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Technical Data

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## FACE SELECTION - Hardwood 5 Ply and Veneer Faces - 7 Ply






The beauty of veneer is in the natural variations of texture, grain, figure, color and the way it is assembled on a door face. Faces will have the natural variations of grain inherent in the species and cut.

### Veneer Cuts

The way in which a log is cut in relation to the annual rings, determines the appearance of veneer.







See WDMA I.S. 1-A

Sections G-6, G-7, G-8, G-9, G-10.

	<p><b>PLAIN SLICED</b> (Flat Cut) Slicing is done parallel to a line through the center of the log. Cathedral and straight patterns result.</p>		<p><b>QUARTER SLICING</b> (Honduras, African &amp; Philippine Mahogany) A narrow striped pattern is produced. These vary in width from species to species. Slicing is done at a 90 degree angle to growth rings.</p>	 <p><b>HALF ROUND SLICING</b> This combination of rotary and plain slicing makes a slice of veneer each revolution.</p>
	<p><b>COMB GRAIN (RIFT CUT)</b> (Red &amp; White Oak) Limited availability. This is a rift-cut veneer distinguished by the tightness and straightness of the grain along the entire length of the veneer. There are occasional cross bars and flake is minimal</p>		<p><b>ROTARY CUT</b> This cut follows the log's annual growth rings, providing a general bold random appearance.</p>	

## Laminates

### MATCHING VENEERS

		
<p><b>Book Match</b> Most commonly used match. Every other piece of veneer is turned over like adjacent pages in a book. The veneer joints match and create a mirror image pattern at the joint line. Book matching is used with rotary, plain sliced, quarter, rift-cut or comb grain veneers.</p>	<p><b>Slip Match</b> Adjoining pieces of veneer are in sequence without turning over every other piece. The grain figure repeats, but joints won't show mirrored effect.. Slip matching is often used in quarter, rift cut and comb grain veneers.</p>	<p><b>Random Match</b> A random selection of individual pieces of veneer from one or more logs. Produces a "board like" appearance. It is most commonly used in opaque grades.</p>
		
<p><b>Running Match</b> Asymmetrical appearance in any single door face. Veneer pieces of unequal width are common. Each face is assembled from as many pieces as necessary.</p>	<p><b>Balance Match</b> Symmetrical appearance. Each face is assembled from even or odd veneer from pieces of uniform width before trimming. <b>This match reduces veneer yield.</b></p>	<p><b>Center Match</b> Symmetrical appearance. Assembled from even number of uniform width veneer before trimming. Veneer joint is in center of panel. <b>This reduces veneer yield.</b></p>

### OTHER FACE OPTIONS

<p><b>High Pressure Decorative Laminates (HPDL)</b> Faces may be selected from a full range of colors available from major manufacturers. Selection include colors, wood grains and special patterns.</p>	<p><b>Medium Density Overlay</b> The phenolic impregnated overlay was developed for premium paint grade surfaces and is superior to paint grades of veneer as it minimizes veneer show through.</p>	<p><b>Tempered Hardboard</b> Faces provide economical paintable doors.</p>	<p><b>Face Veneer Characteristics Grading:</b> Grades; AA, A, B Per; WDMA IS-1A G-11  Note; AA Grade is Subject to availability, cost and lead time.</p>
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## SOLID CORE DOOR 520S

