



# AMERICAN SERIES

Architectural, Flush & CollegeGuard Doors





Doormerica produces American Series commercial, residential flush, and molded doors in our state-of-the-art manufacturing facility located in Stockton, California. Serving the entire nation with reliable, high-quality products and dependable lead times. Providing an array of door products in hardwood, paint grade, molded panel, and five-ply, including factory prefinished architectural doors in various species.

We are LEED certified and feature many products to meet green building initiatives. Doormerica is your full-service commercial and residential door supplier. Building quality products since 1989.





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# FLUSH DOORS

## ECONOMY CONSTRUCTION

Our Economy grade construction offers an affordable and diverse array of particleboard core options. With 1 and 2-ply face options including but not limited to wood veneer, primed and prefinished HDF, MDO, Legacy, and ColledgeGuard. Perfect for light commercial projects.



flush "economy"  
particleboard core



<b>SPECIFICATIONS</b>	3 & 5 ply construction - meets or exceeds industry standards of WDMA I.S.1; all 20 minute doors have been tested in conformance to the following standards ASTM-E-152, CSFM-43.7, CAN S104,NFPA-252, UBC-7-2-97, UL-10C
<b>LAY UP METHOD</b>	loose
<b>MAXIMUM SIZES</b>	width= 4/0; length= depends on faces (see faces below for available length)
<b>THICKNESS</b>	1-3/8" and 1-3/4" only
<b>STILES</b>	softwood (fir, pine, spruce, basswood, SCL) mill option width = 1" nominal, 13/16" minimum after prefit size
<b>RAILS</b>	1-3/8" thickness = (top) MDF 1" nominal, 3/4" minimum after undercut (bottom) MDF, 1-5/8" nominal, 1" minimum after undercut 1-3/4" thickness = MDF, 2-1/4" nominal, 1" minimum after undercut
<b>CORE</b>	28-30lb particleboard, ANSI A208.1 grade LD-1
<b>FIRE RATING</b>	1-3/4" thickness 20 minute rated*
<b>FACES</b>	raw only lauan (okuome) 2 ply- 8/0 max length raw only RN birch 2 ply, MDF back, 1/64" face veneer- 8/0 max length raw only PS red oak 2 ply, MDF back, 1/64" face veneer- 8/0 max length raw MDF single ply- 10/0 max length primed MDF single ply- 10/0 max length embossed primed MDF single ply- 8/0 max length embossed prefinished MDF (legacy) single ply- 8/0 max length
<b>ADHESIVE</b>	Type-1 PVA (interior installation only)
<b>MACHINING</b>	to specification
<b>LITES</b>	to specification
<b>LOUVERS</b>	to specification
<b>ACOUSTICAL RATING</b>	32 STC operable (see doormerica.com for seal information)
<b>WARRANTY</b>	standard two-year (see limited warranty for details)
<b>DESCRIPTION ABBREVIATIONS</b>	E-1-3/8 = 1-3/8" thick PBC E-20NL = 1-3/4" thick PBC, non-rated E-20B = 1-3/4" thick PBC, 20-minute category B E-20A = 1-3/4" thick PBC, 20-minute category A
<b>RECOMMENDED USE</b>	residential and light commercial

## STANDARD CONSTRUCTION

Our Standard grade construction offers an affordable and diverse array of particleboard core options. With 2-ply face options including but not limited to custom “A” grade to premium “AA” grade wood veneers in a variety of slices and assemblies, plastic laminate and MDO. Perfect for light commercial projects.



