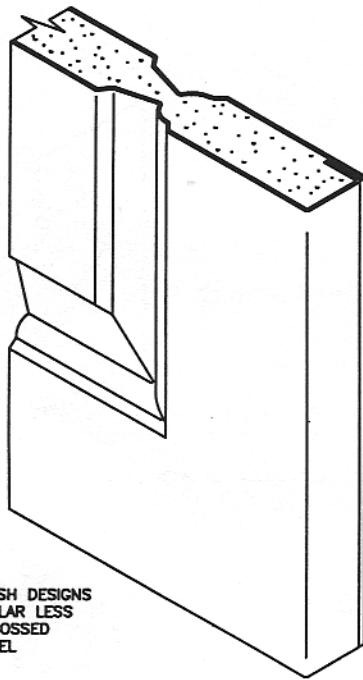




D3-1

1-3/4" IMPERIAL (IU) POLYURETHANE CORE FLUSH AND EMBOSSED PANEL STEEL DOORS BEVELED LOCK EDGE, HANDED



FLUSH DESIGNS
SIMILAR LESS
EMBOSSED
PANEL

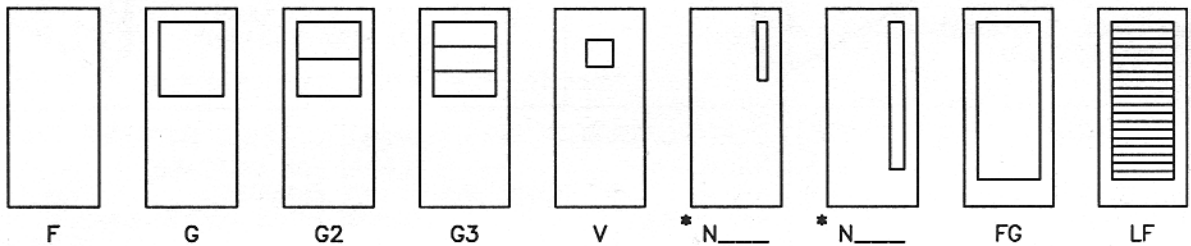
Full Flush or Seamless Style ...

Foamed-in-Place Polyurethane core fills entire door cavity. Core is chemically bonded to all interior surfaces. High impact resistance. Excellent insulation Characteristics.

Suggested Use:

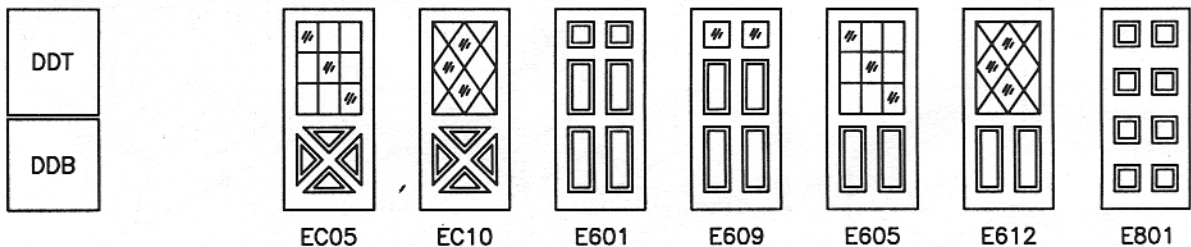
- Interior or Exterior ...*
- Motels/Hotels*
- Office Buildings*
- Urban Renewal*
- Health Care*
- Institutional*
- Data Processing*
- Mercantile*
- Food Processing*

FLUSH DESIGNS



* NARROW LITE TRIM KITS ARE AVAILABLE IN 6" AND 8" WIDTHS AND 36" TO 60" HEIGHTS IN 4" INCREMENTS.

