

Date: 04/06/2018

Revision: 15



General Product & Quality Specification

Moulded Skin Doors

Introduction:

Moulded skin doors are widely specified, and have been suitably developed and designed for internal use only. They should not be exposed or installed into damp ambient conditions, including where wet trades have been recently active. Standard doors are supplied with a white acrylic base coat to both faces of the door (RAL 1013), and must be fully finished during installation. Primed and/or Fully Finished options are available, using a Satin White (RAL 9003), water based paint to both faces ONLY. White Edge banding to the vertical edges is available, width tolerance is unchanged.

Environmental Certification:

Moulded skin doors are manufactured under the formally audited Environmental Standard BS EN ISO 14001. In addition, particularly for use within “sustainable” projects, hollow core doors carry full Chain of Custody compliance, FSC (SW – CoC 006285). Similarly, FD30 Fire doors and the Safe and Sound range are Chain of Custody controlled against PEFC certification (SGS-PEFC/CoC 0090).

Dimensional tolerances apply as follows:

	Tolerance EN1529	Measurement Method
Width	+/- 1.5mm	EN 951
Length	+/- 1.5mm	EN 951
Thickness	+/- 1.0mm	EN 951
Squareness	1.5mm	EN 951
Tolerance EN1530		
Twist	8mm	EN 952
Bow	8mm	EN 952
Cup	4mm	EN 952
Local Flatness	0.4mm	EN 952

Quality:

Manufacture is controlled against a formal quality management system, ISO 9001. At supply, door faces and edges will be visibly defect free, when viewed from 2 meters distance. The moisture content of timber components is critically controlled in line with the industry norm, based on BS EN 942. Door faces will not exceed 8%-12% moisture content at time of despatch. Details of applicable product warranties, including qualifying terms and conditions, are available from the current Premdor Range Guide or website. Alternatively contact Premdor’s Technical or Sales Team for specific guidance.

Packaging and Product Identification:

Doors are clear plastic wrapped for surface protection, with added cardboard inserts to glazed types according to design. A Product Code or ID is ink marked on the doors top edge, together with lock side indicator if relevant.

Fire doors:

FD30 products carry a uniquely numbered identification label applied to the top door edge, indicating compliance with type testing under BS 476 Part 22. All Moulded fire doors are also BWF Certifire accredited. This tamper proof label should not be altered or removed, even after installation.

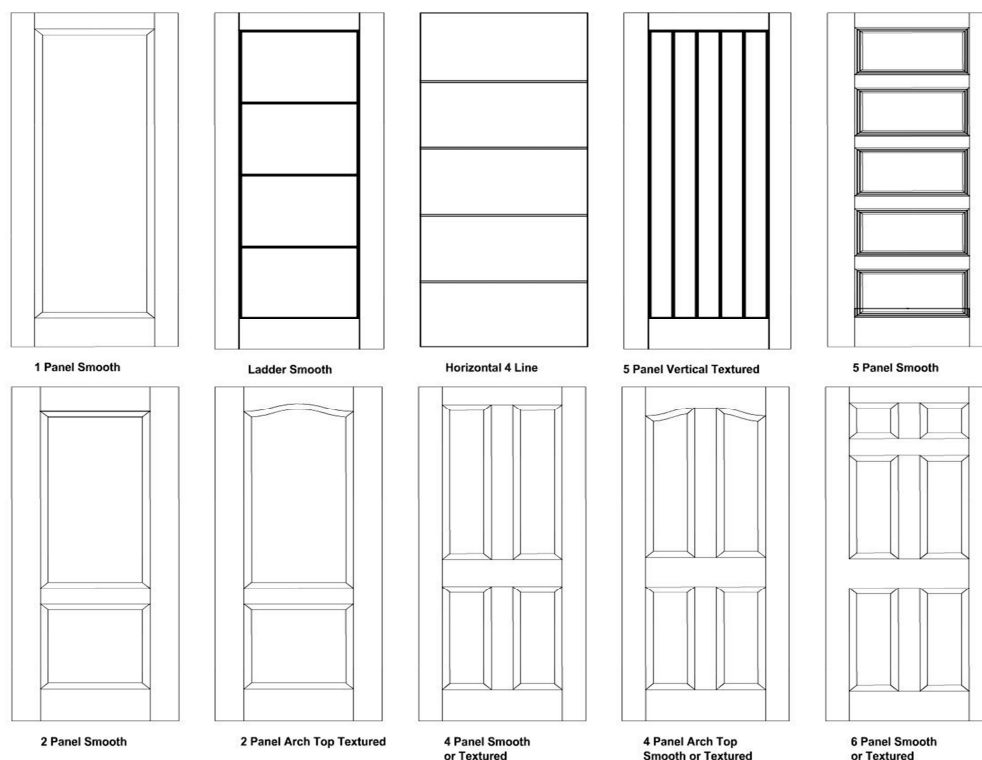
Glazed doors:

