

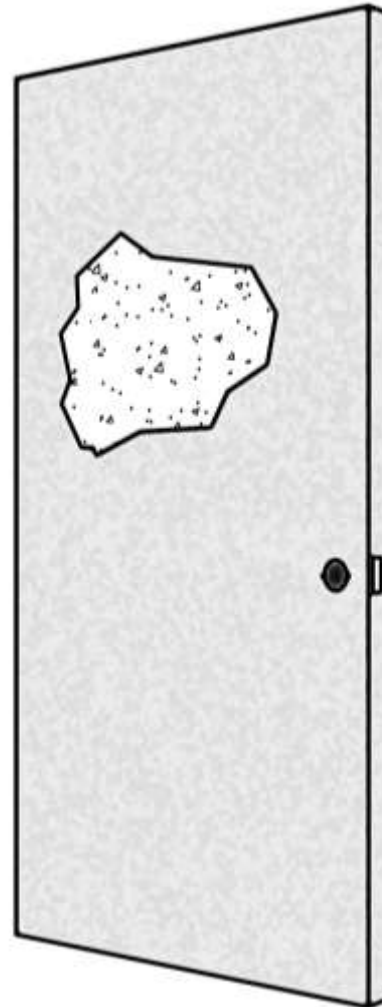
ENGINEERING DETAILS for STANDARD TEMPERATURE RISE DOORS

