

Care and Finishing Procedure for Wood Doors

Handling

1. Do not walk on any door units. Some units contain glass.
2. Avoid dragging doors across one another and keep doors clean. Handle with clean gloves.
3. Store flat on a level surface in a dry, well ventilated building. Avoid exposure to direct sunlight.
4. Doors should be conditioned to average prevailing relative humidity of the locality before hanging.
5. Doors should not be subjected to extreme or rapid changes in heat or humidity. Avoid sudden changes such as forced heat to dry out a building.
6. If the doors are to be stored on the job site, all surfaces including ends and edges must be sealed with an effective quality oil-base sealer within 72 hours to prevent undue moisture absorption.
7. Use three hinges on doors 7'0" in height or less, and four hinges on doors over 7'0" in height.

Preparation for Finishing

1. Before applying the first coat of finish, sand the entire surface lightly with (180 grit) sandpaper. This removes fingerprints and handling marks, as well as opening the wood grain to enhance the stain penetration. For doors with square shaker sticking, lightly ease the outside edge of the sticking with sandpaper. To avoid cross-grain scratches, always sand with the direction of the grain.
1. SPECIAL NOTE: Douglas Fir doors should also be wiped down with Acetone prior to sanding. As Douglas Fir has a heavy sap content, this extra step will clean the surface of any sap stain.
2. Adjust or align components if necessary before finishing. Wood panels "float" and may be knocked into alignment with a wood block and hammer. Be careful not to damage door.
3. After sanding, clean door thoroughly with a cloth to remove all dust or foreign material. Do not use caustic or abrasive cleaners.
4. Hang door before finishing, and then remove to finish properly.
5. All surfaces of the door must be properly finished. The edges (top, bottom and sides) should be coated with each and every coat of finish that is applied to the exterior surface of the door. Doors must be dry before finishing.

6. On exterior doors that are glazed with clear glass, the finish used should be flowed from the wood slightly onto the glass. This will provide assurance against water leakage and protect the glazing compound "putty" from drying out. In areas exposed to occasional rain, a secondary "CAP BEAD" caulking must be applied between glass and molding. **See Figure 1**

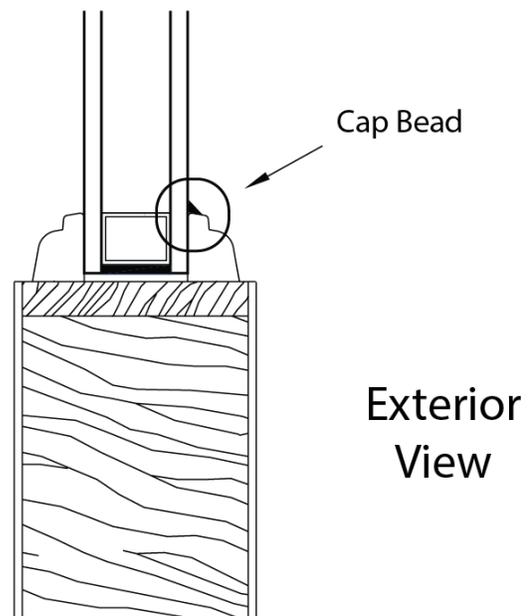


Figure 1: Caulk between Exterior Glass and Molding

*Note: It is the finisher's responsibility to protect glass prior to and during finishing.

7. On doors that have plastic film protection on glass, removal of plastic film protection immediately after applying the finish is required. Failure to remove the plastic film at this time may cause harm to the glass and will create difficulty in removing the film at a later time. Do not use razor blades or sharp objects to remove the film or clean the glass. These items will scratch the glass.

DOOR WARRANTY AND POLICIES

Exterior Finishing

NOTE: Avoid "DARK COLOR FINISHES" in areas exposed to direct sunlight. Dark colors will contribute to warp and or checking.

Avoid exposure to direct sunlight. The UV rays will cause a "SUNBURN EFFECT" that will permanently discolor the door (or portion of door exposed) and will in some cases be impossible to remove without sanding through the veneer.