flush “standard”  
particleboard core



<b>SPECIFICATIONS</b>	3 & 5 ply construction - meets or exceeds industry standards of WDMA I.S.1; all 20 minute doors have been tested in conformance to the following standards ASTM-E-152, CSFM-43.7, CAN S104,NFPA-252, UBC-7-2-97, UL-10C
<b>LAY UP METHOD</b>	bond and sand
<b>MAXIMUM SIZES</b>	width= 4/0; length= depends on faces (see faces below for available length)
<b>THICKNESS</b>	1-3/8" and 1-3/4" only
<b>STILES</b>	raw stain grade = matching hardwood prefinished = matching hardwood P-lam = SCL with matching edge banding over CAT-A = special CAT-A Stile with matching edge banding over width = 1" nominal, 13/16" minimum after prefit size
<b>RAILS</b>	1-3/8" thickness = MDF 1-5/8" nominal, 3/4" minimum after undercut 1-3/4" thickness = MDF, 2-1/4" nominal, 1" minimum after undercut
<b>CORE</b>	28-30lb particleboard, ANSI A208.1 grade LD-1
<b>FIRE RATING</b>	1-3/4" thickness 20 minute rated*
<b>FACES</b>	RN birch 2 ply, MDF back, 1/50" face veneer- 8/0 max length PS red oak 2 ply, MDF back, 1/50" face veneer- 8/0 max length raw MDF single ply- 10/0 max length primed MDF single ply- 10/0 max length primed MDO 2 ply HDF back- 10/0 max length select species raw and prefinished 2 ply, 1/42" face- 10/0 max length plastic laminate 2 ply, 1/50" face- 10/0 max length (all laminates meet or exceeds NEMA standards)
<b>ADHESIVE</b>	Type-1 PVA (interior installation only)
<b>MACHINING</b>	to specification
<b>LITES</b>	to specification
<b>LOUVERS</b>	to specification
<b>ACOUSTICAL RATING</b>	32 STC operable (see doormerica.com for seal information)
<b>WARRANTY</b>	standard two-year (see limited warranty for details)
<b>DESCRIPTION ABBREVIATIONS</b>	S-1-3/8 = 1-3/8" thick PBC S-20NL = 1-3/4" thick PBC, non-rated S-20B = 1-3/4" thick PBC, 20-minute category B S-20A = 1-3/4" thick PBC, 20-minute category A
<b>RECOMMENDED USE</b>	residential and light commercial

\*See fire door specifications section for details on sizes, hardware and construction limitations

# FLUSH DOORS

## HEAVY DUTY CONSTRUCTION

Our heavy duty construction meets or exceeds industry standards. We offer an affordable “bond-to-core” lay-up using ANSI approved and CARB friendly A208.1 particleboard. With 1 and 2-ply face options and a limited-lifetime warranty. Our faces include but are not limited to “A” and “AA” WDMA approved wood veneers in an array of slices and assemblies, factory UV primed and prefinished HDF, primed MDO, Legacy, and ColledgeGuard. Perfect for light commercial and architectural projects.



flush “heavy duty”  
particleboard core



<b>SPECIFICATIONS</b>	3 & 5 ply construction - meets or exceeds industry standards of WDMA I.S.1-A, WI section 12, AWI section 1300 custom grade (A grade faces), AWI section 1300 premium grade (AA grade faces); all 20 minute doors have been tested in conformance to the following standards. ASTM-E-152, CSFM-43.7, CAN S104, NFPA-252, UBC-7-2-97, UL-10C
<b>LAY UP METHOD</b>	bond and sand
<b>MAXIMUM SIZES</b>	width= 4/0; length= depends on faces (see faces below for available length)
<b>THICKNESS</b>	1-3/8" and 1-3/4" only
<b>STILES</b>	paint grade = FJ hardwood, raw stain grade = matching hardwood prefinished = matching hardwood, P-lam = SCL with matching edge banding over CAT-A = special CAT-A stile with matching edge banding over width = 1-3/8" minimum
<b>RAILS</b>	1-3/8" thickness = wood or SCL 1-1/8" minimum 1-3/4" thickness = wood or SCL 1-1/8" minimum
<b>CORE</b>	34lb particleboard, ANSI A208.1 grade LD-2
<b>FIRE RATING</b>	1-3/4" thickness 20 minute rated*
<b>FACES</b>	primed MDO 2 ply HDF back- 10/0 max length select species raw and prefinished 2 ply, 1/42" face- 10/0 max length plastic laminate 2 ply, 1/50" face- 10/0 max length (all laminates meet or exceed NEMA standards)
<b>ADHESIVE</b>	Type-1 PVA (interior installation only)
<b>MACHINING</b>	to specification
<b>LITES</b>	to specification
<b>LOUVERS</b>	to specification
<b>ACOUSTICAL RATING</b>	33 STC operable (see doormerica.com for seal information)
<b>WARRANTY</b>	lifetime (see limited warranty for details)
<b>DESCRIPTION ABBREVIATIONS</b>	HD-1-3/8 = heavy duty 1-3/8" thick PBC HD-20NL = heavy duty 1-3/4" thick PBC, non-rated HD-20B = heavy duty 1-3/4" thick PBC, 20-minute category B HD-20A = heavy duty 1-3/4" thick PBC, 20-minute category A
<b>RECOMMENDED USE</b>	architectural

