

Recommendations on how to store, handle, finish, and install doors.

Storing

- Store flat on level surface in a clean, dry, well-ventilated area protected from sunlight.
- Some species are sensitive to light and must be covered.
- Doors should not be subjected to extremes of heat and/or humidity conditions. Relative humidity should not be less than 30% or more than 60%.
- Store doors in closed-in buildings with operational HVAC systems.
- Cover doors to keep clean, but allow air circulation.
- Seal at earliest possible moment. Edge sealing is particularly important.
- Lift or carry doors. Do not drag one door against another.
- Handle doors with clean hands or clean gloves. Do not walk on or place other materials on top of stacked doors.

Field Finishing

- Just prior to staining, sealing, and finishing, doors must be completely block-sanded in a horizontal position by the finisher with not less than 150-grit sandpaper, to remove all handling marks and raised grain.
- If possible, test surface for compatibility with finish.
- Top, bottom, opening, and hardware recess edges must be sealed after fitting with at least two (2) coats of oil-based paint, varnish, or lacquer.
- Water-based stains, paint, or latex primers should be avoided whenever possible because they raise the grain, may cause veneer splits, and have a tendency to highlight veneer joints.
- Do not use steel wool on oak-veneered or fire-rated doors.
- A wash coat (thin sealer) should be applied prior to the use of a dark stain to avoid a splotchy appearance and/or sharp contrast in color.
- High humidity conditions will adversely affect the finish appearance.
- Manufacturers' warranties do not cover the appearance of field-applied finishes.

Installation

- Allow doors to become acclimated to finished building heat and humidity before fitting and hanging.
- Utility or strength of doors must not be impaired by fitting to the opening, applying hardware, plant-ons, louvers, or other detailing.
- In fitting for width, trim equally from both sides, allowing 1/8" clearance at top and each side.
- In fitting for height, do not trim top edge on labeled doors, and on non-rated doors do not trim top and bottom edge more than 3/4" unless accommodated by additional blocking.
- Threaded-to-the-head wood screws are preferable for fastening all hardware on non-rated doors and required on all rated doors. Pilot holes must be drilled for all screws to avoid splitting.
- Use two (2) hinges for doors up to 60" in height, three (3) hinges for doors up to 90" in height, and an additional hinge for every additional 30" of door height or portion thereof.

See also *Fire Door Requirements*.

Dimensional Tolerances

- Doors not prefit—width $\pm 1/16"$, height $\pm 1/16"$, thickness $\pm 1/16"$.
- Doors machined for hardware—width $\pm 1/32"$, height $\pm 1/16"$, thickness $\pm 1/16"$, hardware location $\pm 1/32"$, locks and hinges $\pm 1/32"$.
- Squareness tolerances—Diagonal measurement difference must not exceed 1/8".
- Stile, rail, and core show-through (telegraphing) will not be considered a defect unless the face of the door varies from the true plane in excess of 1/100" in any three-inch (3") span.
- Warp tolerance—The warp for any nominal 1-3/4" thick or thicker door shall not be more than 1/4" in any 3'6" (3/6) wide by 7'0" (7/0) high section of the door. The measuring section will be reduced to the actual width and/or height of the door if the actual width and/or height is less than 3'6" (3/6) wide by 7'0" (7/0) high. Doors may take up to 1-year to acclimate to the building temperature and humidity
- The warp for any nominal 1-3/8" thick door that is 3'0" (3/0) wide by 7'0" (7/0) high or smaller, shall not be more than 1/4".

Fire Door Requirements

- GENERAL—Install doors as required by NFPA Pamphlet 80. All 20-, 45-, 60-, and 90-minute rated doors may be hung with either half surface or full mortise hinges. Core reinforcements can be specified to permit hardware to be surface-mounted with screws. Labels shall not be removed from fire-rated doors.
- 20-, 45-, 60-, and 90-minute rated doors—Preparation of fire door assemblies must be done under label service in accordance with the manufacturer's service procedure. This includes trimming for size, except a maximum 3/4" off the bottom of the door, and preparation for locks, latches, hinges, closers, lights, louvers, astragals, and any fabrication.
- It is absolutely necessary to predrill pilot screw holes when mounting hardware. When installing butt hinges use #12 x 1-1/4" threaded-to-the-head steel screws with constant diameter wood threads. Drill 5/32" diameter pilot holes for #12 screws. Failure to drill correct size pilot holes could result in stile splitting and void the warranty of the door.

Do not use Mohawk doors in exterior applications.

MOHAWK
 FLUSH DOORS, INC.
PREMDOR