SERIES HR Full Flush 1³/₄" Doors

SERIES CHR Seamless 1³/₄" Doors

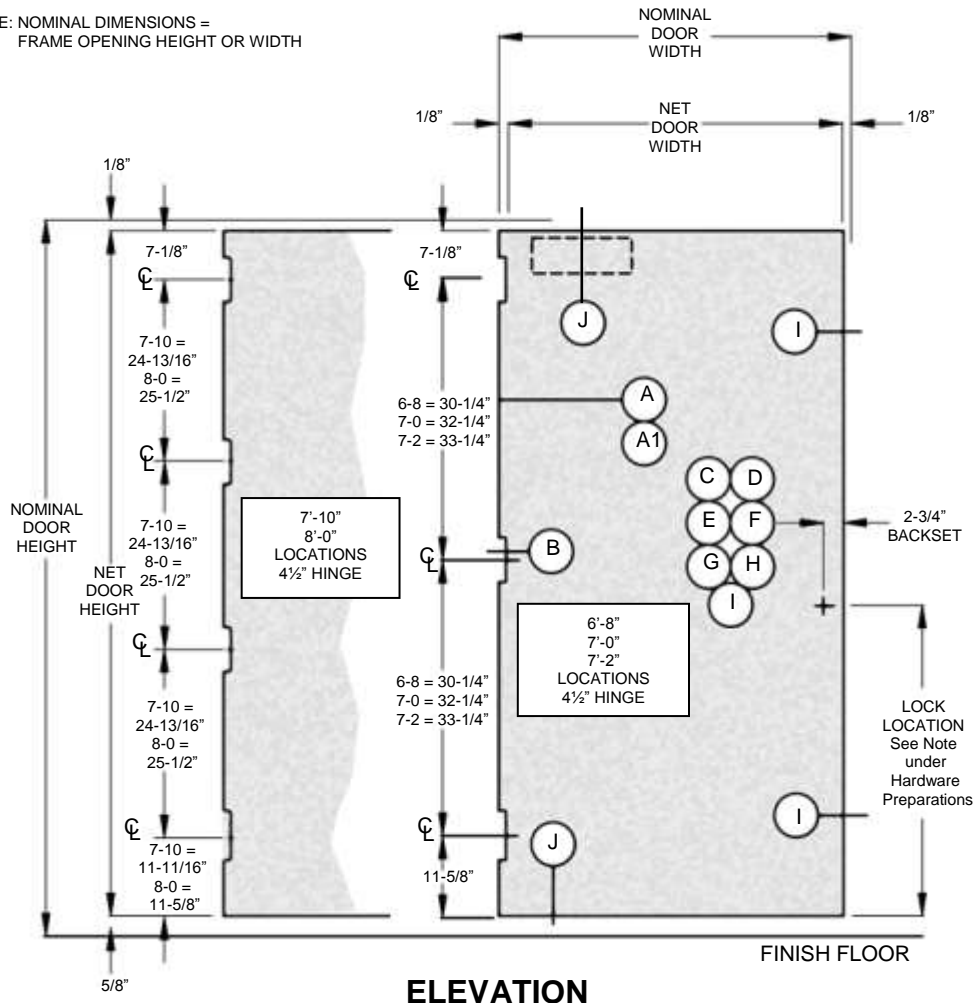
Specifications

1. HR doors shall be formed from two 18 gage A60 Galvannealed Steel per ASTM A924 and A653 and shall be 1-3/4" thick.
2. CHR doors shall be formed from two 16 or 18 gage A60 Galvannealed steel per ASTM A924 and A653 and shall be 1-3/4" thick.
3. Doors shall have a core of rigid mineral core. The core shall have a nominal density of 20.0 #/ft³, with a K factor of 0.65 per ASTM C-518
4. HR doors shall have vertical mechanical interlocking seams on hinge and lock edges. The seam shall be tack welded every 12". There shall be no seam on the faces of door.
5. CHR doors shall have no seams on the faces or edges of doors. Vertical edges of doors shall be continuously seam-welded full height of the door.
6. All hinge reinforcements shall be 3/16" thick.
7. All doors shall be internally reinforced with a 12 gage plate both sides of the door for application of surface applied door closures and holders.
8. Glass light moulding shall be Pioneer standard steel moulding, with no exposed screws on the secure side of door.
9. All doors shall be cleaned and given one coat of baked –on rust- inhibitive metal primer in compliance with ANSI A250.10-2004
10. All fire rated doors, where indicated, shall be manufactured in accordance with UL or WHI procedures and bear the appropriate classification mark (label) with reference to Temperature Rise at 30 minutes of 250 F or 450 F. as required.
11. Door construction complies with ANSI A250.8-2003 (SDI 100)
12. Doors shall be packaged to minimize damage in transit and handling.
13. Hardware reinforcements are in accordance with ANSI A 250.6-2003. Locations are in accordance with ANSI/BHMA A156.115



**Standard SERIES HR Full Flush and
SERIES CHR Seamless 1 3/4" Doors**

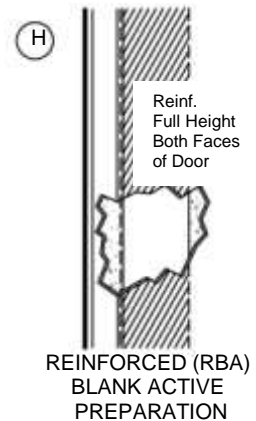
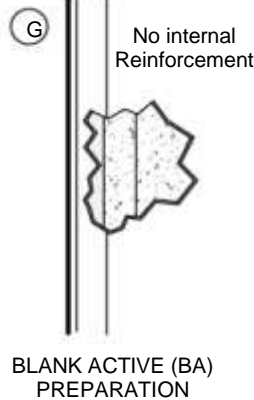
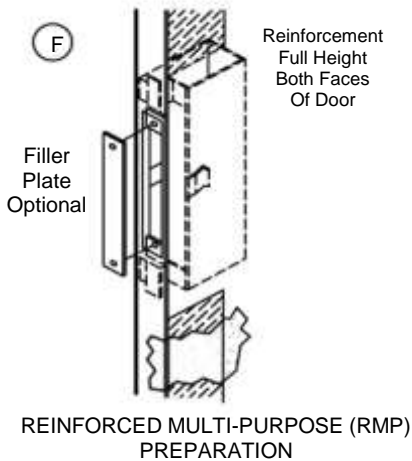
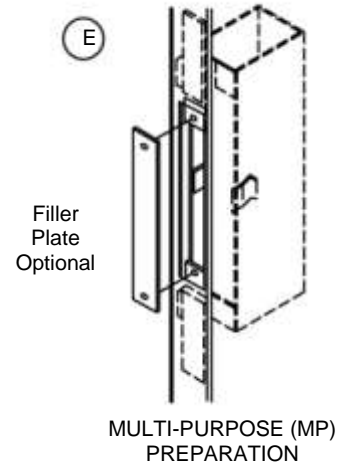
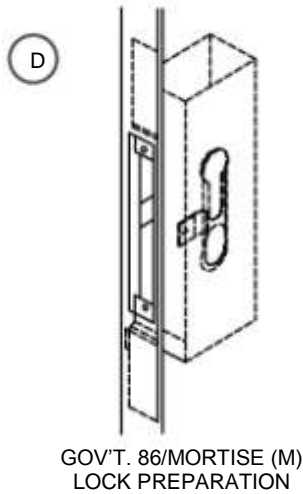
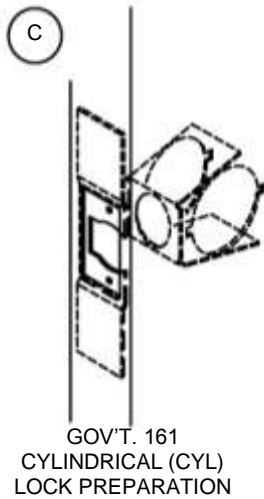
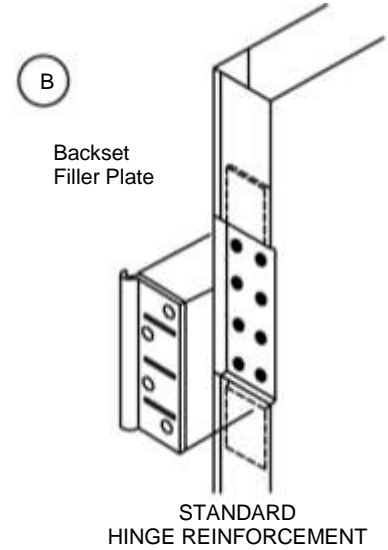
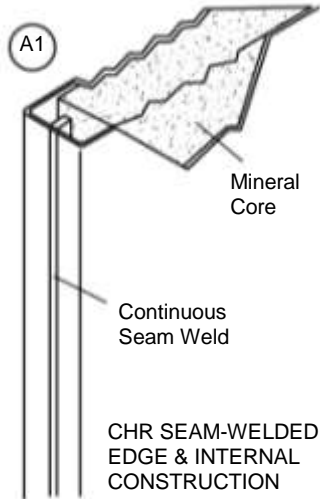
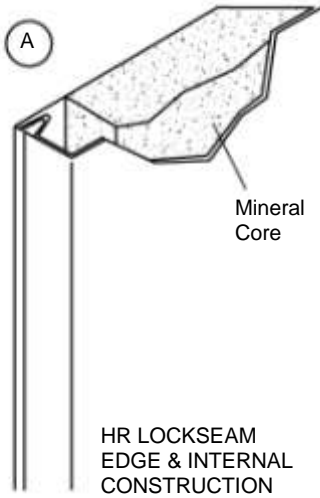
NOTE: NOMINAL DIMENSIONS =
FRAME OPENING HEIGHT OR WIDTH