Factory glazed doors incorporate toughened safety glass to the requirements of BS EN 12600. Panes are discreetly marked accordingly, typically at a corner point of the glass. Glass is suitably bedded and beads are securely fixed. Apertures must not be added to fire doors retrospectively except under specific Premdor approval and BWF Certifire compliance.

Constructional specification:

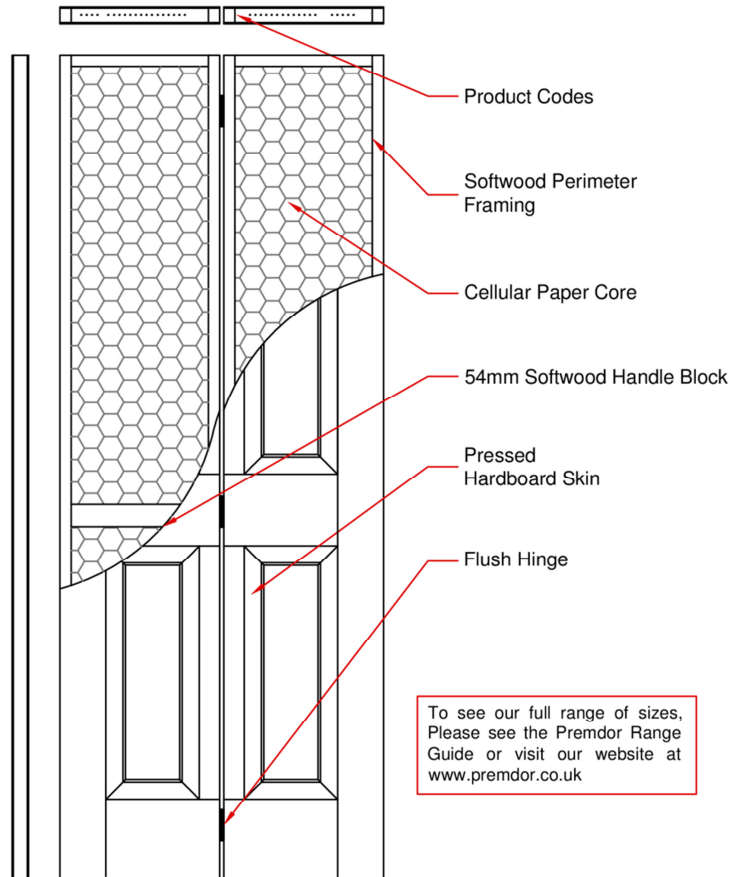
This document contains standard product drawings with, optional core constructions, door weights, and a product summary of the moulded pressed panel range see Annex A, or contact Premdor for more information.

Every effort has been made to ensure the accuracy of this information. In the interest of continuing design development however we reserve the right to modify specifications without prior notice and without incurring any obligation.

