Architectural Door Specifications

Flush Doors

Materials:

- Stiles: Laminated Timberstrand – 38mm X 43mm, running full length of the door
- Rails: Timberstrand – 38 mm x 43 mm
- Cross banding: High density tempered hardboard or 48 lb. MDF, 3mm.
- Core: 28 lb. medium density particleboard.
- Finished edges: solid lumber to match face veneers, 22mmX 45mm Parveneer “T” edge, bonded to stile and cross band.
- Face veneers: Parveneer standard grade is AA, centre balance matched (balance matched for quarter cut veneers), suitable for AWI Premium Grade specifications. Other grades available on request.

Construction:

Parveneer’s door construction is a two step manufacturing process which achieves a true sanded and bonded five ply door with a true AWI / AWMAC #I concealed edge (AWI Quality Standards 8th Edition, 1300-T-7)

- Bonded core: Stiles, rails and cross bands are bonded to the core using a hot press. Matching hardwood edges are then installed prior to face veneering.
- Calibration: The door blank is then sanded to achieve uniform thickness.
- Face veneers are manufactured from carefully selected flitch stock. Sketch faces can be manufactured to simulate stile and rail construction or other configurations. Face veneers are applied to the door blanks in a second pressing stage.
- Finish sanding: 150 grit, ready for finishing.
- Machining: Parveneer doors may be machined for hardware according to customer specifications.

Factory Finishing:

Standard finish is catalyzed lacquer TR2. TR4 (conversion varnish) and TR6 (catalyzed polyurethane) also available. Custom stains and topcoats are spray applied and cured in a heated air convection oven.

Fire Ratings:

Parveneer flush doors as described above may carry a Warnock Hersey 20-minute label for either neutral (UL 10-B) or positive pressure (UL 10-C) applications. Maximum lite size – 1296 in². 45, 60 and 90-minute rated doors are also available, using fire rated mineral core, and are described in Fire Rated section.
Series 100 Flush Wood Doors – Typical Elevation & Section

SERIES 100 Flush Wood Doors

Timberstrand Top Rail
- 38mm X 43mm
- 38mm X 86mm
   If concealed closer is required

28 lb. Particle Core (option SCLC)

Timberstrand Inner Stile
- 38mm X 43mm

Matching Hardwood "T" Edge

43

8 + 10

44

20

3mm High Density Hardboard Crossband

Face Veneer

Timberstrand Bottom Rail
- 38mm X 43mm
- 38mm X 86mm
   If automatic door bottom is required
Parveneer Core Options
Non-Fire Rated Doors

<table>
<thead>
<tr>
<th>Core Type</th>
<th>Particleboard 28 lb/ft$^2$</th>
<th>Structural Composite Lumber Core (SCLC)</th>
<th>Engineered Lumber Core</th>
<th>MDF Core</th>
</tr>
</thead>
<tbody>
<tr>
<td>Inner Stiles &amp; Rails</td>
<td>Timberstrand (width 43mm)</td>
<td>Continuous SCLC</td>
<td>Softwood Lumber (edge glued)</td>
<td>Continuous MDF</td>
</tr>
<tr>
<td>Stile &amp; Rail Options</td>
<td>Increase width up to 132mm</td>
<td>n/a</td>
<td>n/a</td>
<td>n/a</td>
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<tr>
<td>Hardware Blocking</td>
<td>Not required</td>
<td>Not required</td>
<td>Not required</td>
<td>Not required</td>
</tr>
<tr>
<td>STC Rating</td>
<td>36</td>
<td>Not tested</td>
<td>Not tested</td>
<td>Not tested</td>
</tr>
<tr>
<td>Weight (per ft$^2$) *</td>
<td>4.89</td>
<td>6.83</td>
<td>5.89</td>
<td>7.00</td>
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<tr>
<td>Lead lining option</td>
<td>yes</td>
<td>yes</td>
<td>no</td>
<td>yes</td>
</tr>
<tr>
<td>Advantages</td>
<td>Standard core for S/C flush doors. Relatively light in weight</td>
<td>Very strong and stable</td>
<td>Strength and toughness</td>
<td>Can be used for custom thicknesses, face reveals etc.</td>
</tr>
</tbody>
</table>

*calculated including hardboard cross banding for doors 1 ¾” thick. MDF core does not require cross banding.
Architectural Door Specifications

Stile & Rail Sketch Face Doors – Softwood Core

Materials:

- Stiles: Engineered softwood lumber extending the full height of the door
- Rails: Engineered softwood lumber.
- Cross banding: High density tempered hardboard or 48 lb. MDF, 3mm.
- Panels: Matching face veneer and solid edges (depending on type) on MDF core. Alternate is solid edge glued hardwood to match face veneers (edge glued hardwood panels do not meet AWI/AWMAC standards for Premium Grade)
- Finished edges: Solid lumber to match face veneers, 8mmX 44mm, bonded to stile and cross band.
- Trim & beading: Solid lumber to match face veneers

Construction:

Parveneer’s hybrid stile & rail door construction is a three step manufacturing process which achieves a cost effective product with superior strength, durability and stability. All Parveneer doors have a true AWI / AWMAC #I concealed edge (AWI Quality Standards 8th Edition, 1300-T-7)

- Solid lumber stiles and rails are assembled and glued into a traditional stile & rail door, using mortise & tenon or dowel joinery in accordance with AWI/AWMAC Quality Standards, Section 1400.
- Matching hardwood finished edges and hardboard cross bands are then bonded to the lumber core in a hot press.
- Calibration: The door blank is then sanded to achieve uniform thickness.
- Face veneers are manufactured from carefully selected flitch stock, allowing for stiles and rails to be grain and colour matched, and even sequenced for adjacent doors. These face veneers are applied to the door blanks in a second pressing stage.
- Finish sanding: 150 grit, ready for finishing.
- Machining: Parveneer doors may be machined for hardware according to customer specifications.