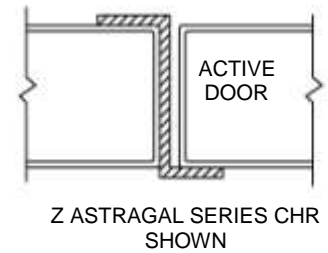
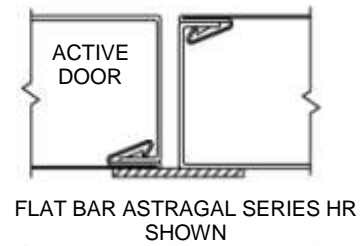
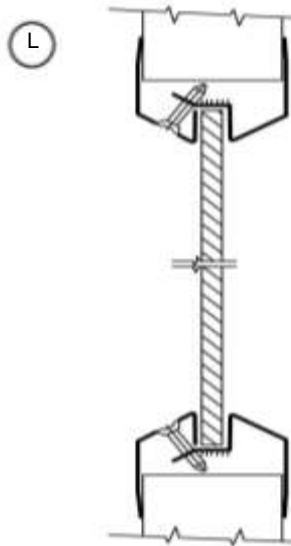
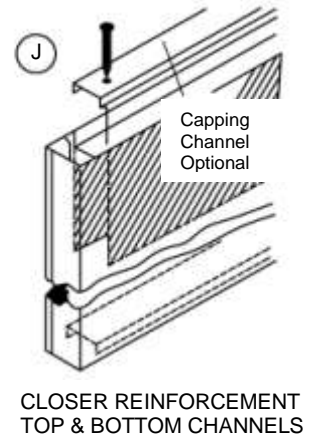
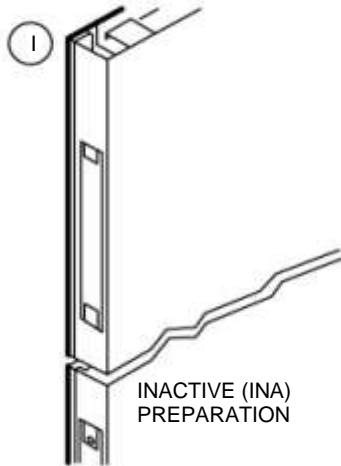
TECHNICAL DATA – DOORS