## EXTRA HEAVY DUTY CONSTRUCTION

Our extra heavy duty construction provides longevity and stability with a limited-lifetime warranty while meeting or exceeding industry standards. We offer an affordable “bond-to-core” lay-up using ANSI approved and CARB friendly SCL core. With 1 and 2-ply face options that include but are not limited to “A” and “AA” WDMA approved wood veneers in an array of slices and assemblies, plastic laminate, factory UV primed and prefinished HDF, primed MDO, Legacy, and ColledgeGuard. Perfect fit for architectural, institutional, educational, and healthcare projects.



flush “extra heavy duty” structural composite lumber core



<b>SPECIFICATIONS</b>	3 & 5 ply construction - meets or exceeds industry standards of WDMA I.S.1-A, WI section 12, AWI section 1300 custom grade (A grade faces), AWI section 1300 premium grade (AA grade faces); all 20 and 45-minute doors have been tested in conformance to the following standards. ASTM-E-152 CSFM-43.7, CAN S104, NFPA-252;UBC-7-2-97, UL-10C
<b>LAY UP METHOD</b>	bond and sand
<b>MAXIMUM SIZES</b>	width= 4/0; length= depends on faces (see faces below for available length)
<b>THICKNESS</b>	1-3/8” and 1-3/4” only
<b>STILES</b>	paint grade = FJ hardwood, raw stain grade = matching hardwood prefinished = matching hardwood, P-lam = SCL with matching edge banding over CAT-A = special CAT-A stile with matching edge banding over width = 1-3/8” minimum
<b>RAILS</b>	1-3/8” thickness = wood or SCL 1-1/8” minimum 1-3/4” thickness = wood or SCL 1-1/8” minimum
<b>CORE</b>	structural composite lumber (engineered), grade LD-2
<b>FIRE RATING</b>	1-3/4” thickness 20-minute rated* 1-3/4” single swing 45-minute rated**
<b>FACES</b>	primed MDO 2 ply HDF back– 10/0 max length select species raw and prefinished 2 ply, 1/42” face– 10/0 max length plastic laminate 2 ply, 1/50” face– 10/0 max length (all laminates meet or exceed NEMA standards)
<b>ADHESIVE</b>	Type-1 PVA (interior installation only)
<b>MACHINING</b>	to specification
<b>LITES</b>	to specification
<b>LOUVERS</b>	to specification
<b>ACOUSTICAL RATING</b>	33 STC operable (see doormerica.com for seal information)
<b>WARRANTY</b>	lifetime (see limited warranty for details)
<b>DESCRIPTION ABBREVIATIONS</b>	EHD-1-3/8 = extra heavy duty 1-3/8” thick SCL EHD-20NL = extra heavy duty 1-3/4” thick SCL, non-rated EHD-20B = extra heavy duty 1-3/4” thick SCL, 20-minute category B EHD-20A = extra heavy duty 1-3/4” thick SCL, 20-minute category A EHD-45B = extra heavy duty 1-3/4” thick SCL, 45-minute category B ** EHD-45A = extra heavy duty 1-3/4” thick SCL, 45-minute category A **
<b>RECOMMENDED USE</b>	architectural and institutional