FACE DESIGN OPTIONS

General Product & Quality Specification

Standard / Hollow Core Moulded Skin Door



Bi-Folding (Hollow) Core Moulded

Assembly Components (Size pre-trim)

Perimeter Framing (Whitewood):	28 x 28mm (35mm Imperial Doors)*
Full Width Lock Block (Whitewood):	54 x 28mm (35mm Imperial Doors)*
Typical door weight	14kgs (762mm x 1981mm)
Maximum edge trim	5mm of All Edges

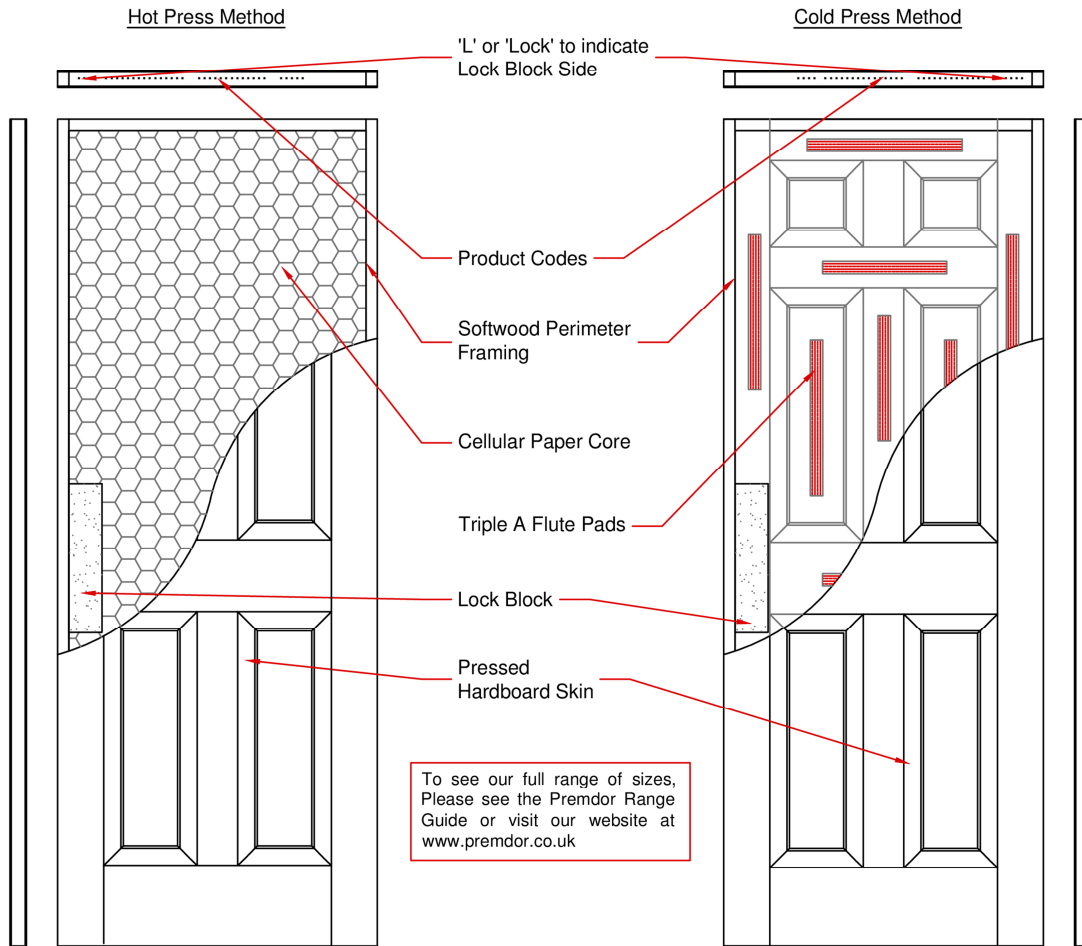
Sizes shown in the catalogue are aperture sizes, and the door will be supplied 1939mm high to accommodate the supplied tracking mechanism. Bi-Folding doors are supplied complete with tracking mechanism.

Full Width Lock block positioned 880mm from top of door (54mm long).

*Size subject to manufacturing trim, after door assembly.

