



FACTORY MACHINING

We at Harring Doors take pride in the accuracy of our machining department. With precise measurements and tooling, we are able to prepare a door to your exacting specifications. For the time it takes one of our skilled technicians to prepare a door in our manufacturing process, an on site carpenter would have great difficulty in matching the cost or the accuracy.

ADVANTAGES OF FACTORY MACHINING

- Quicker installations
- Accurate hardware fitting
- Cleaner, crisper cuts
- If factory finished, proper sealing of cutouts
- Savings over on site preps

TYPICAL HARDWARE PREPS PROVIDED

- Hinges
- Cylindrical locks
- Mortise locks with or without function holes
- Card locks
- Panic devices
- Exit devices
- Concealed vertical rods
- Standard or extension flush bolts
- Concealed overhead closers
- Door bottoms
- Wire raceways
- Pivots
- Peep holes
- Roller latches
- Electric strikes

Or any other hardware requirements you may have.



DIMENSIONAL TOLERANCES

DOORS UNFITTED

Width: + - 1/16 (2mm)
Height: + - 1/16 (2mm)
Thickness: + - 1/16 (2mm)

TYPICAL PREFIT DOOR CLEARANCES

Top & hinge edges: 1/8 (3mm)
Single door lock edge: 1/8 (3mm)
Pair meeting edge: 1/16 (2mm) per leaf
Door bottom: 1/2" (13mm) from top of floor covering (rated or non rated).
 3/4 "19 mm) maximum from top of non-combustible floor.
 3/8 " 10 mm (maximum from top of non-combustible threshold.

DOORS MACHINED FOR HARDWARE

Width: + - 1/32" (1mm)
Height: + - 1/16" (2mm)
Thickness: + - 1/16" (2mm)
Hardware locations: + - 1/32" (1mm)
Locks & hinges: 1/32" (1mm)

WARP

In accordance to industry standards, A.W.I. & the N.W.W.D.A. Warp is any distortion in the door itself, and it does not refer to the door in relation to the frame or the jamb in which it is hung. Warp is measured by placing a straight edge or a taut string on the concave face and determining the maximum distance from the straight edge or string to the door face. The accompanying table and drawing illustrate the Standard and Test.

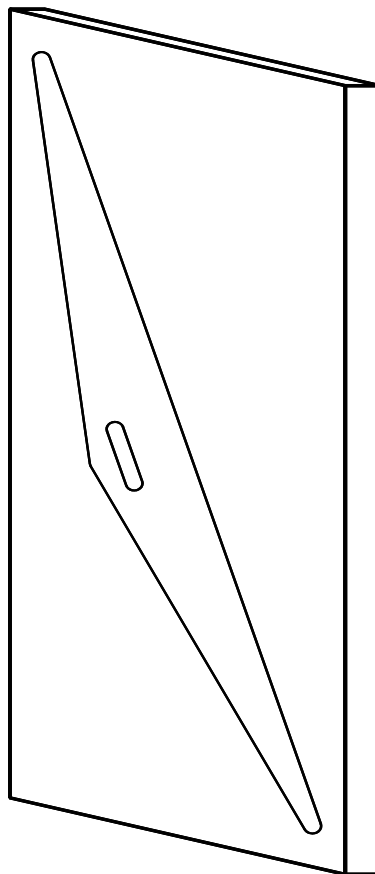
Door Thickness	Door Size	Maximum Deviation Exceeding
1 3/4	3'-6"x7'-0" or smaller	1/4"
1 3/4	larger than 3'-6"x7'-0"	1/4 " in any 3'-6"x 7'-0" section



HOW TO MEASURE WARP

Using a taut string or straight edge, measuring on the concave face of the door, diagonally, horizontally and vertically, ascertain the point of maximum distance between the taut string or straight edge. Here are some other points to look for when measuring:

- Door should be in open position (not latched)
- Do not measure warp in relationship to the frame
- Only when gap exceeds $\frac{1}{4}$ " may door warp be claimed



Often a door may not fit into the frame properly but it is not warped. In these cases, check the frame – it should be set plumb and square and jambs should not be twisted or out of alignment.

Action on any claim for warp may be deferred for up to one year after project completion to permit doors to acclimate to temperature and humidity conditions.

