

**GOLD SERIES**

**7-Ply Architectural Flush Doors**

**MPC-7**

**Mohawk Particle Core Door**

**Edge-Bonded**

**7-Ply Construction**

**QUALITY ASSURANCES:** All Particle Core doors meet or exceed the latest edition of W.D.M.A. I.S. 1A-97 and AWI 1300 Quality Standards.

**APPLICATIONS:** Used in high-traffic areas when AWI 1300 PC7 specifications must be met, architectural in nature.

**MAXIMUM SIZE:** (Single Door) 4/0 x 10/0; (Paired Doors) 8/0 x 10/0.

**THICKNESS:** 1-3/8" and 1-3/4" standard. Other thickness by special request. Maximum 2-1/2".

**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).

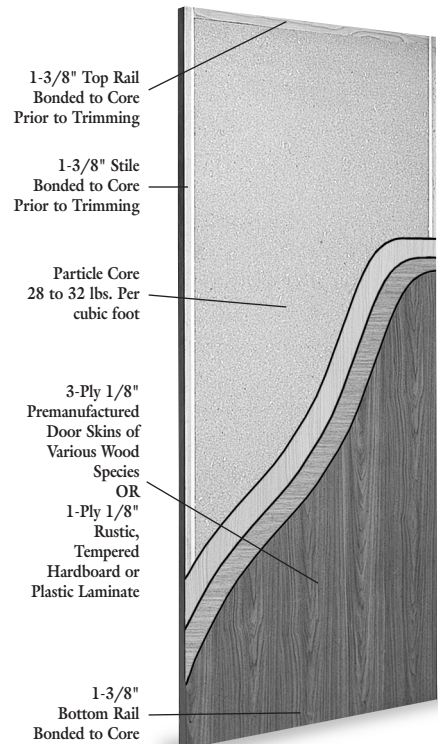
**1-PLY TEMPERED HARDBOARD:** Modulus of rupture 8500 PSI. Meets or exceeds ANSI/AHA-135.4 1982 Standards.

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

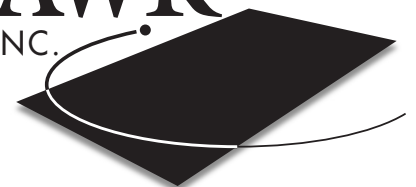
**CORE:** Stiles and rails securely bonded to core using a hot-melt glue process and then sanded to ensure even thickness and minimal telegraphing of core and stile parts through veneer. Meets or exceeds ANSI.A-208-1-1989 for grade 1-LD-1. Face screw pull 90 lbs. Resists warping—superior dimensional stability. Provides full support for cut-outs at light and louver openings, excellent bonding capabilities.

1-LD-2 core by special request (lead time and price will vary).

**STILES:** 1-3/8" standard. Softwood or hardwood stiles available per specifications. Stiles are securely bonded to core using a hot-melt glue process and then sanded to ensure minimal telegraphing of core and stile parts through veneer. Douglas Fir or similar species. Specific gravity of Douglas Fir: .41, approximate screw-holding: 495 lbs. 1-1/4" hardwood stiles by special request. Specific gravity and approximate screw-holding of most popular species: Birch .55, 890 lbs. Cherry .47, 650 load lbs. Maple .56, 923 load lbs. Red Oak .54, 858 load lbs. White Oak .60, 1060 load lbs. Poplar .40, 470 load lbs. Basswood .37, 430 load lbs. Banak .44, 570 load lbs. Walnut .61, 1095 load lbs. African and Honduras Mahogany .45, 596 load lbs. Special framing—any width stile to your specifications by special request. Matching edge-banded veneer by special request. (Field trimming not permitted.) All dimensions prior to factory trimming and prefitting.



**MOHAWK**  
 FLUSH DOORS, INC.  
**PREMDOR**



## 7-Ply Specifications

**RAILS:** 1-3/8" standard. 15" maximum top and/or bottom rail. Wood or hardwood rails available per specifications. Rails are securely bonded to core using a hot-melt glue process and then sanded to ensure minimal telegraphing of core and rail parts through veneer. All dimensions prior to factory trimming and prefitting.

**OPTIONAL LOCKBLOCKS:** 2-1/2" x 20" Softwood (standard). Other species 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 (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, 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 LITE SIZE OPENINGS:** Cut-out areas of half the height of the door must be at least 5-1/2" from any edge or hardware cut-out. Cut-out areas the full length of the door must be at least 8" from edge of door and 5-1/2" from edge of hardware cut-out.

**MACHINING:** We will machine your doors to almost any hardware specifications. In addition, by special request, we offer coordination service. Supply us with approved door, frame, and hardware schedules and all templates, and we will complete all machining information on our machining sheets. There is a charge for this service and it will extend lead-times.

**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".

**TRANSOMS:** Continuous match or end match for finished opening sizes through 4/0 x 10/0. Rabbet for door and transom available by special request.

**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.

**FLAT WOOD ASTRAGALS:** Compatible wood species to match door face. Standard size 2-1/4" x 1/2", other sizes by special request.

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

**ADDITIONAL OPTIONS:** Dutch doors, Wicket doors, astragals, lites (wood and metal), louvers (wood and metal), glazing and identification marking.

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