



<b>Hardware preparation from Cambridge.</b>	<b>J-1</b>
<b>Hardware preparation from the job site or the customer.</b>	<b>J-2</b>
<b>Hand and Bevel of Doors</b>	<b>J-3</b>

### Factory Preparation

Utilizing state of the art production equipment Cambridge Door Inc. has the capability to machine every door we manufacture for the hardware specified. Providing pre-machined doors ensures architects and customers a wide range of flexibility to match their exact specifications and requirements.

In addition to preparation for the functional hardware, Cambridge Door Inc. is also able to do the following work that would normally be done at the jobsite:

- Apply kick plates
- Apply push plates
- Install edge guards
- Install metal louvers
- Install metal vision lite kits
- Apply flashing (prefit doors only)
- Factory glaze

### Order Acknowledgments to Customers

Whether orders arrive on Cambridge Door Inc pre-machining forms, or are to be factory co-ordinated. An order confirmation will be sent to the customer for his/her approval. The customer is responsible for approving the correctness of:

1. The proper number of doors on each item and the total order.
2. Proper door construction by item.
3. Proper door sizes by item.
4. Proper door swings.
5. Correct lite and louver locations within the door's area.
6. Correct hinge and lock locations.

Once Cambridge Door Inc. has received the approved order confirmation; Cambridge Door Inc. will be responsible for the proper location of the machining as taken from the appropriate door, frame, and hardware schedule as well as shop drawings.

### Edge Performance

All Cambridge Door Inc. doors have been tested for superior screw holding power and split resistance. They have passed over 1,500,000 cycle slams.

**Door Closers and Exit Devices** Surface-mounted closers and exit devices are suitable for Fire Doors in singles and pairs. Surface-mounted door closers and exit devices must be installed with through bolts, unless doors are ordered with heavy-duty reinforcement at the top rail. Self-tapping or combination wood/metal screws **should not** be used.

<u>Heavy Duty Reinforcement Performance</u>	<u>Through Bolt Pull Through</u>	<u>Lbs. of Pull</u>
Testing results, when pulling through bolt heads through the door and withdrawing screws from various door core materials, show a marked advantage with Cambridge Door Inc. optional heavy-duty reinforcement rail/block material.	Bolt head pulled through Mineral Core	428
	Bolt head pulled through reinforced blocking.	<b>1472</b>
	<u>Screw Withdrawal</u>	<u>Lbs. of Pull</u>
	Withdrawal from Hardwood	920
	Withdrawal from reinforced blocking	<b>866</b>
	Withdrawal from Softwood Stave Core	593
	Withdrawal from Particle Core	262
	Withdrawal from Mineral Core	126

### **Jobsite Preparation**

All responsibility will shift away from Cambridge Door Inc. when machining preparation is completed at the jobsite. (See Warranty, "Handling, Finishing and Installation Instructions).

The National Fire Protection Association (NFPA) Pamphlet #80 requires that all fire doors be prepared for locks, latches, hinges, concealed closers, glass lights, vision panels, louvers, astragals and laminated overlays by the door manufacturer or his licensee in conformance with the manufacturer's inspection service procedure and under label service. Exceptions to this ruling include; preparation for surface applied hardware; function holes up to 1" diameter and cylinder holes up to 1 1/4" for mortise locks; holes for labeled viewers; a maximum 3/4" undercut on wood and composite doors; and application of some protection plates. This means that the machining of these features can be done on the jobsite. A UL or ITS licensed machinist must conduct all other types of machining.

Cambridge Door Inc. has a number of licensed machinists that are able to machine under Underwriters Laboratories (UL) or Warnock Hersey/Intertek Testing Service (ITS). In order to achieve this certification a company must request in writing from Cambridge Door Inc. to be able to machine and certify Cambridge Door Fire Rated Doors at their location.

The “hand of a door is always determined from the outside. The outside of an exterior door is the street or entrance (key) sides. The outside of an interior room or auditorium door is the corridor or hall (key or imaginary key) side. The outside of a closet door is the side opposite the closet; the room, corridor, or hall side. The outside of a single communicating door is the side from which the butts are invisible when they are closed. The outside of twin communicating doors is the space between two doors. Standard-handed doors push away from the person on the outside/key side. Reverse-handed doors pull toward the person standing on the outside/key side. (AWI/AWMAC 1300)

