

**GOLD SERIES**

**7-Ply Architectural Flush Doors**  
**MFD1/3PC-7**  
**Mohawk 20-Minute Particle Core Fire Door**  
**Edge-Bonded Construction**  
**7-Ply Construction**

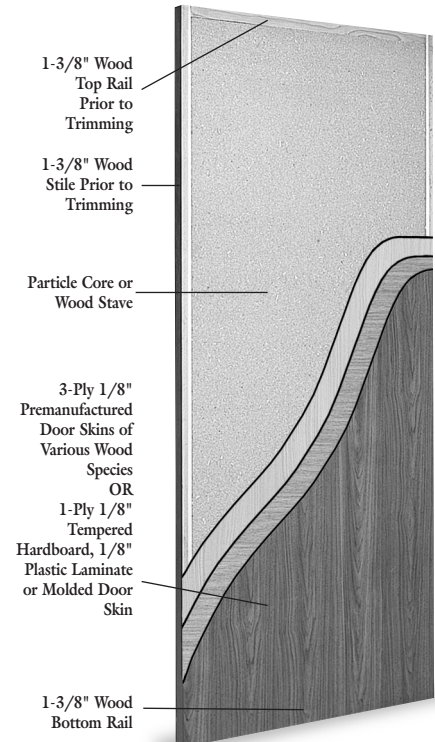
**QUALITY ASSURANCES:** All Particle Core 1/3-hour doors meet or exceed the latest edition of W.D.M.A. I.S. 1A-97 and AWI 1300 Quality Standards and are labeled under Warnock Hersey International program.

**APPLICATIONS:** Used in architectural openings where a 20-minute label is required by building codes. This door meets AWI 1300 PC7 specifications.

**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
DUTCH DOOR	4/0 X 8/0	No
FULL LITE	Yes	Yes

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



Our doors are manufactured to comply with Negative Pressure standards or with UBC Standard 7-2-97 Positive Pressure requirements with the following categories:

**CATEGORY A** Firestop II Stiles, Firestop I Top Rail only—No intumescent required.

**CATEGORY B** Intumescent installed on frame only. Intumescent not allowed to be installed on door and frame. Standard door construction—No intumescent or Firestop stiles or rails required in door. Must have approved Category G gasketing system.

**THICKNESS:** 1-3/4".

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

**CONSTRUCTION:** Typical 7-ply face 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.

**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.



## 7-Ply Specifications

**CORE:** Stiles and rails are securely 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 veneer. Particle core meets or exceeds ANSI.A-208-1-1989 for grade 1-LD-1. Face screw pull 90 lbs. Resists warping—superior dimensional stability. Provides full support for cut-outs at light and louver openings, excellent bonding capabilities. 1-LD-2 core is available by special request (lead time and price will vary).

### STILE & RAIL OPTIONS

EDGES	NEGATIVE PRESSURE	POSITIVE PRESSURE CATEGORIES	
		A	B
<b>STILES</b>	15/16" minimum wood stile standard. 5" stiles available for specific hardware applications.  Metal edges and astragals may be required on standard pairs predicated on door sizes and applications. Doors, where permitted, may be built with treated maple stiles on lock side in lieu of astragals.	Georgia-Pacific Firestop composition with an outer band 1/4" wood. Total stile dimension 1" prior to trimming.  1-1/4" minimum wood stile	standard. 5" stiles available for specific hardware applications prior to trimming.  Must have an approved Category G intumescent kerfed into frame or surface supplied  1-1/8" Minimum Georgia-Pacific  Firestop composition required on all pairs, with intumescent installed on meeting door edges.
EDGES	NEGATIVE PRESSURE	POSITIVE PRESSURE CATEGORIES	
		A	B
<b>RAILS</b>	1" minimum wood Top and Bottom rails.  5" composite rails available for special hardware applications.	Minimum 3/4" Georgia-Pacific Firestop and Composition top rail. Wood bands not required.  5" composite rails available for special hardware applications.  Minimum 1" wood bottom rail.	1" minimum wood Top and Bottom rails.  5" composite rails available for special hardware applications.  Intumescent required at head of frame.  Minimum 1" wood bottom rail.

**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 (PVA) 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, ultra-violet 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.

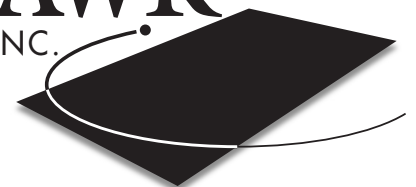
**RUSTIC:** An embossed tempered hardboard face with a modulus of Rupture of 5700 PSI. Meets or exceeds ANSI/AHA – 135.4 1982 Standards. Prefinished on our 540-ft. prefinish line with a 9-step application to capture the rich inherent beauty of Walnut and Oak veneers. Available in 8 decorator tones: Lite 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 LITE SIZE OPENINGS:** 36"x 54". 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. Cut-out areas over half of the length of the door must be at least 8" from edge of door and 5-1/2" from edge of hardware cut-out.

**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.**

<b>MACHINING</b>	<b>NEGATIVE PRESSURE</b>	<b>POSITIVE PRESSURE</b>
<b>HINGES</b>		
Leaf	Yes	Yes
Continuous	Yes	Yes
Pivot	Yes	No
Spring	Yes	Yes
<b>LATCHING OPTIONS</b>		
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
<b>LATCHSETS</b>		
Mortise	Yes	Yes
Cylindrical	Yes	Yes
Card	Yes	Yes
Dead Bolts	Yes	Yes
<b>FLUSHBOLTS</b>		
Surface	Yes	Yes
Mortised	Yes	Yes
<b>FIRE EXIT HARDWARE</b>		
Rim	Yes	Yes
Mortise	Yes	Yes
Surface Vertical Rod	Yes	Yes
Concealed Vertical Rod	Yes	Yes
<b>LESS BOTTOM ROD</b>		
SVR	Yes w/Thermal Pin	Yes w/Thermal Pin
VR	Yes w/Thermal Pin	Yes w/Thermal Pin
<b>CLOSERS</b>		
Mortised	Limited	No
Surface	Yes	Yes
Power-Operated	Yes	Yes
<b>EDGE GUARDS</b>		
Flush	Limited	Limited
Mortised	Limited	Limited
<b>VIEWERS</b>	Yes	Yes
<b>RACEWAY</b>	Yes	Yes
<b>POWER TRANSFERS</b>	Yes	Yes



## 7-Ply Specifications

### 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 layout 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.

**ASTRAGALS:** May be required on standard pairs predicated on door sizes and applications. Doors may be built with treated Maple stiles on lock side in lieu of astragals.

**TRANSOMS:** Continuous match or end match for opening size through 4/0 x 10/0. Transom panels shall be the same construction as 20-minute fire door. Maximum size panel allowed is 48" wide by 52" high. Transom panels may be rabbetted, installed with a metal edge and astragal, or installed with a transom bar between door and transom. Transoms installed over a pair of doors must be separated with a mullion limiting the width of each separate transom to the width of each leaf of the door pair. The panel shall be machined for spring bolts. Standard rabbet size is 1/2" x 7/8" (1/2 of door thickness) for 1-3/4" thick door.

**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:** One year standard. Two-year, Five-year, and Lifetime Warranties available by special request.