HR & CHR SERIES

MANUFACTURING DETAILS: FULL FLUSH & SEAMLESS DOORS



TEMPERATURE RISE DOORS: DETAILS CONT'D



STANDARD SIZES		
DOOR OPENING HEIGHT	DOOR OPENING WIDTH	
	SINGLE	PAIR
	2'-0"	
	2'-4"	4'-8"
	2'-6"	5'-0"
6'-8"	2'-8"	5'-4"
7'-0"	2'-10"	5'-8"
7'-2"	3'-0"	6'-0"
7'-10"	3'-4"	6'-8"
8'-0"	3'-6"	7'-0"
	3'-8"	7'-4"
	3'-10"	7'-8"
	4'-0"	8'-0"

TECHNICAL DATA – DOORS

HR & CHR SERIES

STANDARD HARDWARE PREPARATIONS

HINGES: Doors are mortised and reinforced for application of regular weight (0.134) or heavy weight (0.180) 4-1/2" x 4-1/2" full mortised template butt hinges; 1-1/2" pair @ 6' 8", 7' 0" and 7' 2" doors; 2 pair @ 7' 10" and 8' 0" doors. All hinge reinforcements are 3/16" thick. Top hinge on HR and CHR are further reinforced with high frequency back-up reinforcement.

LOCKS:

Active Doors to be prepared as follows:

1. Gov't 161 Cylindrical (CYL) Lock/Latch, with 2-3/4" backset.
2. Universal Gov't 86 Mortise (M) Lock/Latch (to be used with full escutcheon trim), with 2-3/4" backset.
3. Multi-purpose (MP) preparation consisting of a Gov't 86 edge preparation, with lock reinforcement installed. No cutouts on the faces of the door.
4. Reinforced Multi-purpose (RMP) preparation consisting of Gov't 86 edge preparation, with lock reinforcement installed. The lock stile to be reinforced full height of the door on both sides. The hinge stile is reinforced on both faces at panic device height. No cutouts on the faces of the door.
5. Blank Active (BA) preparation provides a totally blank lock stile — no lock preparation and no internal reinforcements. No cutouts on edges or faces of door.
6. Reinforced Blank Active (RBA) preparation provides a totally blank lock stile — no lock preparation. The lock stile to be reinforced full height of the door on both sides. The hinge stile is reinforced on both faces at panic device height. No cutouts on the faces of the door.

Inactive Doors to be prepared as follows:

1. Inactive (INA) preparation consisting of two ANSI A 156.115 flushbolts – 12" top and bottom rod dimension on doors up to and including 7' 2", 12" bottom and 18" top on doors over 7' 2" and up to and including 7' 6" and 12" bottom and 24", 36" or 48" top as required for doors over 7' 6". A 12" top rod dimension is optionally available on 7' 10" and 8' 0" doors. Inactive door is provided with an ASA 4-7/8" strike preparation (no lip cutout – to maintain reversibility of door). Net door width is 1/8" greater than active door.
2. Blank Inactive (BI) preparation provides a totally blank lock stile — no lock preparation and no internal reinforcements. No cutouts on edges of faces of the door. Net door width is 1/8" greater than active door.
3. Reinforced Blank Inactive (RBI) preparation provides a totally blank lock stile — no lock preparation. The lock stile to be reinforced full height of the door on both sides. The hinge stile is reinforced on both faces at panic height. No cutouts on faces of the door. Net door width is 1/8" greater than active door.

LOCK LOCATION: All Locks located to conform to standard 38" C of strike on frame.

CLOSERS AND HOLDERS: All Doors are reinforced internally both sides of the door for application of most types of surface applied closers and holders. A 12 Ga. Reinforcement plate 4-1/2" high measured from top of door and 16" long measured from a point 1-7/8" from the door jamb will accommodate most of the door closers currently manufactured and used on hinge side installations.

NOTES

In order to provide our customers with the finest products, manufactured in the most up to date manner, Pioneer Industries reserves the right to make design or specific construction changes without notice.

Doors are individually cartoned in corrugated cardboard and banded with straps.

Muntin Bars for multiple glass lights are factory installed.

Doors are prime finished. Factory prefinished doors are optionally available.

Doors are not reversible. Pairs of doors are furnished as two individual doors.

Fire Rated Doors: See Fire Rated Section for critical information & details.