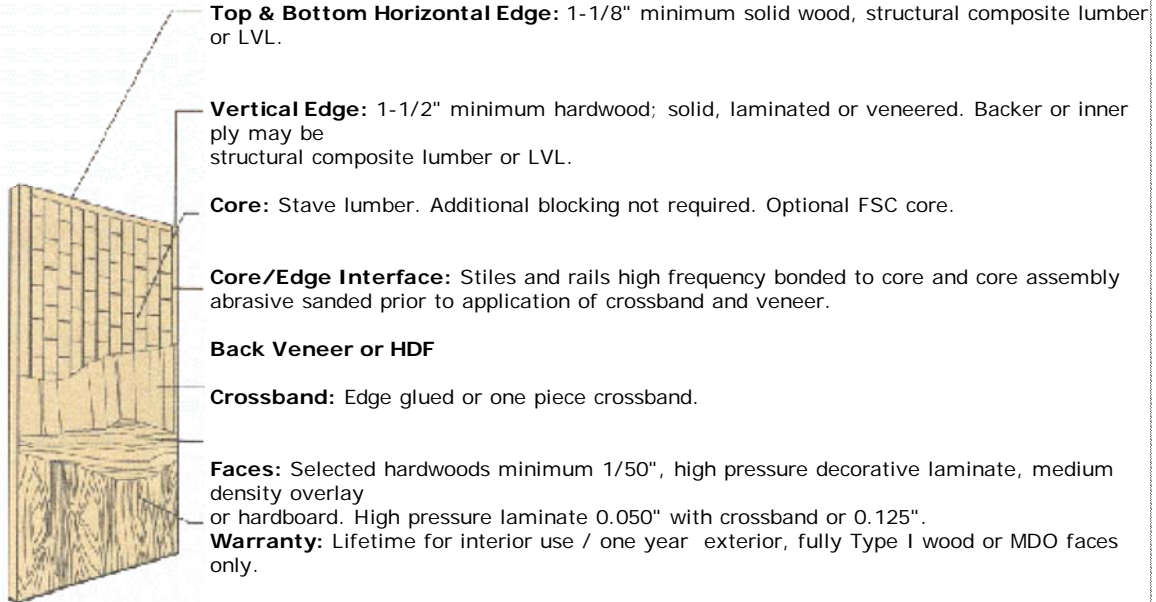
Veneer and High Pressure Decorative Laminate

Stave Core, Bonded and Abrasive Planed

Also Available 20 Minute Rated

WDMA: SLC-7 SLC-5 AWI: SLC-7 SLC-5

WDMA: SLC-HPDL-5 AWI: SLC-HPDL



## SOLID CORE DOOR 520C

Veneer and High Pressure Decorative Laminate

Structural Composite Lumber Core, Bonded and Abrasive Planed Also Available 20

Minute Rated, See Pg. 6

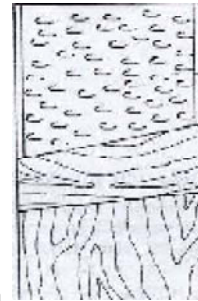
WDMA: SCLC-7 SCLC-5 AWI: SCL

WDMA SCLC-HPDL-5

### General Description:

Construction same as 520S as shown above, however, the core is structural composite lumber.

The composite core is dimensionally stable. Wood's natural characteristics are dispersed during manufacturing, resulting in a stronger, more uniform and predictable product. Top and bottom rails are optional.



Warranty: Lifetime for interior use / one year exterior, fully Type I wood or MDO faces only.

**X-RAY DOORS      5 PLY and 6 PLY**



**LEAD LINED (X-RAY DOORS) 600XR**

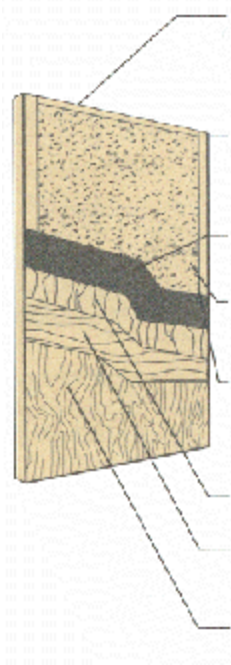
Also Available 20 Minute Rated See Pg. 6

Particleboard Core, Bonded and Abrasive Planed

WDMA: LL

AWI: LL

Acoustical Rated STC 37 - 20 Minute Positive Pressure



**Top & Bottom Rail Horizontal Edge:** 1- 1/4" minimum solid wood or structural composite lumber, one piece or laminated.

**Vertical Edge:** 1-1/2" minimum hardwood, solid, laminated or veneered. Backer or inner ply may be structural or composite lumber or LVL.

**Lead:** Lead shielding is edge to edge under both faces.

**Core:** Particleboard, ANSI A 208, 1 , grade LD-1 or LD-2. Optional stave core or SCLC.

**Core/Edge Interface:** Stiles and rails high frequency bonded to core and core assembly abrasive planed prior to application of lead, crossband and veneer.

**Back Veneer or HDF.**

**Crossband:** Edge glued or one piece crossband.

**Faces:** Selected hardwoods minimum 1/50" high pressure decorative laminate ,medium density overlay or hardboard. High pressure laminate 0.050" with crossband or 0.125".

**Warranty:** Lifetime for interior use.

**RADIATION PROTECTION ENGINEERED**

<u>Lead Thickness</u>	<u>Lbs. per. sq. ft.</u>
1/16"	4
1/8"	8
1/4"	16

Other thickness available

VANCOUVER DOOR CO., Inc., Puyallup, Washington