

1300-T-5

Glass and Glazing

In the absence of specifications, the following standards will apply. Where more than one method or material is listed for a Grade, woodworkers will supply their choice from the alternatives.

Glass/Glazing	Premium	Custom	Economy
Wood Moulding Glass Stop	Plant prepared and bundled in sets appropriately labeled for the jobsite	Plant prepared and bundled in sets appropriately labeled for the jobsite	Shipped loose without preparation
Type, thickness, and manufacturer of glass, particularly insulated glass, must be specified as its construction dictates details of the receiving members. Specifications regarding code compliance are the responsibility of the design professional.			
In the absence of specifications, profile of stop shall be mill option.			
It is recommended that the following be included in the painting section of the specifications: "To create the proper seal against weather, wind, and rain, the finish coats of all doors should be allowed to flow onto the glass area at least 1.6 mm [1/16"]. When cleaning the glass, a razor blade should not be used to scrape the glass. This will destroy the seal. A broad blade putty knife should be used to protect the seal between the glass and the wood."			

1300-T-6

Vertical and Horizontal Edge Interface with Core Components

The architect/specifier is required to make a core interface selection depending upon the application. There are two types of interface between the core and the edges in solid core doors:

A. PC or SLC or SCLC: Bonded: Vertical and horizontal edges of solid and fire resistant core doors must be securely bonded to the core with adhesives and then abrasive planed before veneering to ensure minimal telegraphing of core parts through veneers or overlay.

B. FPC or FSLC or FSCLC: Nonbonded: Vertical and horizontal edges are not bonded to the core. The maximum gap between core and vertical and horizontal edges to be 0.8 mm [$1/32$ "]. Component size thickness tolerance is ± 0.13 mm [.005"] to ensure minimal telegraphing of core parts through veneers or overlay and adequate veneer bonding to core components. In this construction the components that compose the face of the door, whether 5-ply or 7-ply, serve to hold the core components.

C. Prevailing Standard: In the absence of specifications Bonded Core shall be required for Premium and Custom Grade.

Thickness of Vertical Edges after Factory Prefit (prior to installation fitting, if any)

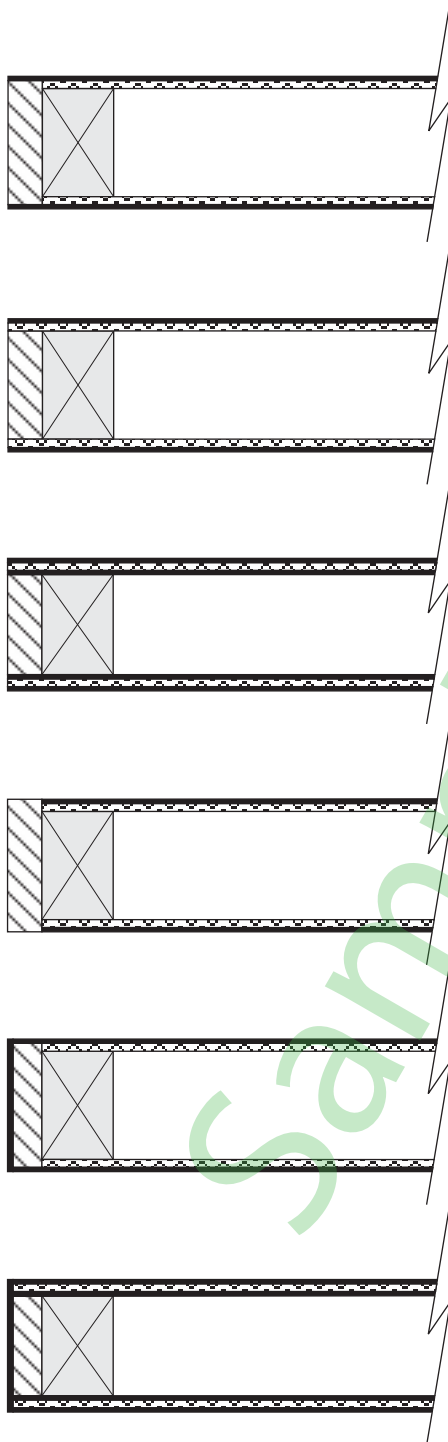
Door Type	Lock Stile	Hinge Stile	Top Rail	Bottom Rail
Solid Core - Stave Lumber Core	9 mm [$3/8$ "]	9 mm [$3/8$ "]	9 mm [$3/8$ "]	9 mm [$3/8$ "]
Solid Core - Other Cores	20 mm [$13/16$ "]	24.5 mm [1"]	20 mm [$13/16$ "]	20 mm [$13/16$ "]
Hollow Core - 35 mm [$1-3/8$ "]	20 mm [$13/16$ "]	24.5 mm [1"]	32 mm [$1-1/4$ "]	32 mm [$1-1/4$ "]
Hollow Core - 44 mm [$1-3/4$ "]	20 mm [$13/16$ "]	24.5 mm [1"]	32 mm [$1-1/4$ "]	32 mm [$1-1/4$ "]
<i>Note: Data above consistent with and used by permission of the Woodwork Institute of California (WIC) April 2002</i>				
Fire-rated (labeled) Doors	Sizes and engineering determined by the rating agency			
Sound Retardant	Consult manufacturers' data sheets for design and specification requirements. Establishment of the need and details is the responsibility of the design professional.			
Establishment of the need and details is the responsibility of the design professional.				
Lead Lined				
Ballistic Resistant				
Electrostatic Shielded				