\*See fire door specifications section for details on sizes, hardware and construction limitations

\*\*Single swing only on 45-minute fire-rated; max size 4/0x8/0

# FLUSH DOORS

## MINERAL CORE CONSTRUCTION

Our mineral core series offer a standard limited-lifetime warranty while meeting or exceeding industry standards. Our 250/30 Temperature-Rise mineral core coupled with our “bond-to-core” lay-up provides security and safety from fire, up to 90-minutes when installed and assembled properly. We offer 1 and 2-ply face options that include but are not limited to “A” and “AA” WDMA approved wood veneers in an array of slices and assemblies, plastic laminate, factory UV primed and prefinished HDF, primed MDO, Legacy, and ColledgeGuard. Perfect fit for light commercial, architectural, institutional, educational, and healthcare projects.



flush mineral core  
45-60-90



<b>SPECIFICATIONS</b>	3 & 5 ply construction - meets or exceeds industry standards of WDMA I.S.1-A, WI section 12, AWI section 1300; testing standards ASTM-E-152, CSFM 43.7 CAN4-S104, NFPA-252, UBC-7-2-97, UL10C
<b>LAY UP METHOD</b>	bond and sand
<b>MAXIMUM SIZES</b>	width= 4/0; length= depends on faces (see faces below for available length)
<b>THICKNESS</b>	1-3/4" only
<b>STILES</b>	laminated composite to wood (Georgia Pacific), specific to rating* edge banding veneer or plastic when matching edges required
<b>RAILS</b>	laminated composite to wood (Georgia Pacific), specific to rating* width = 1" minimum
<b>CORE</b>	gypsum mineral
<b>FIRE RATING</b>	45-60-90 minute rated*
<b>FACES LIGHT COMMERCIAL</b>	RN birch 2 ply, MDF back, 1/64" face veneer, 8/0 max length PS red oak 2 ply, MDF back, 1/64" face veneer, 8/0 max length raw MDF single Ply, 10/0 max length, primed MDF single Ply, 10/0 max length embossed primed MDF single ply, 8/0 max length embossed prefinished MDF (legacy) single ply, 8/0 Max length
<b>FACES ARCHITECTURAL</b>	primed MDO 2 ply HDF back, 10/0 max length select species raw & prefinished 2 ply, 1/42" face, 10/0 max length plastic laminate 2 ply, 1/50" face, 10/0 max length (all laminates meet or exceed NEMA standards)
<b>ADHESIVE</b>	Type-1 PVA (interior installation only)
<b>MACHINING</b>	to specification
<b>LITES</b>	to specification
<b>LOUVERS</b>	to specification
<b>TEMP RISE</b>	30 minutes 250 degrees maximum
<b>ACOUSTICAL RATING</b>	30 STC operable (see doormerica.com for seal information)
<b>WARRANTY</b>	lifetime (see limited warranty for details)
<b>RECOMMENDED USE</b>	architectural and light commercial



## WOOD SKIN TECHNICAL DATA

All Architectural wood skin species are manufactured under conformance to the following industry standards: WDMA I.S. 1-A, WIC Section 12, AWI Section 1300 "Premium" and "Custom" Grade. All Architectural wood skins are 2-ply construction with 1/42" face veneer. All stocking skins used are "Book/Running Match A-Grade" faces. Special species veneers available.