General Product & Quality Specification

Standard / Hollow Core Moulded Skin Door



Standard (Hollow) Core Moulded

Assembly Components (Size pre-trim)

Perimeter Framing (Whitewood):

28 x 28mm (35mm Imperial Doors)*
 28 x 33mm (40mm Metric Doors)*
 28 x 38mm (44mm Imp/Met Doors)*

Lock Block one side (Particleboard):

65 x 28mm (35mm Imperial Doors)
 65 x 33mm (40mm Metric Doors)
 65 x 38mm (44mm Imp/Met Door)

Typical door weight

14kgs (762mm x 1981mm)

Maximum edge trim

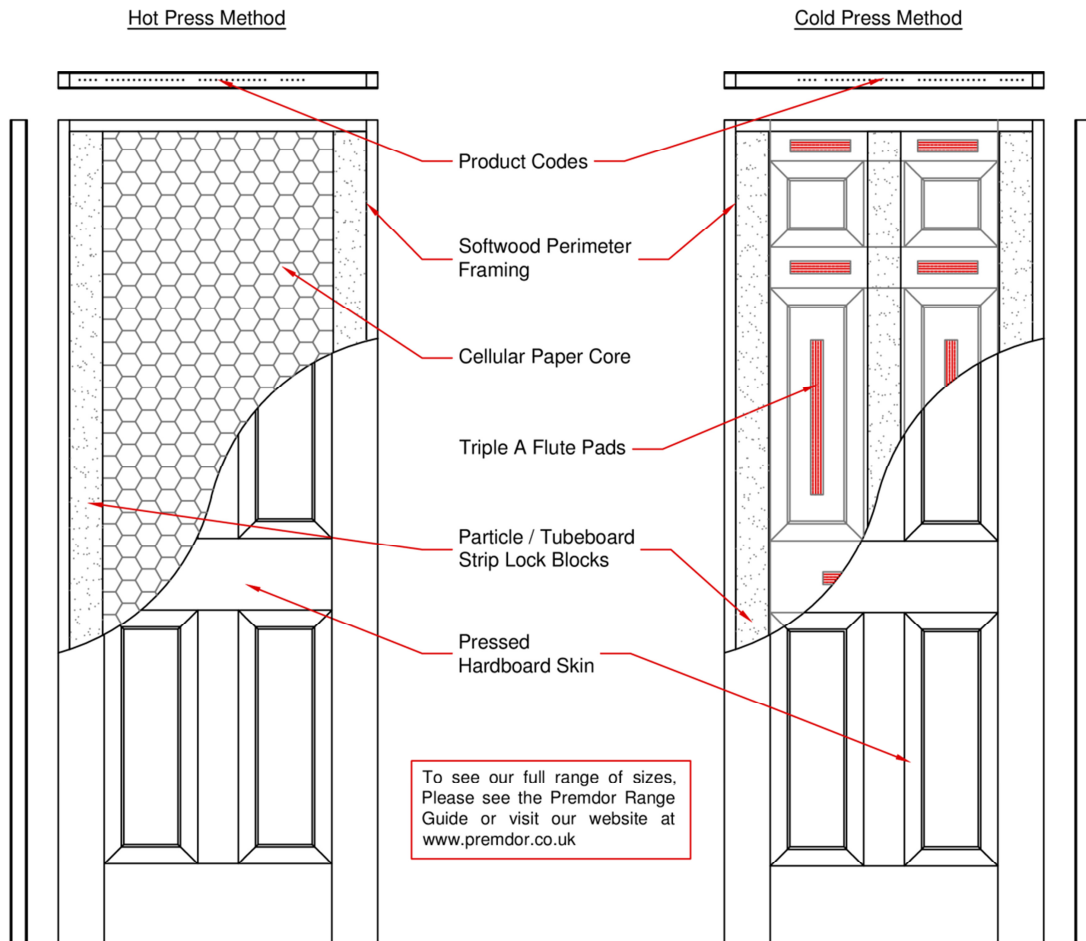
5mm of All Edges

Lock block positioned one side, 880mm from top of door (360mm long). Checking Ink jetting for handing.

*Size subject to manufacturing trim, after door assembly.