Factory Finishing:

Standard finish is catalyzed lacquer TR2. TR4 (conversion varnish) and TR6 (catalyzed polyurethane) also available. Custom stains and topcoats are spray applied and cured in a heated air convection oven.

Fire Ratings:

Parveneer doors as described above may carry a Warnock Hersey 20-minute label for either neutral or positive pressure applications. Maximum lite size – 1296 in². 45 and 60 minute rated doors are also available using fire rated mineral core.
Series 200 Softwood Core Wood Doors – Typical Elevation & Section for Flush Construction

Depending on the configuration, this can be a more economical alternative to the more standard engineered softwood stiles and rails with applied veneers. Centre of door can be open & beaded to receive glass, flat panel or raised panel. Please note that solid lumber door panels are not permitted in AWI/AWMAC Premium or Custom Grade doors.
Architectural Door Specifications

True Veneered Stile & Rail Doors – Softwood Core

Materials:

- Stiles: Engineered softwood lumber, plywood or MDF extending the full height of the door.
- Rails: Engineered softwood lumber, plywood or MDF.
- Cross banding: High density tempered hardboard or 48 lb. MDF, 3mm.
- Panels: Matching face veneer and solid edges (depending on type) on MDF core. Alternate is solid edge glued hardwood to match face veneers (edge glued hardwood panels do not meet AWI/AWMAC standards for Premium Grade)
- Finished edges: Solid lumber to match face veneers, 9.5mmX 44mm, bonded to stile and cross band.
- Trim & beading: Solid lumber to match face veneers

Construction:

Parveneer’s stile & rail door construction is a three step manufacturing process which achieves a cost effective product with superior strength, durability and stability. All Parveneer doors have a true AWI / AWMAC #1 concealed edge (AWI Quality Standards 8th Edition, 1300-T-7)

- Stiles and rails are banded with matching hardwood of sufficient thickness to accommodate required machining. They are then veneered both sides in a hot press.
- Raised panels are MDF framed with matching hardwood and then veneered both sides.
- Flat panels are veneered MDF
- Stiles, rails and panels are then assembled and glued into a traditional stile & rail door, using mortise & tenon or dowel joinery in accordance with AWI/AWMAC Quality Standards, Section 1400.
- Finish sanding: 150 grit, ready for finishing.
- Machining: Parveneer doors may be machined for hardware according to customer specifications.

Factory Finishing:

Standard finish is catalyzed lacquer TR2, TR4 (conversion varnish) and TR6 (catalyzed polyurethane) also available. Custom stains and topcoats are spray applied and cured in a heated air convection oven.

Fire Ratings:

Parveneer doors as described above may carry a Warnock Hersey 20-minute label for either neutral or positive pressure applications. Maximum lite size – 1296 in².
Parveneer’s engineered stile & rail doors combine the flexibility and design of stile & rail construction with the strength and stability of flush door construction. Joinery is mortise & tenon, loose tenon or dowel in accordance with AWI/AWMAC Section 1400-T-8. Centre of door can be open & beaded to receive glass, flat panel or raised panel. Please note that solid lumber door panels are not permitted in AWI/AWMAC Premium or Custom Grade doors.
Architectural Door Specifications

\textit{Sketch Face Simulated Stile & Rail Flush Doors}

Materials:

- Stiles: Laminated Timberstrand – 38mm X 43mm, running full length of the door
- Rails: Timberstrand – 38 mm x 43 mm
- Cross banding: High density tempered hardboard or 48 lb. MDF, 3mm.
- Core: 28 lb. medium density particleboard.
- Finished edges: solid lumber to match face veneers, 22mmX 45mm Parveneer “T” edge, bonded to stile and cross band.

Construction:

Parveneer’s door construction is a two step manufacturing process which achieves a true sanded and bonded five ply door with a true AWI / AWMAC #1 concealed edge (AWI Quality Standards 8\textsuperscript{th} Edition, 1300-T-7)

- Bonded core: Stiles, rails and cross bands are bonded to the core using a hot press. Matching hardwood edges are then installed prior to face veneering.
- Calibration: The door blank is then sanded to achieve uniform thickness.
- Face veneers are manufactured from carefully selected flitch stock. Sketch faces can be manufactured to a wide variety of configurations, including simulated stile and rail construction. Face veneers are applied to the door blanks in a second pressing stage.
- Finish sanding: 150 grit, ready for finishing.
- Machining: Parveneer doors may be machined for hardware according to customer specifications.

Factory Finishing:

Standard finish is catalyzed lacquer TR2. TR4 (conversion varnish) and TR6 (catalyzed polyurethane) also available. Custom stains and topcoats are spray applied and cured in a heated air convection oven.

Fire Ratings:

Parveneer flush doors as described above may carry a Warnock Hersey 20-minute label for either neutral (UL 10-B) or positive pressure (UL 10-C) applications. Maximum lite size – 1296 in\textsuperscript{2}. 45, 60 and 90-minute rated doors are also available, using fire rated mineral core, and are described in Fire Rated section.
Series 200 Sketch Face Wood Doors – Typical Elevation & Section for Flush Construction

Depending on the configuration, this can be a more economical alternative to the more standard engineered softwood stiles and rails with applied veneers. Centre of door can be open & beaded to receive glass, flat panel or raised panel. Please note that solid lumber door panels are not permitted in AWI/AWMAC Premium or Custom Grade doors.
Series 200 True Stile & Rail Wood Doors – Typical details for non-rated doors