# FLUSH DOORS

## ARCHITECTURAL PREFINISHED HARDWOOD DOORS

- UV Technology cured system that provides the highest level of quality and durability
- Eliminates the issues of a field finished door
- Environmentally friendly with zero VOC emissions
- LEED compliant with no added Urea Formaldehyde
- Meets or exceeds AWI section 1500 and WDMA I.S.1-A TR-08 specifications
- Nine standard colors available
- Supplied with 4.1-mil peelcoat protective film
- Custom color match available (minimums apply)

	CLEAR	NEVADA	ARIZONA	OREGON	CALIFORNIA
ROTARY WHITE BIRCH					
P/S RED OAK					
P/S WHITE MAPLE					
P/S CHERRY					



These swatch samples are not intended to be used for final color selection. Please contact Doormerica for an actual face veneer sample to determine your desired color selection.

	FLORIDA	VIRGINIA	GEORGIA	ALABAMA
ROTARY WHITE BIRCH				
P/S RED OAK				
P/S WHITE MAPLE				
P/S CHERRY				



## HARDWOOD PREFINISH TECHNICAL DATA

The Ultra Violet (UV) coating system supplied by Doormerica is a full, complete UV cured system. This system is in direct compliance of A.W.I. Section 1500 "UV curable coating item A #5610." The performance number is 33, which compares to the very best of any coating systems. The coating process is as follows:

1. Sand
2. 1st coat = UV filler
3. Sand
4. 2nd coat = UV filler
5. Buff
6. 3rd coat = UV Epoxy Acrylic Topcoat
7. Buff
8. 4th coat = UV Epoxy Acrylic Topcoat

The total dry film is 1.2-1.6 mils dry

# COLLEDGEGUARD PRESTAINED DOORS



ColledgeGuard prestained door skins are made from industrial grade HDF board developed and finished in a variety of colors and grain variations. These fully finished doors offer a deeper and bolder grain branding process for a unique and superior upscale appearance. Built with traditional solid core construction components, ColledgeGuard prestained doors can be adapted to many popular applications.

Perfect for light commercial applications where a prefinished surface is desirable. ColledgeGuard prestained doors have a color coordinated prepainted wood edge and are available in a variety of fire ratings. Made from environmentally friendly materials that are CARB II compliant as well as recognized by FSC, SCS.