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Semi-Solid Core Moulded Skin Door



Semi-Solid Core Moulded

Assembly Components (Size pre-trim)

Perimeter Framing (Whitewood):

28 x 28mm (35mm Imperial Doors)*
28 x 33mm (40mm Metric Doors)*

Lock Block full height both sides:

54/72 x 28mm (35mm Imperial Doors)
54/72 x 33mm (40mm Metric Doors)

Typical door weight

18kgs (762mm x 1981mm)

Maximum edge trim

5mm of All Edges

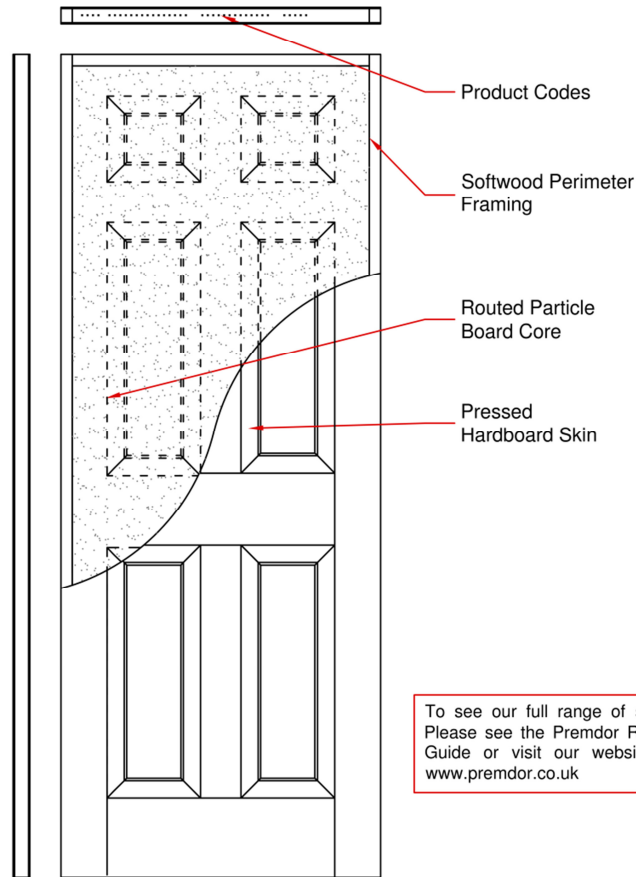
Lock block positioned both sides. Particle / Tubeboard strip running the full height of the door.

*Size subject to manufacturing trim, after door assembly.

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General Product & Quality Specification

Safe'N'Sound Core Moulded Skin Door



To see our full range of sizes,
Please see the Premdor Range
Guide or visit our website at
www.premdor.co.uk

Safe'N'Sound Core Moulded

Assembly Components (Size pre-trim)

Perimeter Framing (Whitewood):

Stile, 28 x 38mm (35mm Imperial Doors)*
Rail, 28 x 27.3mm (35mm Imperial Doors)*

Stile, 34 x 38mm (40mm Metric Doors)*
Rail, 34 x 27.3mm (40mm Metric Doors)*

Typical door weight

28kgs (762mm x 1981mm)