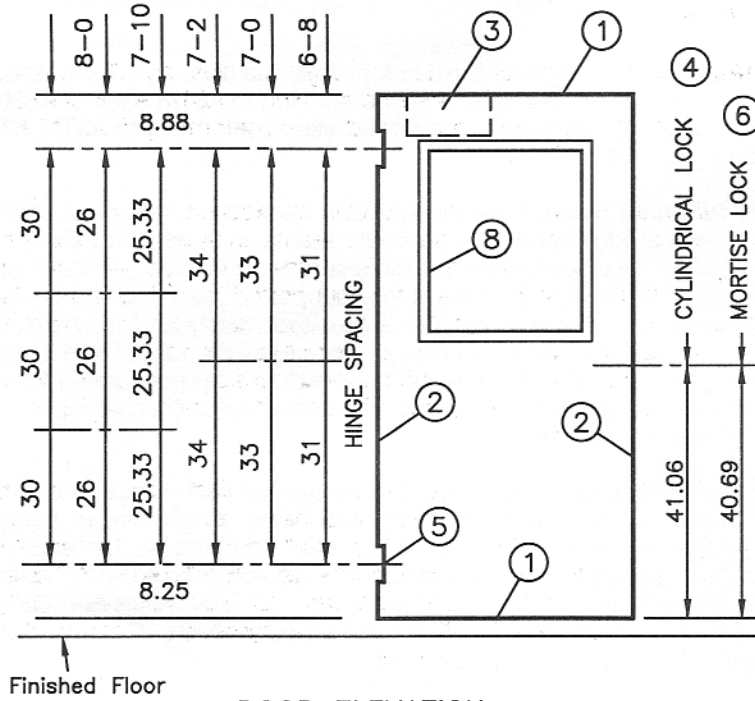
EMBOSSED PANEL DESIGNS



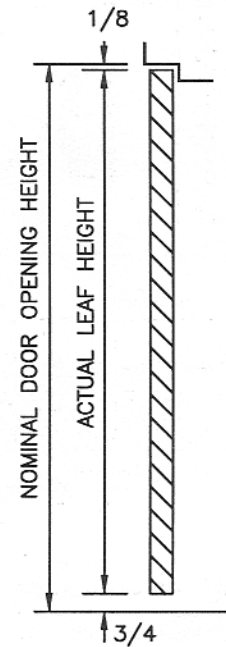
6/1/01

D3-2

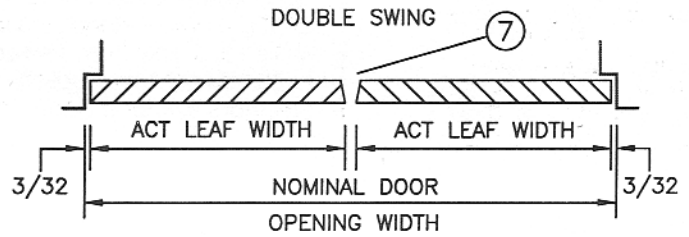
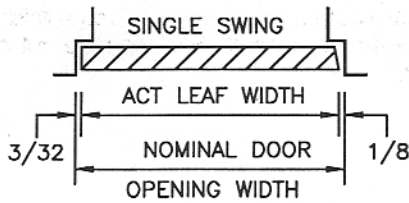
Hardware locations shown match Ceco standard frames.



DOOR ELEVATION



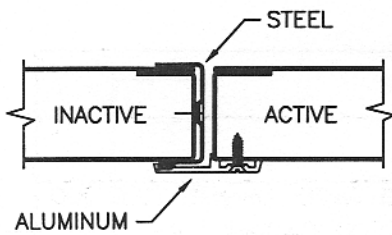
VERTICAL SECTION



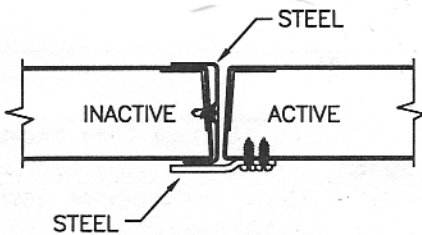
HORIZONTAL SECTIONS

(Conversion: 1" = 25.4 mm, e.g., 1-3/4" = 44.45 mm)