## HDF DOORS



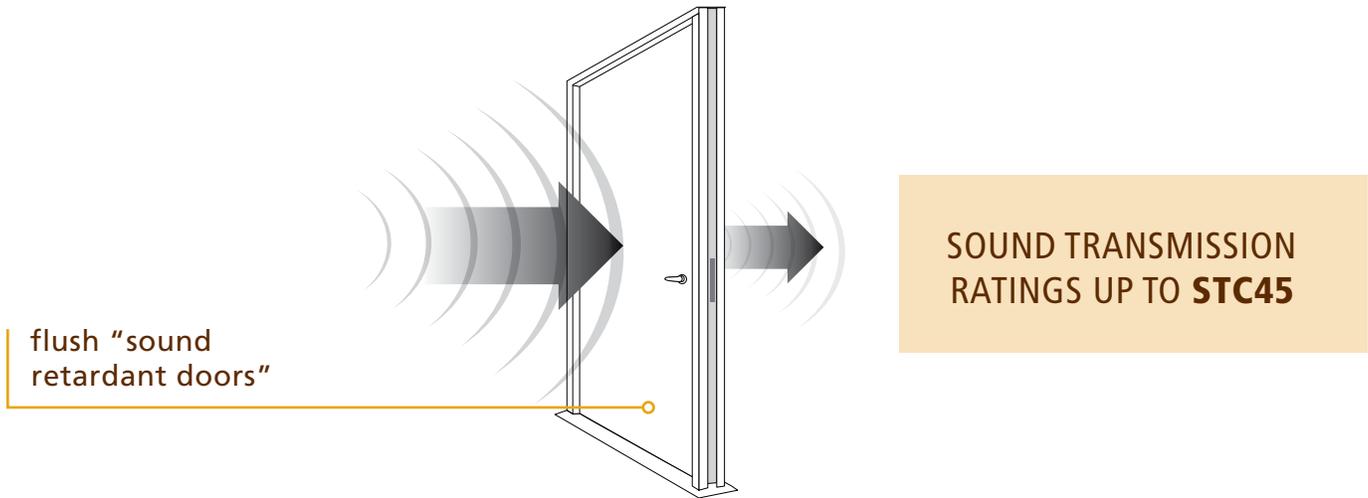
corresponding door edge paint colors

# FLUSH DOORS

## STC CONSTRUCTION

### Sound Transmission Class (STC)

Sound transmission is the movement of sound through a medium. Preventing the transfer of sound through door openings involves both specialized door construction as well as controlling gaps and tolerances around a door. These require special products and techniques. The higher the STC value the better the performance.



<b>SPECIFICATIONS</b>	3 & 5 ply construction - meets or exceeds industry standards of WDMA I.S.1-A, WI section 12, AWI section 1300; custom grade( A grade faces), AWI section 1300 premium grade (AA grade faces)
<b>LAY UP METHOD</b>	bond and sand
<b>MAXIMUM SIZES</b>	width= 4/0; length= 8/0
<b>THICKNESS</b>	1-3/4" only
<b>STILES</b>	paint grade = FJ hardwood, raw stain grade = matching hardwood prefinished = SCL with matching edge banding over P-lam = SCL with matching edge banding over width = 1-3/8" minimum
<b>RAILS</b>	1-3/4" thickness = wood or SCL 1-1/8" minimum
<b>CORE</b>	STC 43: RIGICOREGP, STC 45: RIGICOREEX
<b>FIRE RATING</b>	1-3/4" thickness 20-minute rated*
<b>FACES</b>	primed MDO 2 ply HDF back- select species raw and prefinished 2 ply, 1/42" face plastic laminate 2 ply, 1/50" face (all laminates meet or exceed NEMA standards)
<b>ADHESIVE</b>	Type-1 PVA (interior installation only)
<b>MACHINING</b>	to specification
<b>LITES</b>	STC 39 max lite kit 22x36 (see doormerica.com for kit and glass details)
<b>LOUVERS</b>	n/a
<b>ACOUSTICAL RATING</b>	43 STC operable - non-rated and 20-min fire 45 STC operable - non-rated, 20-min fire, and 45-min fire
<b>WARRANTY</b>	lifetime (see limited warranty for details)
<b>STC OPENING COMPONENTS</b>	see doormerica.com for seal information
<b>RECOMMENDED USE</b>	architectural and institutional

# HOLLOW CORE CONSTRUCTION

flush hollow core



<b>SPECIFICATIONS</b>	3 & 5 ply construction - meets or exceeds industry standards of WDMA I.S.1
<b>LAY UP METHOD</b>	loose
<b>MAXIMUM SIZES</b>	width= 4/0; length= depends on face (see faces below for available length)
<b>THICKNESS</b>	1-3/8" and 1-3/4" only
<b>STILES</b>	MDF available on MDF type skins, only 1-3/8" thickness & 6/8 length; softwood available on all skin types 1-3/8" and 1-3/4" thickness; width = 1" nominal, 13/16" minimum after prefit size
<b>RAILS</b>	1-3/8" thickness = (top) MDF 1" nominal, 3/4" minimum after undercut (bottom) MDF, 2" nominal, 1" minimum after undercut 1-3/4" thickness = MDF, 2-1/4" nominal, 1" minimum after undercut
<b>CORE</b>	cellular honeycomb with 5" hexagonal cells
<b>LOCK BLOCKS</b>	double 3" x 20" particleboard (28lb) as standard
<b>FACES</b>	lauan (okoume) - raw, 8/0 maximum; RN birch - raw, 2 ply, 1/64" face veneer thickness, 8/0 maximum; PS red oak - raw, 2 ply, 1/64" face veneer thickness, 8/0 maximum; MDF - primed and raw, single ply, 10/0 maximum; embossed MDF primed and prefinished, single Ply, 8/0 maximum
<b>ADHESIVE</b>	Type-1 PVA (interior installation only)
<b>MACHINING</b>	to specification
<b>LITES</b>	to specification (blocking only upon request)
<b>LOUVERS</b>	to specification (blocking only upon request)
<b>ACOUSTICAL RATING</b>	n/a
<b>WARRANTY</b>	standard 2-year (see limited warranty for details) <i>note: no warranty for telegraphing</i>
<b>DESCRIPTION ABBREVIATIONS</b>	FP-1-3/8 = 1-3/8" thick, MDF stiles FJ-1-3/8 = 1-3/8" thick, FJ softwood stiles SWE-1-3/8 = 1-3/8" thick, clear softwood stiles FJ-1-3/4 = 1-3/4" thick, FJ softwood stiles SWE-1-3/4 = 1-3/4" thick, clear softwood stiles
<b>RECOMMENDED USE</b>	residential and light commercial