1300-T-7

Door Edge Details

In the absence of specifications, where more than one method or material is listed, woodworkers will supply their choice from the alternatives. All edges must conform to standards and comply with tests for telegraphing and warp. All edge types are not available from all door manufacturers.



#1 Edge: 5-ply door, abrasive planed before veneering, with the edge of the veneer but not the edge of the crossband exposed. Not available in all areas.

#2 Edge: 5-ply door, abrasive planed before veneering, with the edge of the veneer and the crossband exposed.

#3 Edge: 7-ply door, abrasive planed before veneering, with the edges of the 3-ply face veneer and crossbands exposed.

#4 Edge: 5-ply or 7-ply door banded with a solid hardwood trim strip such that the joint shows on the face of the door.

#5 Edge: 5-ply door with the vertical edge veneered to match or contrast with the face as specified.

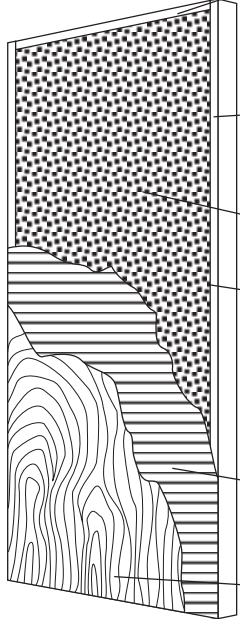
#6 Edge: 7-ply door with the vertical edge veneered to match or contrast with the face as specified.



1300-T-8

Veneer, Bonded Particle Core

PC-5
8th edition



Top and Bottom Horizontal Edge: 20.6 mm [13/16"] minimum wood after factory fitting, one piece or laminated without voids or show-through (telegraphing) [SCL permitted for interior use only when installed with compressed face exposed; MDF not permitted]

Vertical Edge: Lock stile=20.6 mm [13/16"] & Hinge stile=24.5 mm [1"] minimum hardwood; solid, laminated or veneered, after factory fitting. SCL allowed under hardwood in lamination.

Core: Particleboard, ANSI A208.1, grade LD-1 or LD-2

Bonding: Stiles and rails securely bonded to core, then entire unit abrasive planed before veneering

Veneer Back (7-ply doors)

Crossband: Edge glued or one-piece wood or high performance composite product, without voids or show-through (telegraphing)

Veneer Face

PC-7
8th edition



Criteria	Premium	Custom	Economy
Veneer face	"AA" grade, edge glued joints	"A" grade, edge glued joints	"B" grade, edge glued joints
Veneer match	Book, slip or random Center Balanced Pair and set match Door and transom end or continuous matched	Book, slip or random Running Pair match Door and transom end or continuous matched	Mill option
Vertical edges	Same species and grade as face, lumber or veneer over hardwood (ME); sanded ease No visible joints allowed	Same species as face, lumber or veneer (ME); or compatible hardwood (CE); sanded ease Visible joints allowed on hinge edge	Mill option; sanded ease Visible joints allowed
Lights, louvers and mouldings	Same species and grade lumber, or veneered, or metal vision frames	Compatible species lumber or metal vision frames	Mill option
Transoms	Bottom horizontal edge runs full width. Matching species and grade lumber or veneered	Bottom horizontal edge runs full width. Compatible species lumber or veneered	Mill option

NOTE: Label rating is available in any grade, subject to fabrication under label agreement.

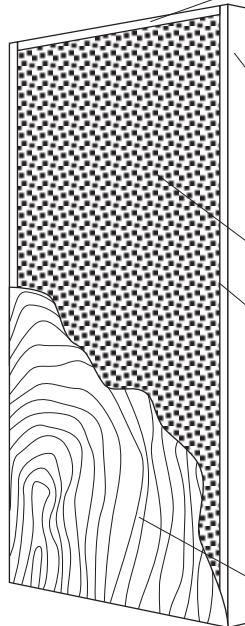
Label	Door Symbol	Rating	Wall Rating
20-minute	FD 1/3	1/3 hour	1 hour

NOTES: Veneer match in excess of Standards must be specified. Maple edges allowed for Natural and White Birch. Core and edge requirements also apply to 20-minute rated doors. Light openings in 20-minute doors allowed up to size tested by manufacturer. Louvers not allowed in 20-minute doors. 9-ply doors are available and should be evaluated and specified or approved by the design professional when desired. In the absence of specifications the manufacturer may choose from the alternatives within or above the Grade.