OVERLAPPING ASTRAGAL 4451
FOR 1-3/4" THICK DOORS WITH OPTIONAL POLY-PILE INSERT

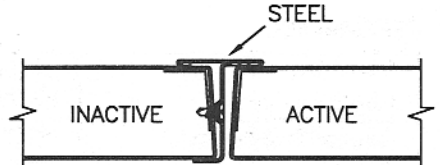


OVERLAPPING ASTRAGAL 4441
FOR 1-3/4" THICK DOORS



LISTED

OVERLAPPING ASTRAGAL 4471
FOR 1-3/4" THICK DOORS



LISTED

6/1/01



Ceco Door Products

TECH-DATA

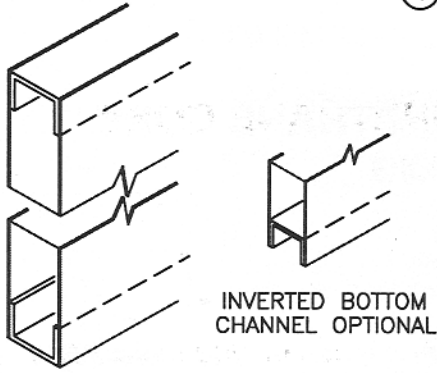
IMPERIAL DOORS

D3-3

16 GAGE STEEL END CHANNELS

WELDED TO DOOR

FLUSH TOP AND BOTTOM CHANNELS

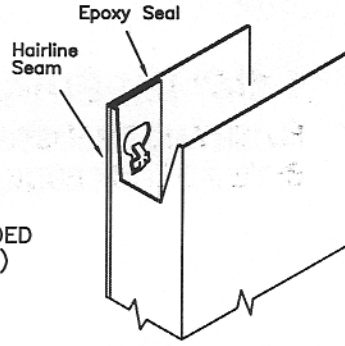


①

VERTICAL EDGES

MECHANICALLY INTERLOCKED HEMMED EDGES

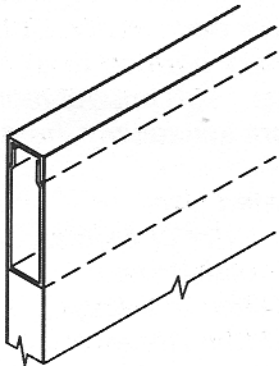
ALSO AVAILABLE SEAMLESS (WELDED OR BODY FILLER)



②

CLOSER REINFORCEMENT (OPTIONAL)

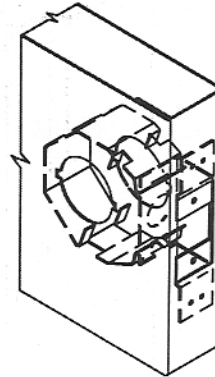
12 GAGE STEEL CHANNEL 16" LONG



③

LOCK PREPARATION GOV. 160/161 CYLINDRICAL TYPE

(LC1)
(ANSI A115.2)
2-3/4" BACKSET

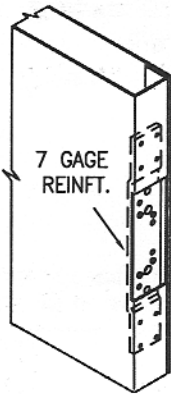


④

HINGE PREPARATION

4-1/2 OR 5 IN. HIGH, STANDARD OR HEAVY WEIGHT, FULL MORTISE HINGES

HINGE EDGE IS HANDED AND NOT BEVELED.



ANSI A156.7 TEMPLATE

⑤

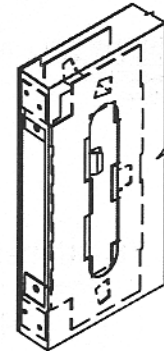
LOCK PREPARATION GOV. 86-4 MORTISE TYPE

(LM1) (ANSI A115.1)
2-3/4" BACKSET

(LM0) SIMILAR TO DETAIL LESS FACE CUTOUT

(LP0) SIMILAR TO DETAIL LESS ALL CUTOUTS AND REINFORCEMENT

LOCK EDGE IS BEVELED 1/8" IN 2" (1:16)

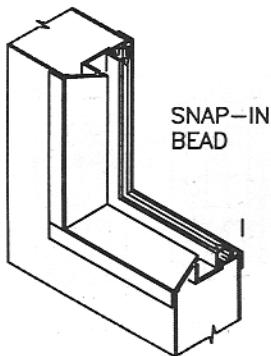


⑥

GLAZING TRIM 4831 FOR STANDARD FLUSH DOORS

ALUMINUM

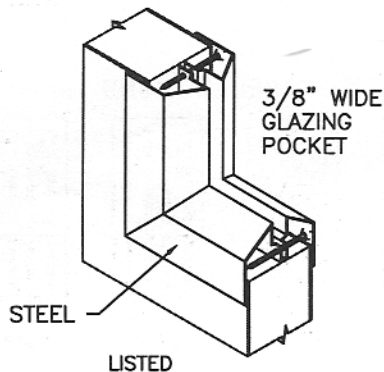
3/8" WIDE GLAZING POCKET



⑦

GLAZING TRIM SlimTrim FOR ALL FIRE DOORS

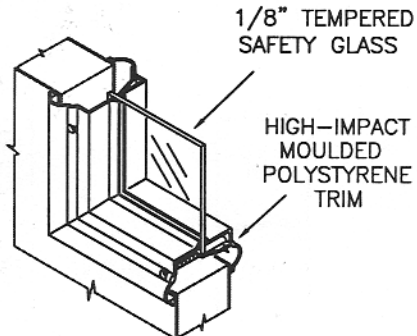
STEEL LISTED



⑧

GLAZING SYSTEM FOR STANDARD EMBOSSED PANEL DOORS

1/8" TEMPERED SAFETY GLASS



⑧

6/1/01



Ceco Door Products

D3-4

STANDARD SIZES NOMINAL DOOR OPENING

| WIDTH | | HEIGHT |
|--------|--------|---|
| SINGLE | DOUBLE | |
| 2'-0" | 4'-0" | 6'-8" 7'-0" 7'-2" 7'-10" 8'-0" 9'-0" |
| 2'-4" | 4'-8" | |
| 2'-6" | 5'-0" | |
| 2'-8" | 5'-4" | |
| 2'-10" | 5'-8" | |
| 3'-0" | 6'-0" | |
| 3'-4" | 6'-8" | |
| 3'-6" | 7'-0" | |
| 3'-8" | 7'-4" | |
| 3'-10" | 7'-8" | |
| 4'-0" | 8'-0" | |