Maximum height edge trim

5mm of Top & Bottom

Maximum width edge trim

12mm of Each Long Edge

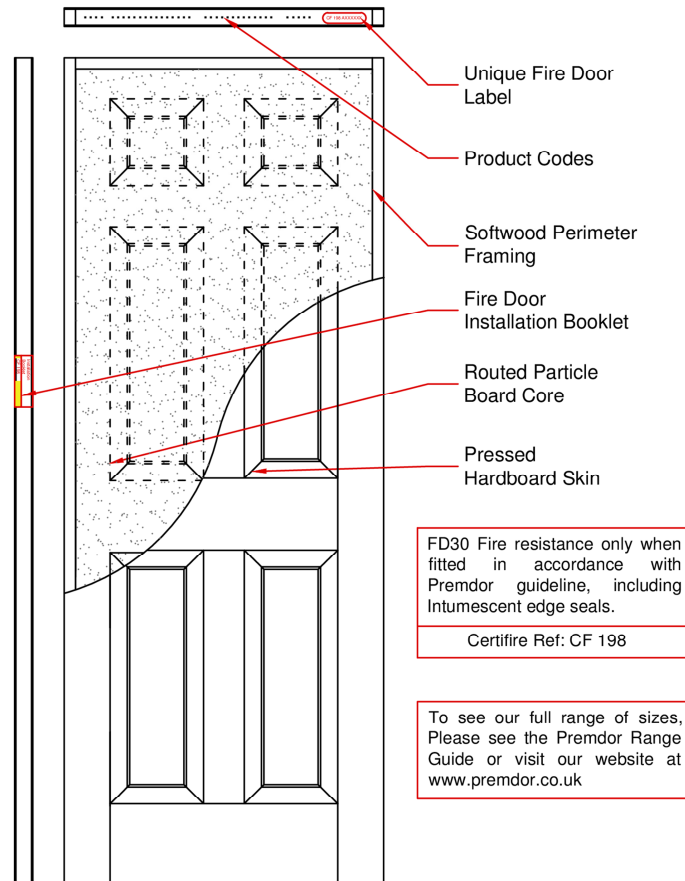
Lock fixing position directly into the core.

*Size subject to manufacturing trim, after door assembly.

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Fireshield Moulded Skin Door - (FD30)



Fireshield FD30 Core Moulded

Assembly Components (Size pre-trim)

Perimeter Framing (Whitewood):	38 x 38mm (44mm Imp/Met Doors)*
Typical door weight	36kgs (762mm x 1981mm)
Maximum Top edge trim	No top trim allowed.
Maximum Bottom edge trim	10mm
Maximum Long edge trim	10mm

Lock fixing position directly into the core.

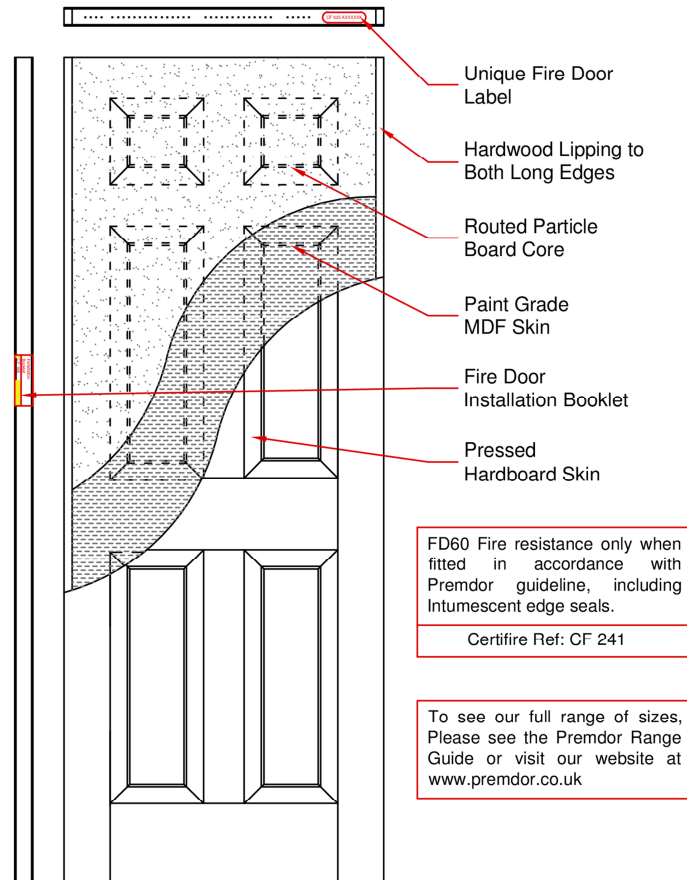
*Size subject to manufacturing trim, after door assembly.