1300-T-9

High Pressure Decorative Laminate (HPDL), Bonded Particle Core

PC-HPDL-3
8th edition



Top and Bottom Horizontal Edge: 20.6 mm [13/16"] minimum wood after factory fitting, one piece or laminated without voids or show-through (telegraphing) [SCL permitted for interior use only when installed with compressed face exposed; MDF not permitted]

Vertical Edge: Lock stile=20.6 mm [13/16"] & Hinge stile=24.5 mm [1"] minimum hardwood; solid, laminated or veneered, after factory fitting. SCL allowed under hardwood in lamination.

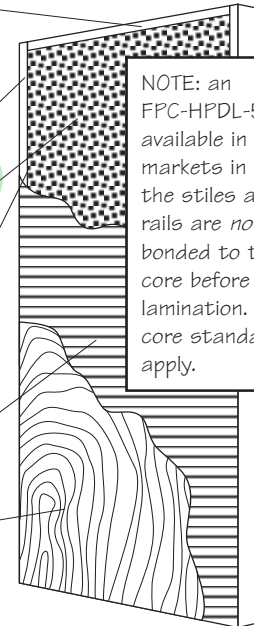
Core: Particleboard, ANSI A208.1, grade LD-1 or LD-2

Bonding: Stiles and rails securely bonded to core, then entire unit abrasive planed before laminating

Crossband: Edge glued or one-piece wood or high performance composite product, without voids or show-through (telegraphing)

Laminate Face

PC-HPDL-5
8th edition



NOTE: an FPC-HPDL-5 is available in some markets in which the stiles and rails are not bonded to the core before lamination. FPC5 core standards apply.

Criteria	Premium	Custom	Economy
Laminate face	HGS (nominal 0.048") high pressure decorative laminate; continuous door and transom match, material permitting	HGS (nominal 0.048") high pressure decorative laminate; continuous door and transom match, material permitting	HGS (nominal 0.048") high pressure decorative laminate; Mill Option door and transom match.
Vertical edges for wood grain patterns	Matching HGS laminate, or finished matching species lumber or veneer to blend with face; no visible joints allowed	Matching HGS laminate, or finished compatible lumber or veneer; no visible joints allowed	Mill option
Vertical edges for solid colors	Matching HGS laminate or close grain hardwood painted to match; no visible joints allowed	Matching HGS laminate or close grain hardwood painted to blend; visible joints allowed on painted hinged edge only	Mill option
Lights, louvers, and mouldings for wood grain patterns	Matching species, lumber or veneer with transparent finish, or painted metal vision frame or louver	Compatible species lumber or veneer for finishing or primed metal vision frame or louver	Mill option
Lights, louvers, and mouldings for solid colors	Matching HGS laminate, or close grain hardwood with paint finish, or painted vision frame or louver to match	Matching HGS laminate, or close grain hardwood for paint finish, or primed vision frame or louver	Mill option
Transom bottom horizontal edges for wood grain patterns	Matching HGS laminate, or matching species lumber or veneer with transparent finish to blend with face	Matching HGS laminate, or compatible lumber or veneer for transparent finish	Mill option
Transom bottom horizontal edges for solid colors*	Matching HGS laminate or close grain hardwood painted to match; no visible joints allowed	Matching HGS laminate, or matching species lumber or veneer for transparent finish; no visible joints allowed	Mill option