1. Stain-and-Clear Finish

The first coat should be stain-and-sealer, a combination of stain and sealer, which colors the door and seals the surface. It is available in a wide range of colors. The stain-and-sealer should have an alkyd-resin base. Under no circumstances should a lacquer-based toner or any other lacquer-base finish be used on exterior doors.

The second and third coats (two top coats minimum) may be a solvent-borne (oil-base, alkyd-resin base, polyurethane resin-base) or a water-borne (latex resin-base) clear finish. Coatings must be adequate to bridge the stile & rail joints to seal the door. Here are the Pros and Cons of solvent-borne vs. Water-borne clear finishes:

*Solvent-Borne

Advantages: Faster drying, harder and more water resistant. May be applied under variable weather conditions.

Disadvantages: Subject to ultraviolet degradation and not as flexible or durable as water-borne clear finish.

*Water-Borne

Advantages: very flexible, greater ultraviolet resistance, and good exterior durability.

Disadvantages: Cannot be applied below 10°C (50°F), long drying period required, and may not cure fully for several weeks. Water sensitive until cure is complete.

Note: Do not sand between coats of clear latex. All stain-and-clear finishes will perform measurably better if protected from direct effects of sunlight and weathering, and refinishing will not be required as frequently.

2. Paint Finish

Either oil-base or latex resin-base exterior grade paints may be used with success on panel doors. Oil-base paints offer more resistance to the passage of

water (liquid and vapor) than latex resin-base paints, but the latter have better durability and color retention.

Doors should be sealed with good quality oil-base primer followed by two top coats of either an oil-base or latex resin-base paint. Of course, both primer and top coat should be made by the same manufacturer and be designed to be used in combination.

Note: where possible exposure to direct sun or rain is a factor, doors should be sealed with premium quality oil-based primer followed by two top coats of a premium quality oil-base paint.

3. Caution

Trimlite cannot evaluate all the available paints and stains, or the customers' specific application requirements, your paint dealer should know of suitable finish systems that give satisfactory results in your region. It is highly recommend that top quality finishes be selected, and the application instructions on the container be followed explicitly.

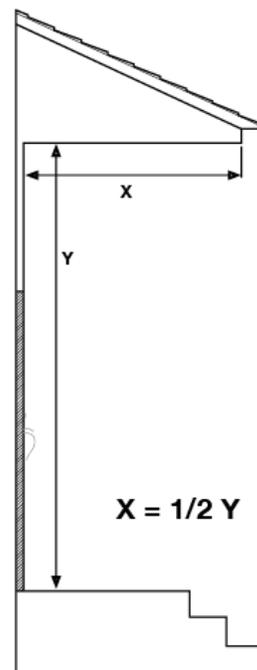


Figure 2: Overhang Guide

Figure 2: Where X is the length of the overhang required and Y is the distance from the bottom of the door to the base of the overhang.

DOOR WARRANTY AND POLICIES

Interior Finishing

1. Stain- and-Clear Finish
A solvent-borne finish system is recommended for interior doors and may be a lacquer-based system. If a brush application is to be used, it is recommended that a pre-sealer be used prior to staining. For best performance, a minimum of two clear top coats should be used over stains.
2. Doors should be sealed with a good quality oil-base primer followed by two top coats of a solvent-base or latex enamel.

Fitting and Hanging

1. When hanging door, allow adequate clearance for swelling of door or frame in damp weather. Allow approximately 3/16" clearance for swelling when the door is installed in fully dry conditions. Jambs must be plumb.
2. Do not cut doors down in height by more than 2" (1-1/2" maximum from bottom, 1/2" maximum from top). Care should be taken in cutting doors down in width to avoid exposing engineered components. Use a sharp fine-tooth saw for trimming ends of doors.
3. Caution must be used to avoid impairing the strength of the door when fitting for locks. Allow at least 1" of wood back of mortise.
4. Use three hinges on doors up to 7' in height and four hinges on doors over 7'. Hinges must be set in a straight line to prevent distortion.
5. Prior to exterior exposure, doors must be finished with complete finish system.