All Fire Certification Documents freely available for download from;

<http://www.premdor.co.uk/downloads/fire-certificates>

General Product & Quality Specification

Firemaster Moulded Skin Door - (FD60)



Firemaster FD60 Core Moulded

Assembly Components (Size pre-trim)

Vertical Edge Lipping (Hardwood):	19mm (54mm Imp/Met Doors)*
Typical door weight	58kgs (762mm x 1981mm)
Maximum Top edge trim	No top trim allowed.
Maximum Bottom edge trim	Unrestricted
Maximum Long edge trim	3mm

Lock fixing position directly into the core.

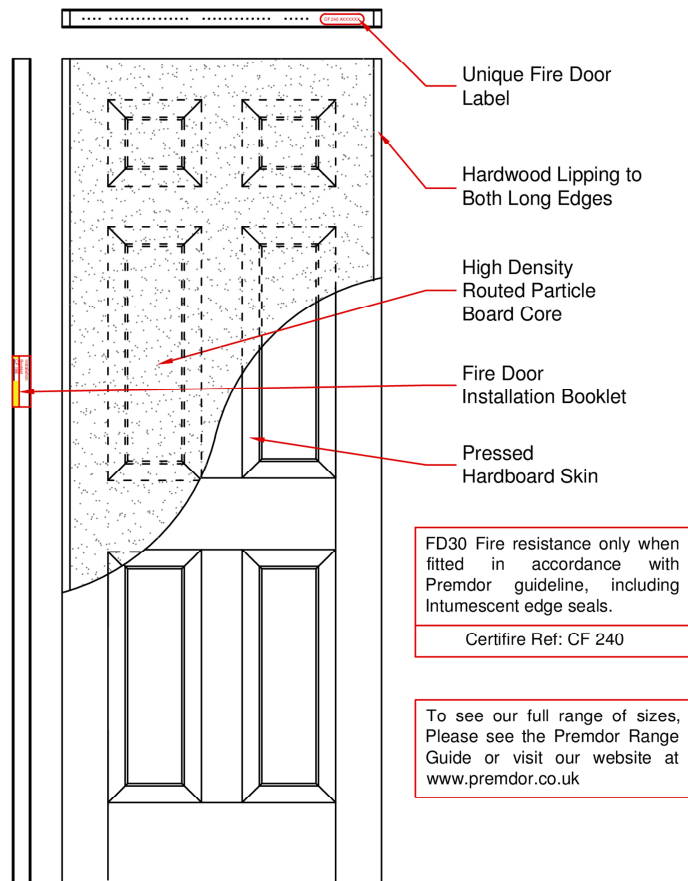
*Size subject to manufacturing trim, after door assembly.

All Fire Certification Documents freely available for download from;

<http://www.premdor.co.uk/downloads/fire-certificates>

General Product & Quality Specification

Fireshield SoundSure Moulded Skin Door - (FD30)



SoundSecure FD30 Core Moulded

Assembly Components (Size pre-trim)

Vertical Edge Lipping (Hardwood):	19mm (44mm Imp/Met Doors)*
Typical door weight	58kgs (762mm x 1981mm)
Maximum Top edge trim	No top trim allowed.
Maximum Bottom edge trim	5mm
Maximum Long edge trim	3mm

Lock fixing position directly into the core.

