hardware cut-out. Light must be glazed with a minimum of 1/4"-thick listed wire glass and installed in a listed light frame, per NFPA 80. All measurements are from edge of cut-out.

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MACHINING: All fire door assemblies must be prepared in accordance with the NFPA 80 Par. 1-9.5 which states that all machining must be done under a labeling service except machining for surface-applied hardware with cut-outs less than 1" in diameter, function holes for mortise locks, holes for labeled viewers. All hardware and applications must be listed and approved. Field fitting is not permitted.

MACHINING	NEGATIVE PRESSURE	POSITIVE PRESSURE
HINGES		
Leaf	Yes	Yes
Continuous	Yes	Yes
Pivot	Yes	No
Spring	Yes	Yes
LATCHING OPTIONS		
Single Swings	1 or 2 Point	1 or 2 Point
Pairs	2, 3, or 4 Point	2, 3, or 4 Point
Electric Strikes	Yes	Yes
LATCHSETS		
Mortise	Yes	Yes
Cylindrical	Yes	Yes
Card	Yes	Yes
Dead Bolts	Yes	Yes
FLUSHBOLTS		
Surface	Yes	Yes
Mortised	Yes	Yes
FIRE EXIT HARDWARE		
Rim	Yes	Yes
Mortise	Yes	Yes
Surface Vertical Rod	Yes	Yes
Concealed Vertical Rod	Yes	Yes
LESS BOTTOM ROD		
SVR	Yes w/Thermal Pin	Yes w/Thermal Pin
VR	Yes w/Thermal Pin	Yes w/Thermal Pin
CLOSERS		
Mortised	Limited	No
Surface	Yes	Yes
Power-Operated	Yes	Yes
EDGE GUARDS		
Flush	Limited	Limited
Mortised	Limited	Limited
VIEWERS		
	Yes	Yes
RACEWAY		
	Yes	Yes
POWER TRANSFERS		
	Yes	Yes



MISCELLANEOUS OPTIONS

OPTION	NEGATIVE PRESSURE	POSITIVE PRESSURE
Plant-On Molding	Yes	Yes
Face Grooves	Yes	Yes
Louvers	No	No
Kick Plates (Up to 48")	Yes	Yes

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APPLIED DECORATIVE DOOR MOLDING: The applied molding designer series takes the flush door to a new level of fine millwork at a fraction of the cost of stile and rail door products. We offer 7 standard molding profiles and 4 standard plant-on configurations. (Refer to our brochure for standard lay-out configurations.) Your design options do not stop here, as we will custom-design your choice of molding profiles and layouts. Our standard species is basswood; however, we will match face veneers by special request. Our standard sizes are **M1** – 5/8" x 3/8", **M2** – 1-1/8" x 9/16", **M3** – 1-3/8" x 5/8", **M4** – 1-3/4" x 3/4", **M5** – 1-3/8" x 5/8", **M6** – 1-1/2" x 3/8", and **M7** – 1-3/4" x 3/4". Maximum width is 2-1/2", maximum height is 1/2". Multiple pieces may be used provided the pieces are separated with a space between the pieces no less than the width of the individual piece. Applied with adhesive and/or mechanical fasteners with a maximum penetration into the door 1/2", spaced not more than 2" on center. Must be a minimum of 4" from edge of door or light. Maximum area of molding not to exceed 22% of area of door, i.e., 3/0 x 7/0 door area = 36 x 84 = 3024 square inches. 22% = 665.3 square inches for 1-1/2" wide molding. Maximum usage 665.3 divided by 1.5 = 443.5 inches = 37 feet of molding. All applied molding must be factory-applied or applied by a licensed WH1 or UL Shop.

DUTCH: Maximum size 4/0 x 8/0. Single swing only; Negative Pressure doors only. Shelves may be applied to one or both sides. Dutch doors shall be provided with one of the following: an overlapping astragal applied to bottom edge of top leaf; a rabbetted bottom rail of top leaf and top rail of bottom leaf; or intumescent installed in bottom of top leaf. Machining for hinges per NFPA80. Cylindrical latch sets—one (maximum 2-1/8" bore) per leaf to provide latching top and bottom leaves or between either top and bottom leaf into frame.

TRANSOMS: Maximum width of transom 48", maximum height of transom 40". Single swing locations only. End matched or continuous matched transoms. Maximum size of door and transom combined is 4/0 x 10/0. Transom panels may be used with or without a transom bar for Neutral Pressure assemblies. When Positive Pressure is required, transom bars must be used. Maximum door and transom combined is 4/0 x 9/0. Transom assembly without a transom bar: top rail of door and bottom rail of transom panel must have one-piece G.P. Firestop interior blocking with a minimum of 5" x 1-1/2" thickness. Other construction of transom can be similar to that of 60-minute fire-rated door. Other construction of 60-minute fire-rated door remains unchanged. Panel shall be machined for spring bolts. Standard rabbet size is 1/2" x 7/8". Assembly described above may be used without rabbetted joint by having wrap-around metal edges at bottom rail of transom and top rail of door, along with an astragal. With transom bar: transom panel construction must be the same as that of 60-minute fire-rated door except that bottom rail of transom should be only as wide as top rail of door. Transoms constructed for use with a transom bar cannot be used with wrap-around metal edges and astragal replacing transom bar. Manufacturer of transom panel shall machine for steel spring bolts and they shall be shipped with transom panel. Only Stanley #1697 or Lawrence #142 or equivalent spring bolts shall be used.

SAMPLE TRANSOM PANEL INSTALLATION INSTRUCTIONS: Transom panel **MUST** be used in a rated frame. Transom panel must be attached to frame with steel spring bolts. Steel spring bolts must be installed on stile edges of transom panel no more than 6" from each corner with the following number used per edge:

Up to 18" in height2 spring bolts

Up to 36" in height3 spring bolts

Holes shall be drilled into frame to accept each spring bolt. Maximum clearances between transom panel and frame shall not exceed 1/8". Approved type steel spring bolts shall be Stanley #1697, Lawrence #142 or equivalent. Any other method of attachment must have prior written approval from Warnock Hersey International, Inc. See illustration on page OP 3.

MOPAK: Mopak is a tough, transparent polyethylene film protecting the door from scratches, dust, and handling marks, standard on all prefinished doors. Available by special request on unfinished doors.

LIMITED WARRANTY: Five year standard. Lifetime Warranty available by special request.

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