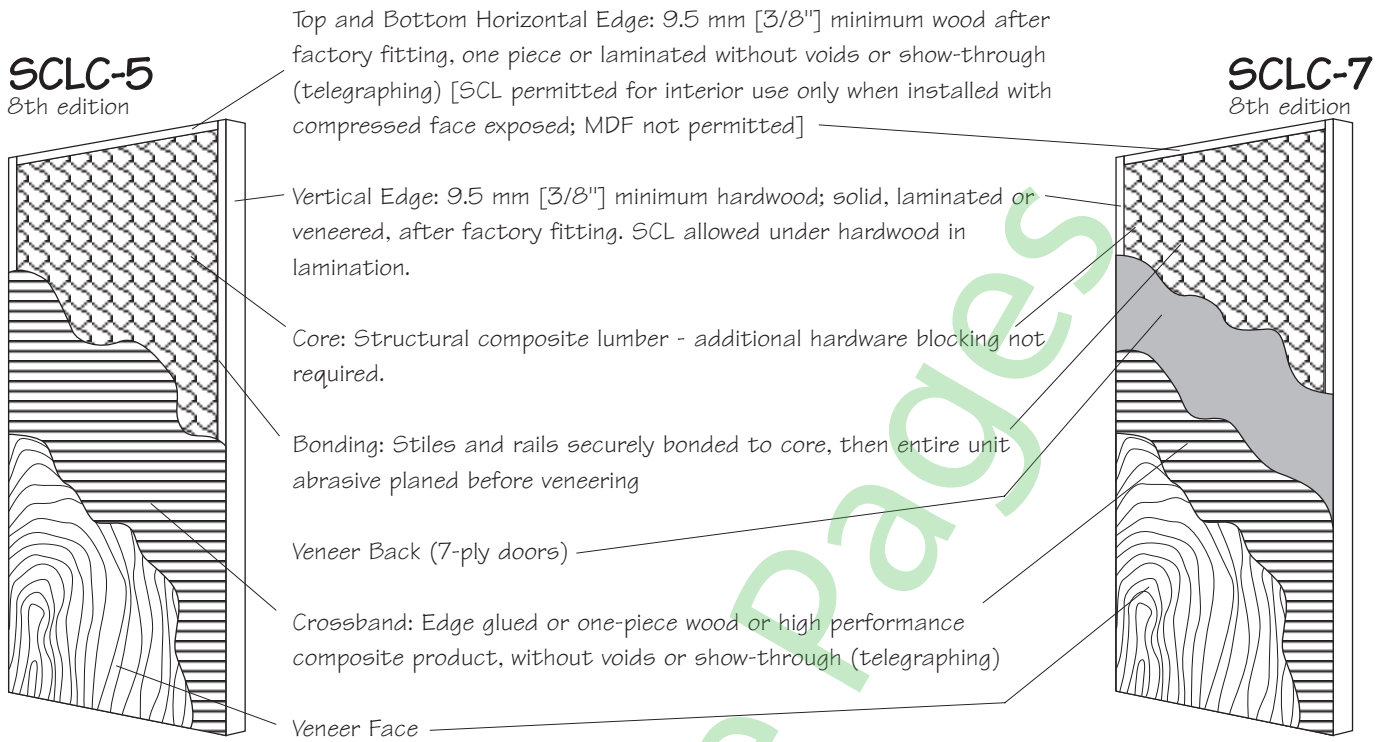
NOTE: Label rating is available in any grade, subject to fabrication under label agreement.

Label	Door Symbol	Rating	Wall Rating
20-minute	FD 1/3	1/3 hour	1 hour

NOTES: Pair matching not available. Species, color, and finishing for entire wood and/or metal trim package to be specified. Core and edge requirements also apply to 20-minute rated doors. Light openings in 20-minute doors allowed up to size tested by manufacturer. Louvers not allowed in 20-minute doors. 9-ply doors are available and should be evaluated and specified or approved by the design professional when desired. * Includes other non-wood grain patterns.

1300-T-10

Veneer, Bonded Structural Composite Lumber Core



Criteria	Premium	Custom	Economy
Veneer face	"AA" grade, edge glued joints	"A" grade, edge glued joints	"B" grade, edge glued joints
Veneer match	Book, slip or random Center Balanced Pair and set match Door and transom end or continuous matched	Book, slip or random Running Pair match Door and transom end or continuous matched	Mill option
Vertical edges	Same species and grade as face, lumber or veneer over hardwood (ME); sanded ease No visible joints allowed	Same species as face, lumber or veneer (ME); or compatible hardwood (CE); sanded ease Visible joints allowed on hinge edge	Mill option; sanded ease Visible joints allowed
Lights, louvers and mouldings	Same species and grade lumber, or veneered, or metal vision frames	Compatible species lumber or metal vision frames	Mill option
Transoms	Bottom horizontal edge runs full width. Matching species and grade lumber or veneered	Bottom horizontal edge runs full width. Compatible species lumber or veneered	Mill option

NOTE: Label rating is available in any grade, subject to fabrication under label agreement.

Label	Door Symbol	Rating	Wall Rating
20-minute	FD 1/3	1/3 hour	1 hour

NOTES: Veneer match in excess of Standards must be specified. Maple edges allowed for Natural and White Birch. Core and edge requirements also apply to 20-minute rated doors. Light openings in 20-minute doors allowed up to size tested by manufacturer. Louvers not allowed in 20-minute doors. 9-ply doors are available and should be evaluated and specified or approved by the design professional when desired. In the absence of specifications the manufacturer may choose from the alternatives within or above the Grade.



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With over forty years of evolutionary history behind our new *8th Edition*, it represents the culmination of five years of hard work and thousands of AWI Member volunteer's hours with input and support from our related industry association partners. Our sincere thanks go to those volunteers and organizations that made the *8th Edition* possible; without their dedication it would not be a reality.

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