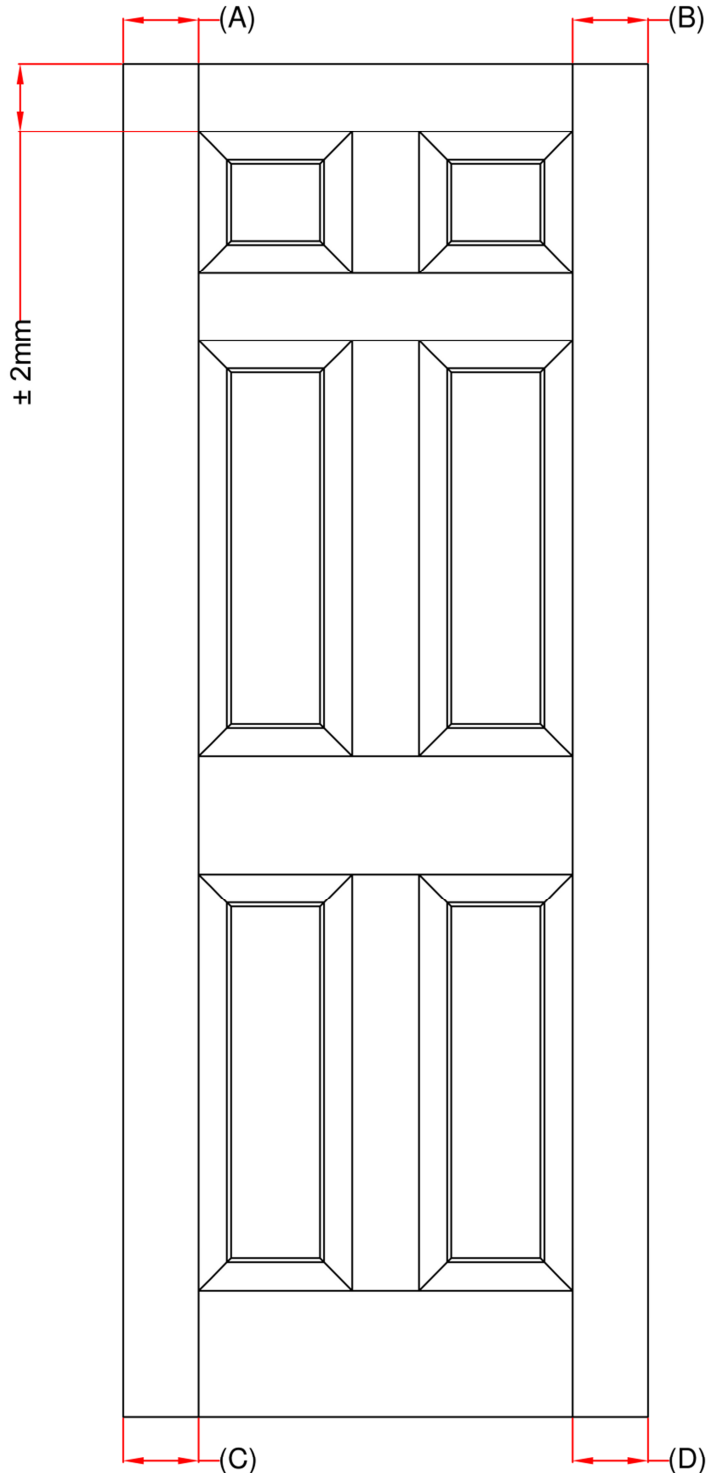
*Size subject to manufacturing trim, after door assembly.

All Fire Certification Documents freely available for download from;

<http://www.premdor.co.uk/downloads/fire-certificates>

DO NOT SCALE ALL DIMENSIONS IN MILLIMETERS IF IN DOUBT - ASK ALL RIGHTS RESERVED	REV	DESCRIPTION	DATE	BY	GENERAL TOLERANCE PLEASE REFER TO PROCESS SPECIFICATION UNLESS OTHERWISE STATED ALL RIGHTS RESERVED
	0	Initial Revision In Vault	26/09/2014	LWhitehead	

Moulded Door Tolerances (EN 1529 & EN 951)



Max difference between (A) and (B) or (C) and (D) = 6mm

Max difference between (B) and (D) or (A) and (C) = 3mm

	Tolerance EN 1529	Measurement Method
Width	$\pm 1.5\text{mm}$	EN 951
Length	$\pm 1.5\text{mm}$	EN 951
Thickness	$\pm 1.0\text{mm}$	EN 951
Squareness	1.5mm	EN 951

Moulded skin designs will vary.

PREMDOR

TITLE: Moulded Door Tolerances (EN 1529 & EN 951)

PROJECT: Moulded Door Range

DATE: 26/09/2014

DRAWN BY: LWhitehead

SCALE: NTS

REVISION: 0

DWG: 201375