

**SUBJECT:****15LE & 17LE Series 1 3/4" Full Flush  
& Seamless Solid Core Doors****NO: D-2.0****DATE: 10/00****PAGE: 1**

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**SCOPE:**

This bulletin covers the details and features of the subject door.

**PURPOSE:**

To inform the reader of the construction features, specifications, and available types and sizes of these door Series.

**DESCRIPTION:**

While the details and specifications enclosed are self-explanatory, the following features should be noted:

- 1) Please note the chart covering in detail the applicable physical properties of Amweld's Super-Core® material, as shown on page D-5.0.
- 2) The 15LE Series door will be furnished with a visible seam on the vertical edges. The 17LE Series door will be furnished as a completely seamless unit.
- 3) Super-Core®, the rigid foam plastic core, is in a slab form and bonded to the panel faces with a heat cured urethane adhesive, pressure rolled to improve flatness.
- 4) The top of the door is flush to meet most architectural specifications. This allows the unit to be installed in exterior openings without the use of special top cap closures. For watertight conditions, caulking by painter is required.
- 5) Reference Page D-1.0 for typical door elevations/styles available.
- 6) Wrap around astragals required for inactive doors.
- 7) "G" lites in doors up to and including 9'0" in height will be the same size as those in 8'0" units. Those in doors from 9'1" up to and including 10'0" in height will be approximately 60" high. Standard glazing hole spacing from the top and both vertical edges will apply. The dimension from the bottom of the hole to the bottom of the door will vary.

**SUMMARY:**

The 1 3/4" doors, in Series 15LE full flush and Series 17LE seamless, provide an expanded Amweld door line coupled with a wide range of hardware preparations, enabling architects and contractors to exercise complete freedom in selecting door types and thicknesses for all construction projects.

**15LE - 17LE SERIES 1 3/4" SPECIFICATIONS**

Contractor shall furnish and install steel doors as manufactured by Amweld Building Products, in all openings except as otherwise provided for in the specifications.

**CONSTRUCTION** - 15LE Series full flush 1 3/4" doors shall have each face formed of 20, 18, 16 or 14 gage\* steel to present a completely smooth and unbroken surface on faces of door. Visible seams permitted at door edges. With 16 gage steel channels forming the top and bottom end closures, the face panels shall be securely continuously laser welded around their entire perimeters.

17LE Series seamless doors shall be similar in construction to full flush doors. Panels shall present a completely smooth and unbroken surface on faces and vertical edges of door. No visible seams permitted.

The panels shall be securely bonded by a thermosetting adhesive to Amweld's Super-Core®, a 1# density, odorless, rigid foam that is resistant to fungus, bacteria, moisture, mildew and rot.

**HARDWARE** - Lockset preparation shall provide for field installation of locksets manufactured in accordance with ANSI/DHI A115.1 (Mortise) or A115.2 (Bored). The lock reinforcing shall be 14 gage. They shall be pierced and tapped for mounting specified locksets. Mounting holes for surface applied escutcheons shall be drilled in the field by others. All doors require locksets with flat faces.

Hinge mortises shall be reinforced with 10 gage steel standard, (7 gage optional), welded in place and tapped for 1 1/2 pairs 4 1/2" x 4 1/2" templated hinges (2 pair at doors over 7'6") (5" regular or heavyweight optional). Hinges furnished by others. Mortises shall extend the full width of hinge stile and filler plates shall be provided to permit installation of hinges for right or left hand swing, as specified. 4 1/2" hinge preparation shall accept both regular and heavyweight.

All 15LE - 17LE Series 1 3/4" doors shall be prepared with closer reinforcing which will accept most regular or parallel arm applications. When called for on drawings, or otherwise specified, doors shall be prepared with 14 gage reinforcing for push-pull plates. Reinforcings must be drilled and tapped in the field by installer.

Inactive leaves, where called for on drawings or in the door schedule, shall be mortised and reinforced with 14 gage steel for top and bottom flush bolts (ANSI/DHI A115.4). Strike edge of all doors shall be prepared for ANSI/DHI A115.1 strike (4 7/8" Universal). Inactive doors shall be provided with an astragal, except inactive leaves prepared for push-pull plates or rim-type panic devices which shall have blank panels and be furnished without astragals.

**GLAZING** - Glass lite doors are furnished with formed (20 Ga. C.R.) steel glazing strips of the screw-in type to permit selection of secure side in the field. Glazing arrangements accommodate 1/4" (6.4mm) thick glass, supplied by others.

**FINISH** - Exposed surfaces on doors shall be cleaned, treated with a three (3) stage iron phosphate and given one shop coat of synthetic resin, rust-inhibitive alkyd enamel primer.