## LITES

### W-7 LIP MOLDING



### W-9 FLUSH MOLDING



<b>USE</b>	for use with non-rated 1-3/4" solid doors only (for more details see catalog) W-7 lip molding and W-9 flush molding
<b>SPECIES AVAILABLE</b>	birch, cherry, mahogany, maple, red oak, walnut and white oak (for more details see catalog)
<b>SIZES</b>	various sizes available in full-inch increments up to maximum area/size listed below (for more details see catalog)
<b>GLASS SIZE</b>	glass should be cut 1/16" less in length and width than wood beaded lite size ordered (for more details see catalog)
<b>PARTS LIST</b>	(1) one instruction sheet (8) eight prefit wood beads with nails prefit into the opening (1) one piece of 1/4" glass  <i>note: glass should be cut 1/16" less in length and width than the lite opening size and measure 1/4" in thickness (for more details see catalog)</i>



## ONE PILLAR OF A SUSTAINABLE STRATEGY IS THE SELECTION OF PROPER BUILDING MATERIALS

Sustainable materials such as MDF (medium density fiberboard) are a good environmental choice. The base material of all Doormerica products is MDF, made from the byproducts of the lumber industry.

We applaud projects designed for sustainability and welcome a chance to contribute. Please send your project specifics and available credits to Doormerica group at [doormerica.com](http://doormerica.com) or call (888) 454-2888.

The LEED (Leadership in Energy and Environmental Design) Green Building Rating System was originally developed by the U.S. Green Building Council (USGBC) to provide a recognized standard for the construction industry to assess the environmental sustainability of building designs.

Doormerica is committed to engineering our manufacturing processes so that we may assist our customers in achieving their LEED certification rating. Doormerica is focused on being a good global partner in environmental stewardship. All Doormerica products are certified by a nationally recognized third party certification service.

Please contact us or visit [doormerica.com](http://doormerica.com) for further information



# LIMITED WARRANTY & CLAIMS PROCEDURE

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:**

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 concaved 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".

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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.
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 touch-up 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.

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 cannot 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.

#### **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 6" 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.

#### **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 prefinished should be checked against approved finish sample prior to any installation. Installation of any pre-machined or prefinished 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.



## AMERICAN SERIES

[doormerica.com](http://doormerica.com)

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## MMI DOOR LOCATIONS

### MICHIGAN (HQ)

6361 Sterling Drive North  
Sterling Heights, MI 48312

586-264-0950

800-686-9218

Fax: 586-264-5430

### OHIO

400 Circle Freeway Drive  
Cincinnati, OH 45246

513-874-6771

800-215-3770

Fax: 513-870-0242

### PENNSYLVANIA

172 Plummer Road  
Sidman, PA 15955

814-487-7800

800-452-0251

Fax: 814-487-7850