SIZE LIMITS - DESIGNS

| | FLUSH DESIGN | 6 PANEL | 8 PANEL | CROSS BUCK & LITES |
|------|--------------|---------|---------|--------------------|
| MAX. | 4090 | 4070 | 3070 | 3070 |
| MIN. | 2068 | 2668 | 2868 | 2868 |

E6 and EB designs: mortise lock preparation limited to 3'-0" width, minimum.

FIRE DOORS

| | |
|--|--|
| LABELING AGENCY: WARNOCK HERSEY | |
| TEST: ASTM E-152, UL10B, UBC 43-2 | |
| • DESIGNS: F, G, N, V, E6, OR EB | |
| • RATING: (20 GAGE) 3/4 HR. OR 1-1/2 HR. | |
| MAX. SIZE: 40 x 80 SINGLE 80 x 80 PAIR | |
| • RATING: (18 & 16 GAGE) 3/4 HR, 1-1/2 HR. OR 3 HR. | |
| MAX. SIZE: 40 x 90 SINGLE 80 x 90 PAIR | |

PRODUCT SPECIFICATIONS:

1-3/4" Thick steel doors shall be as manufactured by Ceco Door Products, Milan, TN USA. Doors shall conform to the Steel Door Institute guide specification, ANSI A250.8-1998; see chart below for performance classifications.

IMPERIAL doors are made full-flush or (optional) seamless style. Faces sheets are commercial quality cold rolled steel conforming to ASTM A366 or A620 & A568 ...or (optional) hot-dipped galvanized steel conforming to ASTM A924 and A653 -- see chart below.

Imperial full-flush doors have mechanically interlocked, hemmed, hairline seams on vertical edges and have no visible seams on faces (S.D.I. Design I). Doors specified "seamless" have no visible seams on faces or vertical edges (S.D.I. Design II). Face sheets are totally supported by a foamed-in-place polyurethane core. The core fills the entire door cavity and is chemically bonded to all interior surfaces. Density of foam exceeds 1.8 pcf and it has a crush strength of 3600 psf. The top and bottom door edges are closed flush by 16 gage steel channels welded in place. The bottom edge channel can also be installed inverted (optional).

Hardware Provisions: Hinge preparations are handed. Hinge edges are mortised for 4-1/2" or 5" high, standard and heavy weight hinges (specify which). 7 gage steel hinge reinforcements are welded inside the door edge and are drilled and tapped for fasteners in accordance with ANSI A156.7. The lock edge has a standard bevel (1:16) and is prepared for Gov. series 86, 160/161, or 90 locks in accordance with ANSI A115 (specify which). Optional closer reinforcement is a 12 gage steel channel.

Paint: 1-3/4" steel doors shall be provided with one coat of oven-cured neutral color primer paint. Primer coat shall conform with ANSI A250.10. The primer coat is a preparatory base for necessary finish painting. "Colorstyle" finish coat is also available from a selection of standard colors (optional). Colorstyle finish is electrostatically applied, oven-cured urethane enamel. For accurate color selectors ask for a Ceco Colorstyle chart.

MATERIAL

| DOOR FACE SHEETS | GRADE | C.R. | GALV | | RECOMMENDED DOOR FRAME MATERIAL |
|---------------------------|------------------|------|------|-----|---------------------------------|
| | | | A60 | G90 | |
| 20 Gage Steel (4080 max.) | Standard Duty | STD | OPT | - | 16 Gage Steel |
| 18 Gage Steel | Heavy Duty | STD | OPT | OPT | 16 Gage Steel |
| 16 Gage Steel | Extra heavy Duty | STD | OPT | OPT | 16 or 14 Gage Steel |

PERFORMANCE

| | |
|-------------------------------|--|
| Core Thermal Characteristics: | U Factor: 0.067 R Factor: 14.97 |
| Sound Transmission Class: | STC 26 (F Design, 18 Gage Face Sheets, ASTM E90-81 & E413-73 [Fully Operable]) |
| Physical Endurance Level: | Meets ANSI A 151.1 Performance Test, 20 GAGE: Level B (500,000 Cycles); 18 and 16 Gage: Level A (1,000,000 Cycles) |



Ceco Door Products

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