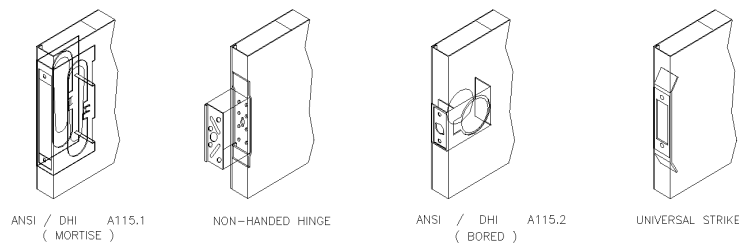
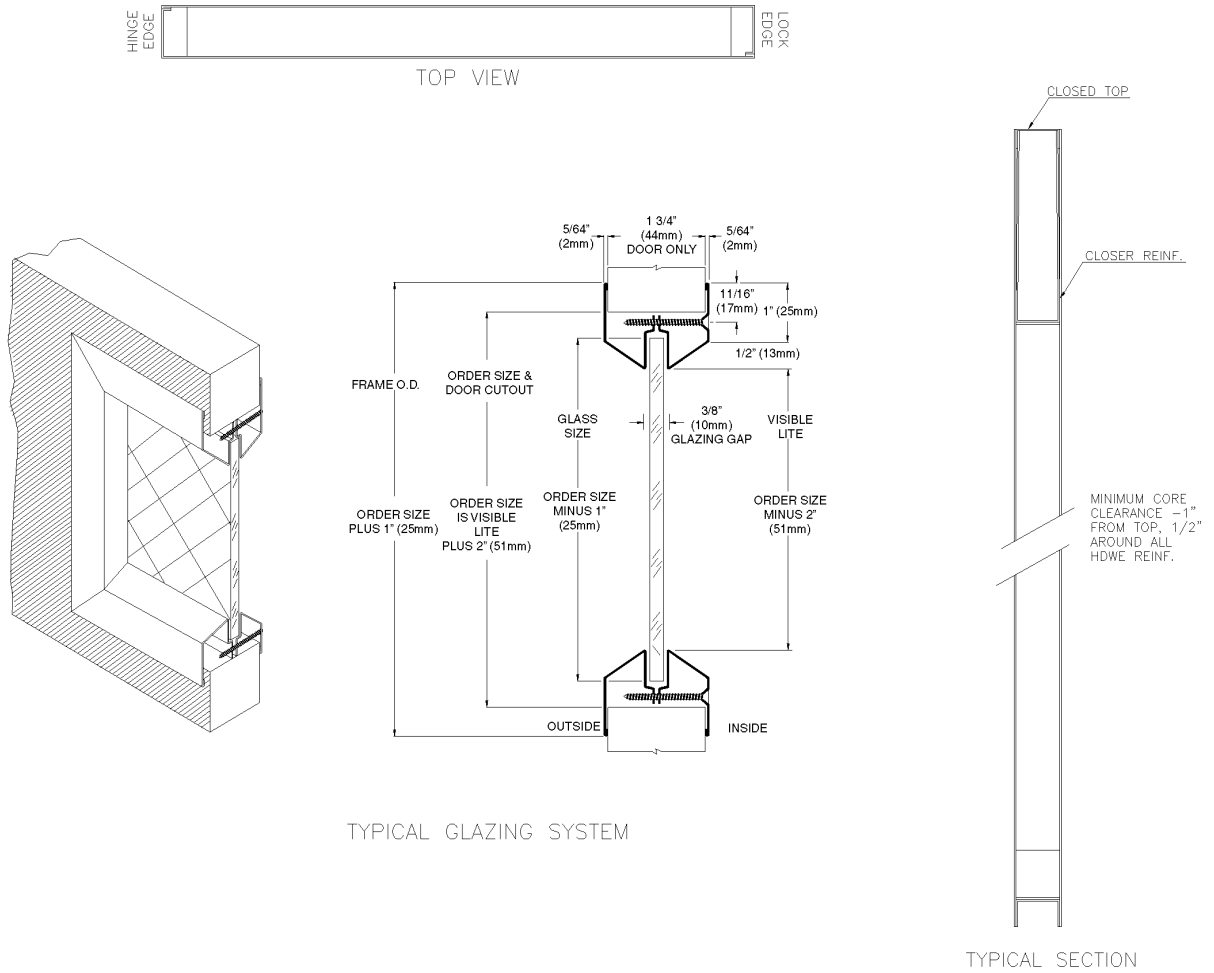
**STANDARD DOOR SIZES** -

Width	2'0", 2'4", 2'6", 2'8", 2'10", 3'0", 3'4", 3'6", 3'8", 3'10" and 4'0"
Height	6'8", 7'0", 7'2", 7'10", 8'0", 8'1" to 10'0"

\*20 gage available up to 3'6" x 7'2"

18 and 16 gage available up to 4'0" x 10'0"

14 gage available up to 4'0" x 8'0"

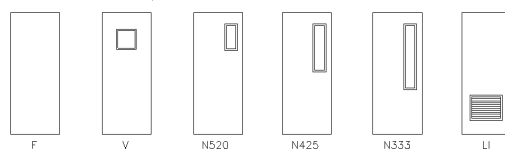


TYPICAL HARDWARE PREPARATIONS

3 HR. LABEL STYLES



1 1/2 HR. LABEL STYLES



3/4 HR. LABEL STYLES