Maintenance

Your door has been handcrafted to last for years to come. But, like any fine piece of furniture, its finish will require some simple, periodic maintenance to keep it looking and great and provide protection against the elements. Regular finish maintenance is also a requirement of the warranty that's included with every Trimlite Door.

Here are some signs to watch for. They indicate that it's time for some simple, easy-to-perform maintenance:

- Hairline cracks in the top coat of the finish
- Changes in the color of the finish
- Changes in the texture of the finish, such as flaking or scaling
- Dullness or chalkiness in the finish

If you live in a severe climate or your entry receives a lot of direct sunlight from a southern or western exposure, you'll want to examine your door's finish often. Depending on the conditions, you may also need to maintain the door finish more frequently.

Stile and rail wood doors have multiple areas for moisture to gain access, therefore it's very important to pay particular attention to adequate overhang and use only premium high quality coatings and finishing techniques. In the event of little or no overhang please ask your Trimlite Customer Service Representative for other door options.

Warranty

Trimlite guarantees all doors for a period of one year from date of shipment from our plant against defects which renders them unserviceable for the use for which they are intended by the manufacturer provided the following conditions are met:

1. Manufacturing defects must be reported promptly before fitting, finishing, or hanging.
2. Provided that doors are operative, action on any claims after installation may be deferred at the option of Trimlite for a period of six months from date of complaint. During this time period, doors must remain hung in the original installation to permit conditioning to humidity and temperature.
3. Trimlite agrees, at our option, to repair or replace any doors that are defective within the meaning of this guarantee. Claims for rehanging, refinishing, or other expenses for work not originally performed by the manufacturer will not be allowed.
4. Due to extreme weather conditions, exposures, and architectural designs, Trimlite will not guarantee any double door units, or outswing units for air or water infiltration where there is not sufficient overhang to protect the door.
5. The entire door, including edges, top, bottom, and sides must receive at least two coats of an

oil base paint, varnish, or sealer at the time of installation. (See section: Finishing Instructions)

Allowable Tolerances

1. Thickness, width, and height tolerances from nominal sizes shall not exceed 1/16" plus or minus.
2. A squareness tolerance of not more than 1/8" between two diagonal measurements taken across the face of the door shall be allowed.
3. For doors 3' x 7' or smaller, deformation (bow, cup, twist, warp) shall not be considered a defect unless it exceeds 1/4" in the plane of the door itself
(door larger than 7' warp not to exceed 3/8")
When measure as specified in Clause 3.1.2.2 C.S.A. Standard -132.2- 1972.

Exclusion

The following are not defects in workmanship of material and are not covered by this written warranty:

1. Damage caused by attempts other than Trimlite's to repair the door and/or unit.
2. Failure to properly seal the door.
3. Defects caused by improper installation such that the door does not swing freely.
4. Damage cause by improper handling or on-site storage.



Warranty

5. This warranty shall be void and Trimlite shall have no liability hereunder if the purchaser installs, treats, or retains, for more than thirty days, a door and/or unit containing an obvious defect, without giving the notice is required herein, or if the purchaser fails to give the required notice within reasonable time after discovery of defect.

Door Policy

1. RECEIVING: Upon receiving, order must be checked for accuracy or damaged. If damage is apparent, it must be noted on the delivery receipt.
2. SPECIAL ORDERS: Care must be taken to insure order accuracy. Order sheets with swing diagrams are available. Special order cancellation will not be accepted once work has begun on the unit.
3. RETURN GOODS AUTHORIZATIONS (RGA)
Contact your Trimlite representative to request inspection and return authorization. All doors approved for return must be shipped back to Trimlite in the same condition in which it was shipped. No credit will be given for doors return in non-saleable condition.

Claim Policy

1. A representative of your firm must inspect the unit.
2. Provide purchase order number, invoice number, and original ship date.
3. Identify product and problem.
4. Provide contact names and phone numbers.
5. With the above information, Trimlite will make arrangements to go to the job site with a representative of your firm.
6. After determination of the problem has been established, Trimlite will repair or replace the unit as per the guarantee.

